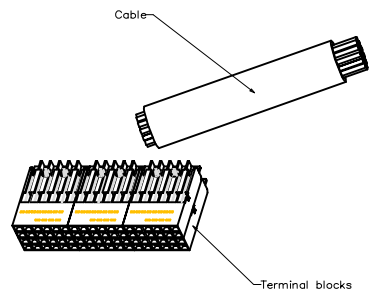


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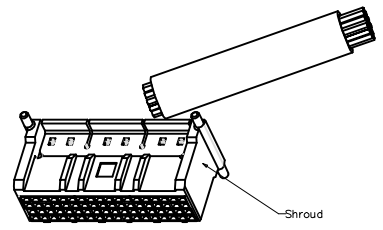
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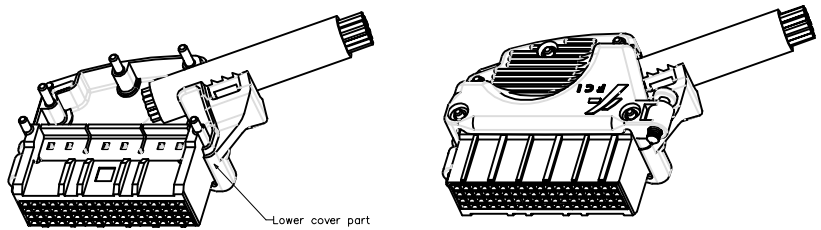
**STEP 1**  
Strip the cable(s) and insert the individual wires into their corresponding IDC – contacts.



**STEP 2**  
Insert the terminal blocks in the shroud. The flexible walls between the pegs of the shroud will bend outwards due to the dots on the terminal blocks. Make sure that all dots fit into the positioning windows before continuing. Attention : The shroud can be assembled as indicated in the figure below or upside down – polarisation ribs facing upwards, see 2nd picture of step 3 – to reverse the direction of the cable outlet; check which configuration is needed.

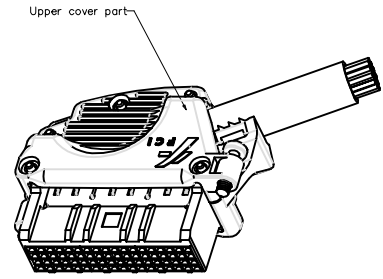


**STEP 3**  
Put the assembly into the lower cover part. The pegs of the shroud should fit into the ovalized holes of the cover. Make sure no wires will be squeezed when closing the covers.

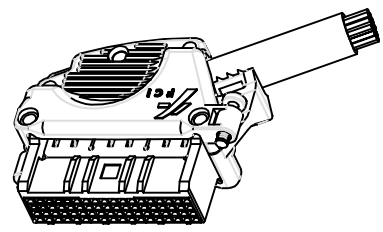


Configuration with reversed cable outlet; polarisation ribs of shroud facing upwards. ( see instructions step 2 )

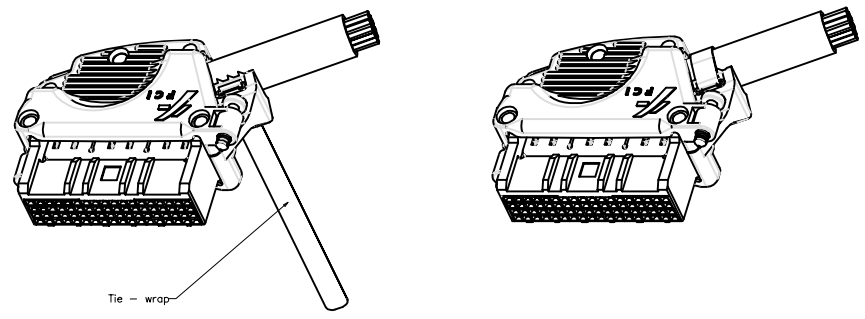
**STEP 4**  
Fit the upper cover part on top of the assembly and close the connector. The covers are designed to stick together once they have been assembled. The transition between both covers will not be seamless; a "gap" of approximately 0.3 mm is intended.



**STEP 5**  
Deform the pegs – create rivets – using the approved tool to do this.



**STEP 6**  
Insert the tie-wrap in the cavity as shown below. The buckle should click into its place, making it easy to wrap it around the cable(s) and feed it through the buckle again.



**STEP 7**  
Wrap the strap around the cable(s), feed it through the buckle and tighten it using the appropriate tool. The cable should be pressed against the ribs of the feature holding the tie-wrap to provide the necessary strain relief.

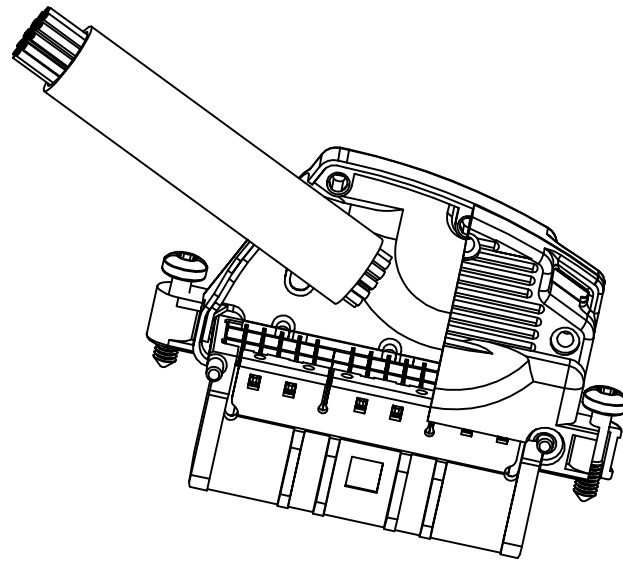
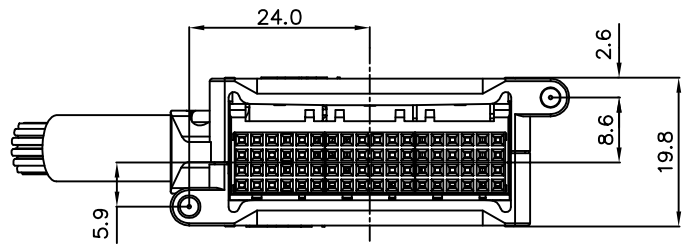
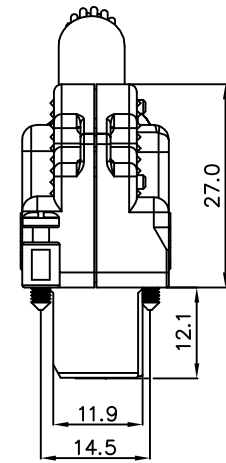
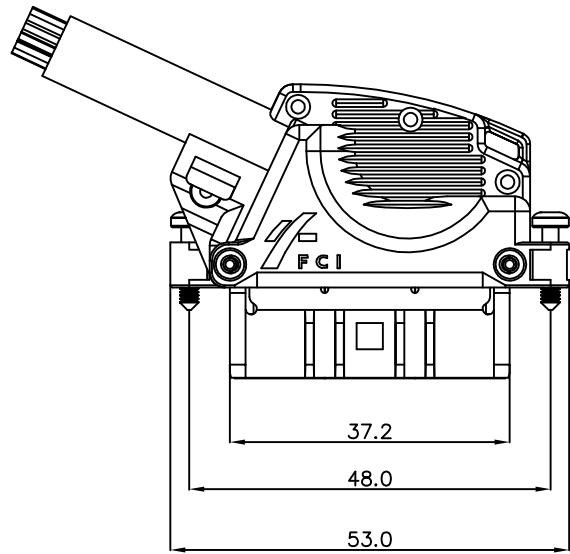
HM1C13D2C110EB consists of	Qty.
HM1C16D20L10EB Terminal block left	3
HM1C16D20R10EB Terminal block right	3
HM1C13P49CAP1B Upper cover half with pre-assembled screw	1
HM1C13P50CAP1B Lower cover half with pre-assembled screw	1
HM1SH2B 72 pos. shroud	1
HPTET637C Metal tie wrap	1

Parts – terminal blocks, covers and shroud – should be ordered separately and will be delivered in bulk packing.

mat'l code				tolerance unless otherwise specified		CUSTOMER COPY	 www.fciconnect.com
rev.	ecn no.	dr	date	.X ±0.3	.XX ±0.10	projection	
A	DG03-0088	AZ	11/20/03	linear			72 POS. Metral Cable Conn.
B	DG05-0035	CLu	3/01/05	angles	.X ±0.1*		unit
				dr	ANTONIO ZHU 11/20/03	mm/inch	size
				enr	ANTONIO ZHU 11/20/03	scale	dwg no.
				chr	ANTONIO ZHU 11/20/03	A3	BSE202920001
				appd	JOSEPH HSIA 11/20/03		sheet 1 OF 2
sheet	revision	B	B				
index	sheet	1	2				

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B					.XX ±0.10	
				angles	.X ±0.1°	
				dr	ANTONIO ZHU 11/20/03	unit
				enr	ANTONIO ZHU 11/20/03	mm/inch
				chr	ANTONIO ZHU 11/20/03	scale
				appd	JOSEPH HSIA 11/20/03	
sheet		revision		product family		code
index		sheet		CABLE CONNECTOR		
				size		dwg no.
				A3		BSE202920001
				sheet		2 of 2