

NUMBER OF CIRCUITS	PLUG NUMBER	CAP NUMBER
6	[]-480270-[]	[]-480271-[]
8	[]-480283-[]	[]-480284-[]
10	[]-480285-[]	[]-480286-[]
12	[]-480287-[]	[]-480288-[]
16	[]-480438-[]	[]-480439-[]

Figure 1

1. INTRODUCTION

This instruction sheet covers the MATE-N-LOK Connectors shown in Figure 1. Each connector consists of a cap, plug, and pin and socket contacts. The cap may be mounted and will accept pin contacts. The plug accepts socket contacts. Read these instructions carefully before assembling the connector.

Reasons for reissue of this sheet are provided in Section 7, REVISION SUMMARY.

SOCKET CONTACT		PIN CONTACT		TOOL (408-7159)
STRIP	LOOSE PIECE	STRIP	LOOSE PIECE	
61314-[]	60617-[]	[]-61116-[]	60618-[]	90123
61117-[]	60619-[]	[]-61118-[]	60620-[]	90124
350078-[]	61173-[]	350079-[]	61174-[]	90066
350557-[]	--	350558-[]	--	90124

Figure 2

2. CONTACT CRIMPING

2.1. Strip-Form

Crimp strip-form contacts using the proper applicator according to the instruction sheet shipped with the applicator.

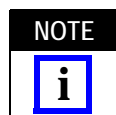
2.2. Loose-Piece (LP)

Crimp loose-piece contacts using the hand tools and instruction sheets listed in Figure 2.



Damaged contacts may not be used. They must be replaced with a new one.

3. CONTACT INSERTION



Use pin contacts only in the cap connector, and socket contacts only in the plug connector.

3.1. Single-Wire Leads

For single-wire leads, push socket or pin into housing until you feel the latch click. See Figure 1. Pull back lightly on wire to make sure contact is latched in place.

3.2. Two-Wire Leads

For two-wire leads, first align contact with cavity as shown in Figure 3. Push contact into housing until you feel the latch click. Pull back lightly on wire to make sure contact is latched in place.

NOTE *Two-wire leads may be used only in socket contacts.*

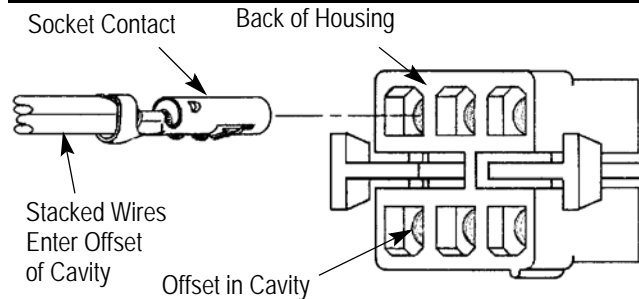


Figure 3

3.3. Insertion

When inserting contacts crimped to small, flexible wire, use Insertion Tool 91002-[]. Refer to Instruction Sheet 408-7347. Insertion tool 455830-1 (408-7984) can be used on larger wire.

4. HOUSING ENGAGEMENT

4.1. Mating

Align index ribs on plug and cap (see Figure 1) and push together until locking legs on plug engage the cap housing. See Figure 4.

4.2. Unmating

To disengage the housings, squeeze the locking legs together and pull plug out of cap. See Figure 4.

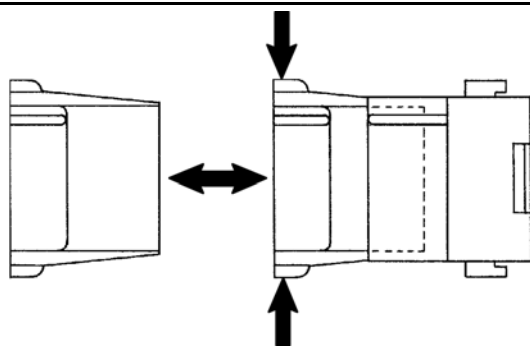


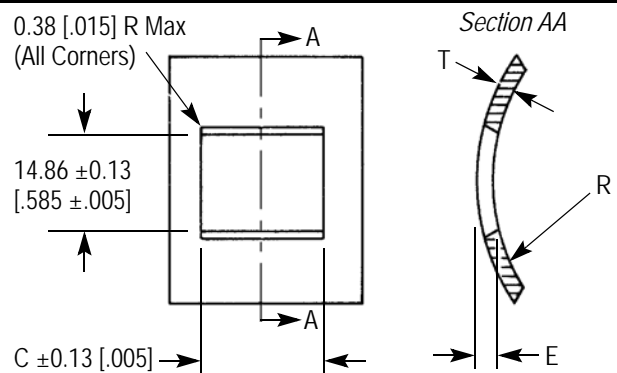
Figure 4

5. PANEL MOUNTING

1. To mount cap to panel or motor, first stamp cutout using the dimensions provided in Figure 5. Be sure punch and housing enter panel from the same side. See Figure 6.

2. Install the cap in panel as shown in Figure 6 using a rocking motion. Slide one locking ear under panel,

then rock the housing to the other side and slide the other locking ear under panel.



HOUSING	CAVITIES	DIMENSION
[]-480271-[]	6	18.16 [0.715]
[]-480284-[]	8	23.11 [0.910]
[]-480286-[]	10	28.07 [1.105]
[]-480288.[]	12	33.02 [1.300]
[]-480439-[]	16	42.93 [1.690]

NOTE: Effective panel thickness "E" is 1.07 - 2.54 [0.40 - .100] and is dependent on "T" and "R". Panel may be flat.

Figure 5

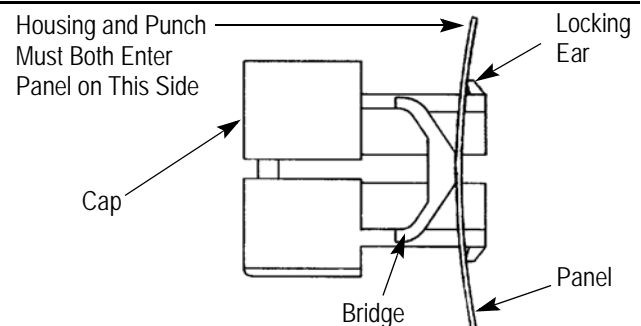


Figure 6

6. CONTACT EXTRACTION

Two types of extraction tools are available. Use tool 465644-1 (Instruction Sheet 408-7211) to extract both pin and socket contacts when you can clearly see the contacts as you look into the front of the housing and can easily reach the rear of the housing. If either view or access is restricted, use tools 1-305183-1 (for pin contacts), or 1-305183-2 (for socket contacts). See instruction sheet 408-7158.

7. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Changed wording in Paragraphs 3.1 and 3.2.
- Added tooling info to Paragraph 3.3
- Updated document to corporate requirements.