

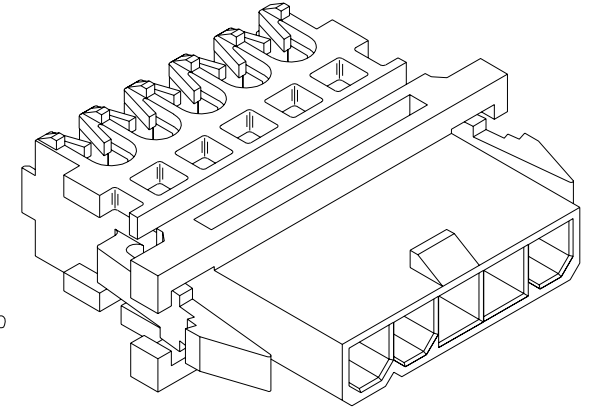
HOUSING MATERIAL: 94V-0 UNFILLED POLYESTER  
COLOR: WHITE

TERMINAL MATERIAL: PHOSPHOR BRONZE

SEE NOTE 10

SECTION A-A

SECTION B-B



**NOTES:**

1. ASSEMBLY NO. 71690-23\*\* SHOWN FOR ILLUSTRATION.
2. MATES WITH PART NUMBER 71694-\*\*\*\*.
3. SEE SHEET 2 FOR PART NUMBERS AND THEIR CONFIGURATIONS.
4. FINISHES (SEE CHART):  
 TIN OVERALL - .000100/(0.00254) MINIMUM TIN OVERALL, OVER NICKEL UNDERPLATING OVERALL.  
 15 GOLD - .000015/(0.00038) MINIMUM SELECT GOLD AND .000150/(0.00380) MINIMUM SELECT TIN OVER NICKEL UNDERPLATING OVERALL.
5. ITEM NUMBERS PRECEDED BY AN "X" IN THE CHART ARE NOT AVAILABLE.
6. RECOMMENDED FOR USE WITH UL # 1007 STYLE WIRE.
7. OPTIONAL COVER NUMBERS: 71161-\*\*\*01 (FEED THRU) OR ---02 (FEED TO VERSION).
8. SEE SHEET 7 FOR PANEL CUTOUT DETAIL.
9. PART CONFORMS TO SPECIFICATION NO. PS-71690-001.
10. RECYCLE LOGO: >PBT< FR TO BE LOCATED IN THIS AREA.
11. IDT SLOT IDENTIFIER COLOR STRIPE TO BE LOCATED ON THIS SURFACE. ID PER CHART BELOW.

| WIRE GAUGE | ID COLOR        |
|------------|-----------------|
| 18         | FLRSCNT MAGENTA |
| 20         | BLUE            |
| 22         | GREEN           |
| 24         | BLACK           |

12. SEE SMES-71690-0000 FOR TERMINATION SPECIFICATIONS.
13. PACKAGE PER PK-71690-0000.

NOTE FOR LEAD FREE CONVERSION:

THE PRIMARY SHIPPING CARTON WILL BE LABELED "COMPLIANT TO ROHS DIRECTIVE 2002/95/EC AND ELV ANNEX II OF DIRECTIVE 2000/53/EC". CARTONS WITHOUT THIS LABEL MAY CONTAIN PRODUCT WITH LEAD.

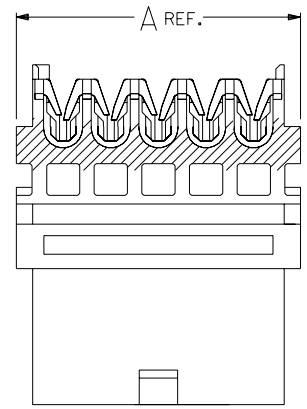
|   |  |
|---|--|
| L | LEAD FREE CONV<br>ECN UCP2004-2042<br>ADAMS 04/04/20   |
| K | CHANGE PROD SPEC<br>ECR UDT2001-0195<br>KMS 9/22/2000  |
| J | ALL WHITE MAT'L<br>PER EC # U71026<br>ELO 97/2/26      |
| I | 18 AWG CLR CHANGE<br>PER ECR U70413<br>ELO 10/23/96    |
| H | REVISED<br>PER ECR U61437<br>PAR 05/15/96              |
| G | REVISED<br>PER ECR U61185<br>TSE 03/27/96              |
| F | ADD GOLD ASSY'S<br>PER ECR U51189<br>08/30/95 sds      |
| E | REV CHARTS/D DIM<br>PER ECR U60094<br>07/26/95 sds     |
| 8 | J D ADD HOLE/NOTE 12<br>PER ECR U50939<br>04/17/95 sds |
| 7 | L C ADD DIM/REV NOTE<br>8/10/94 sds                    |
| 6 | L C ADD NOTE II<br>PER ECR U40717<br>6/29/94 sds       |
| 4 | L B FINAL RELEASE<br>PER ECR U40514<br>4/25/94 sds     |
| 2 | L A  |
| 1 | L A  |

MFG, SH, REV, LTR, REVISIONS

| DIMENSIONS SHOWN (METRIC) INCH                        |               | TITLE   |         |
|---|---------------|---|---------|
| UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2° |               | MINI-FIT IDT<br>SINGLE ROW<br>PLUG SALES ASSEMBLY   |         |
| 3 PLACE ± .010  | ---           | MOLEX INCORPORATED SHEET NO. DATE<br>U.S.A. 1 OF 8   01/28/93   |         |
| 2 PLACE ± .014 ± 0.25                                 | ---           | PART NO. DRWG. NO.<br>SEE CHART SDA-71690-****  |         |
| 1 PLACE --- ± 0.36                                    | ---           | FILE NAME 571690X1<br>DEN MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION                                |         |
| DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS  |               | THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION |         |
| DRWG. BY: RWB   | CHK'D BY: SAS | SCALE: 4: 1   | DIV: TC |

| J | CKT SIZE | S T A T | ASSEMBLY ITEM NUMBER | PANEL MOUNTS | WIRE AWG | WIRE DESCRIPTION              | DIMENSION A |         | DIMENSION B |         | DIMENSION C |        | PLATING SEE NOTE 4 |
|---|----------|---------|----------------------|--------------|----------|-------------------------------|-------------|---------|-------------|---------|-------------|--------|--------------------|
|   |          |         |                      |              |          |                               | INCH        | (MM)    | INCH        | (MM)    | INCH        | (MM)   |                    |
|   | 2        |         | 71690-1001           | NO           | 18       | SOLID,FUSED STRANDED,STRANDED | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) | TIN OVERALL        |
|   | 2        |         | 71690-1003           | NO           | 20       |                               | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 2        |         | 71690-1004           | NO           | 22       |                               | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) | TIN OVERALL        |
|   | 2        |         | 71690-1005           | NO           | 24       |                               | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 2        |         | 71690-1007           | NO           | 18       |                               | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) | I5 GOLD            |
|   | 2        |         | 71690-1009           | NO           | 20       |                               | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 2        |         | 71690-1010           | NO           | 22       |                               | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) | I5 GOLD            |
|   | 2        |         | 71690-1011           | NO           | 24       |                               | 0.490       | (12.45) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 2        |         | 71690-1101           | YES          | 18       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) | TIN OVERALL        |
|   | 2        |         | 71690-1103           | YES          | 20       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 2        |         | 71690-1104           | YES          | 22       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) | I5 GOLD            |
|   | 2        |         | 71690-1105           | YES          | 24       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 2        |         | 71690-1107           | YES          | 18       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) | I5 GOLD            |
|   | 2        |         | 71690-1109           | YES          | 20       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 2        |         | 71690-1110           | YES          | 22       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) | TIN OVERALL        |
|   | 2        |         | 71690-1111           | YES          | 24       |                               | 0.821       | (20.48) | 0.378       | (9.60)  | 0.1654      | (4.20) |                    |
|   | 3        |         | 71690-1401           | NO           | 18       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) | TIN OVERALL        |
|   | 3        |         | 71690-1403           | NO           | 20       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |
|   | 3        |         | 71690-1404           | NO           | 22       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) | I5 GOLD            |
|   | 3        |         | 71690-1405           | NO           | 24       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |
|   | 3        |         | 71690-1407           | NO           | 18       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) | TIN OVERALL        |
|   | 3        |         | 71690-1409           | NO           | 20       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |
|   | 3        |         | 71690-1410           | NO           | 22       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) | I5 GOLD            |
|   | 3        |         | 71690-1411           | NO           | 24       |                               | 0.655       | (16.65) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |
|   | 3        |         | 71690-1501           | YES          | 18       |                               | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) | TIN OVERALL        |
|   | 3        |         | 71690-1503           | YES          | 20       |                               | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |
|   | 3        |         | 71690-1504           | YES          | 22       |                               | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) | I5 GOLD            |
|   | 3        |         | 71690-1505           | YES          | 24       |                               | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |
|   | 3        |         | 71690-1507           | YES          | 18       |                               | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) | TIN OVERALL        |
|   | 3        |         | 71690-1509           | YES          | 20       |                               | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |
|   | 3        |         | 71690-1510           | YES          | 22       |                               | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) | I5 GOLD            |
|   | 3        |         | 71690-1511           | YES          | 24       | SOLID,FUSED STRANDED,STRANDED | 0.986       | (25.05) | 0.543       | (13.80) | 0.3307      | (8.40) |                    |

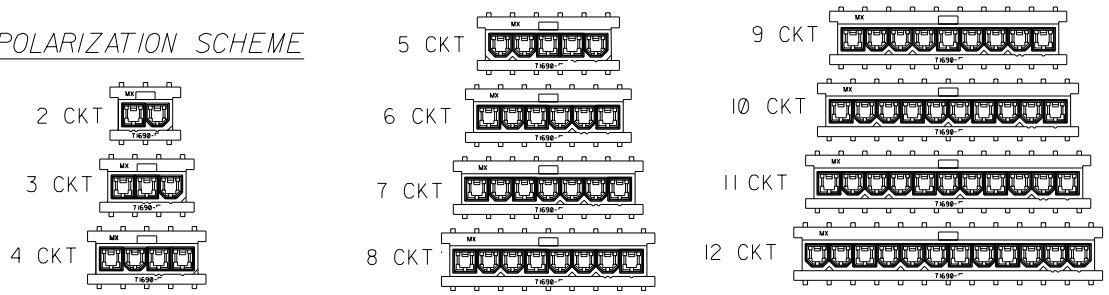
WITHOUT PANEL MOUNTS



|   |             |
|---|-------------|
| L | SEE SHEET I |
| H | SEE SHEET I |
| F | SEE SHEET I |
| D | SEE SHEET I |
| C | SEE SHEET I |
| A | SEE SHEET I |
| 4 | SEE SHEET I |
| 3 | SEE SHEET I |
| 2 | SEE SHEET I |
| I | SEE SHEET I |

71690

POLARIZATION SCHEME



|  |                |  |                |
|--|----------------|--|----------------|
| DIMENSIONS SHOWN (METRIC) INCH                       |                | UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°  |                |
| 5 PLACE ± .010                                       | INCH           | ---  | METRIC         |
| 2 PLACE ± .014 ± 0.25                                | INCH           | ---  | METRIC         |
| 1 PLACE --- ± 0.36                                   | INCH           | ---  | METRIC         |
| DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS |                |  |                |
| DRWG. BY: RWB  | CHK'D. BY: SAS | FILE NAME: S71690X2  | SCALE: 1:1     |
| APP'D. BY:   | SCALE:         | THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION. | DATE: 01/28/93 |

MFG. SH. REV. LTR. REVISIONS

REVISE ONLY ON CAD SYSTEM

TITLE: MINI-FIT IDT SINGLE ROW PLUG ASSEMBLY

MOLEX INCORPORATED SHEET NO. 2 DATE 01/28/93

SDA-71690-\*\*\*\*

| CKT SIZE | S T A T | ASSEMBLY ITEM NUMBER | PANEL MOUNTS | WIRE AWG | WIRE DESCRIPTION                | DIMENSION A |         | DIMENSION B |         | DIMENSION C |         | PLATING SEE NOTE 4 |
|----------|---------|----------------------|--------------|----------|---------------------------------|-------------|---------|-------------|---------|-------------|---------|--------------------|
|          |         |                      |              |          |                                 | INCH        | (MM)    | INCH        | (MM)    | INCH        | (MM)    |                    |
| 10       |         | 71690-4201           | NO           | 18       | SOLID, FUSED STRANDED, STRANDED | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) | TIN OVERALL        |
| 10       |         | 71690-4203           | NO           | 20       |                                 | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4204           | NO           | 22       |                                 | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4205           | NO           | 24       |                                 | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4207           | NO           | 18       |                                 | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) | 15 GOLD            |
| 10       |         | 71690-4209           | NO           | 20       |                                 | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4210           | NO           | 22       |                                 | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4211           | NO           | 24       |                                 | 1.813       | (46.05) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4301           | YES          | 18       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) | TIN OVERALL        |
| 10       |         | 71690-4303           | YES          | 20       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4304           | YES          | 22       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4305           | YES          | 24       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4307           | YES          | 18       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) | 15 GOLD            |
| 10       |         | 71690-4309           | YES          | 20       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4310           | YES          | 22       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 10       |         | 71690-4311           | YES          | 24       |                                 | 2.144       | (54.45) | 1.701       | (43.20) | 1.4886      | (37.80) |                    |
| 11       |         | 71690-4601           | NO           | 18       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) | TIN OVERALL        |
| 11       |         | 71690-4603           | NO           | 20       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4604           | NO           | 22       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4605           | NO           | 24       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4607           | NO           | 18       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) | 15 GOLD            |
| 11       |         | 71690-4609           | NO           | 20       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4610           | NO           | 22       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4611           | NO           | 24       |                                 | 1.978       | (50.25) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4701           | YES          | 18       |                                 | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) | TIN OVERALL        |
| 11       |         | 71690-4703           | YES          | 20       |                                 | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4704           | YES          | 22       |                                 | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4705           | YES          | 24       |                                 | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4707           | YES          | 18       |                                 | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) | 15 GOLD            |
| 11       |         | 71690-4709           | YES          | 20       |                                 | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4710           | YES          | 22       |                                 | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |
| 11       |         | 71690-4711           | YES          | 24       | SOLID, FUSED STRANDED, STRANDED | 2.309       | (58.65) | 1.866       | (48.74) | 1.6540      | (42.00) |                    |

|   |             |
|---|-------------|
| L | SEE SHEET I |
| H | SEE SHEET I |
| F | SEE SHEET I |
| E | SEE SHEET I |
| A | SEE SHEET I |
| 4 | SEE SHEET I |
| 2 | SEE SHEET I |
| 1 | SEE SHEET I |

|          |      |      |           |
|----------|------|------|-----------|
| MFG. SH. | REV. | LTR. | REVISIONS |
|----------|------|------|-----------|

DIMENSIONS SHOWN (METRIC) INCH  
UNLESS OTHERWISE SPECIFIED  
TOLERANCES: ANGULAR ± 1/2°

|                |        |
|----------------|--------|
| 5 PLACE ± .010 | ---    |
| 2 PLACE ± .014 | ± 0.25 |
| 1 PLACE ---    | ± 0.36 |

DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS

DRWG. BY: RWB    CHK'D. BY: SAS    SCALE:    :

APPR. BY:    :

THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.

TITLE: MINI-FIT IDT SINGLE ROW PLUG ASSEMBLY

MOLEX INCORPORATED U.S.A.    SHEET NO. 6    DATE 03/10/93

PART NO. SDA-71690-\*\*\*\*    DRWG. NO. SEE CHART

71690

B

A



**MOLEX INCORPORATED**  
LISLE, ILL. 60532 U.S.A.

## WIRE TERMINATION SPECIFICATION

### 1.0 APPLICABLE DRAWINGS:

THIS SPECIFICATION APPLIES TO A-71690 AND A-71694 SERIES OF INSULATION DISPLACEMENT CONNECTORS.

### 2.0 SCOPE:

THIS SPECIFICATION IS DESIGNED TO INSURE THE PROPER TERMINATION AND PERFORMANCE OF THE A-71690 AND A-71694 SERIES OF INSULATION DISPLACEMENT CONNECTORS.

### 3.0 GENERAL:

THE .1654/(4.20) CENTER INSULATION DISPLACEMENT CONNECTOR SYSTEM IS DESIGNED TO INTERCONNECT DISCRETE WIRE AS OUTLINED IN THIS SPECIFICATION.

### 4.0 CONDUCTOR REQUIREMENTS:

#### 4.1 CONDUCTOR SIZE IDENTIFICATION:

| CONDUCTOR SIZE | CONDUCTOR STYLE                    | HOUSING ID COLOR (SEE FIG. 4) | TERMINAL ID HOLE POSITION (SEE FIG.8; SHT.5) |
|----------------|------------------------------------|-------------------------------|--|
| 18 AWG         | STRANDED WITH TOPCOAT,FUSED, SOLID | RED                           | POSITION 1                                   |
| 20 AWG         | STRANDED WITH TOPCOAT,FUSED, SOLID | BLUE                          | POSITION 2                                   |
| 22 AWG         | STRANDED WITH TOPCOAT,FUSED, SOLID | GREEN                         | POSITION 3                                   |
| 24 AWG         | STRANDED WITH TOPCOAT,FUSED, SOLID | BLACK                         | POSITION 4                                   |

RECOMMENDED UL STYLE: 1007, 1061

#### 4.2 INSULATION REQUIREMENTS:

INSULATION DIAMETER: .090 MAX

INSULATION HARDNESS: 85 MAX ON THE SHORE A SCALE

### 5.0 TERMINATION REQUIREMENTS:

#### 5.1 CABLE INSERTION DEPTH:

THE CABLE SHOULD BE INSERTED TO DEPTH OF .140/(3.56)\* FROM THE TOP OF THE HOUSING TO THE TOP OF THE WIRE (SEE FIGURE 2). WIRE MUST BE LOCATED BELOW THE BOTTOM OF EAGLES.

\* TERMINATION DEPTH FOR THE 24 AWG WIRES IN THE FOLLOWING ASSEMBLIES TO BE .138±.005/(3.51±0.13); 71690-6008 AND 71694-2402.

STRAIN RELIEF

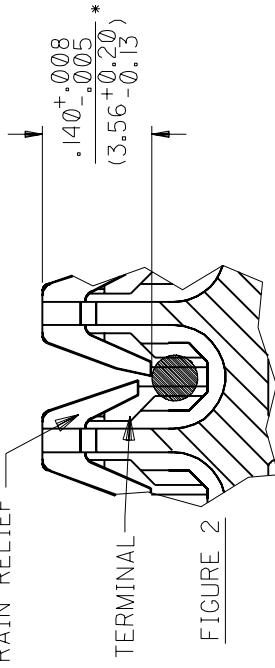
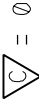


FIGURE 2

| REV. | B | A | B | B | B |
|------|---|---|---|---|---|
| SHT. | 1 | 2 | 3 | 4 | 5 |

FILE NAME

T71690X1



C

= 0

REVISE ONLY ON CAD SYSTEM

REV.

B

THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.

SHT.

1 OF 5

DRWG. NO. SMES-71690-0000

DRWG. NO. SMES-71690-0000



## WIRE TERMINATION SPECIFICATION

### 5.2 WIRE CUT OFF

IN THE FEED-TO VERSION THE WIRE MUST BE DISPLACED IN BOTH INSULATION DISPLACEMENT SLOTS AND MUST PROTRUDE THROUGH THE SECONDARY SLOT BY  $(1.52)/.060$  MIN. AS SHOWN IN FIGURE 3.

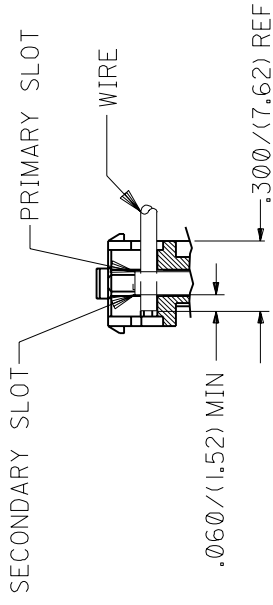


FIGURE 3

### 5.3 HORIZONTAL PULL OUT FORCE

THE CONNECTOR MUST MAINTAIN THE FOLLOWING MIN. PULL OUT VALUES WHEN A FORCE IS APPLIED AT A RATE OF 1 INCH PER MINUTE TO THE CABLE IN A DIRECTION PERPENDICULAR TO THE INSULATION DISPLACEMENT SECTION. AS SHOWN IN FIGURE 4. (NOTE CABLE MUST BE SLIT TO FORM INDIVIDUAL CONDUCTORS AFTER TERMINATION BUT PRIOR TO TESTING).

| AWG    | PULL FORCE     |
|--------|----------------|
| 18 AWG | 14.0 LBS. MIN. |
| 20 AWG | TBD            |
| 22 AWG | TBD            |
| 24 AWG | 8.0 LBS. MIN.  |

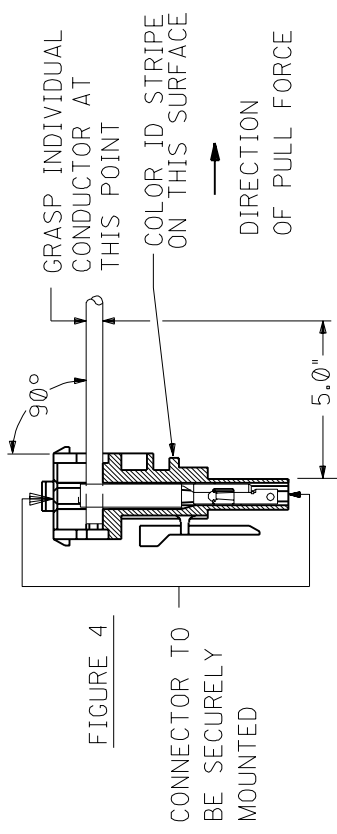


FIGURE 4

### 5.4 VERTICAL PULL OUT FORCE

THE CONNECTOR MUST MAINTAIN THE FOLLOWING MIN. PULL OUT VALUES WHEN A FORCE IS APPLIED AT A RATE OF 1 INCH PER MINUTE TO THE CABLE IN A DIRECTION PARALLEL TO THE INSULATION DISPLACEMENT SECTION. AS SHOWN IN FIGURE 5. (NOTE CABLE MUST BE SLIT TO FORM INDIVIDUAL CONDUCTORS AFTER TERMINATION BUT PRIOR TO TESTING).

| AWG    | PULL FORCE    |
|--------|---------------|
| 18 AWG | 5.0 LBS. MIN. |
| 20 AWG | TBD           |
| 22 AWG | TBD           |
| 24 AWG | 2.4 LBS. MIN. |

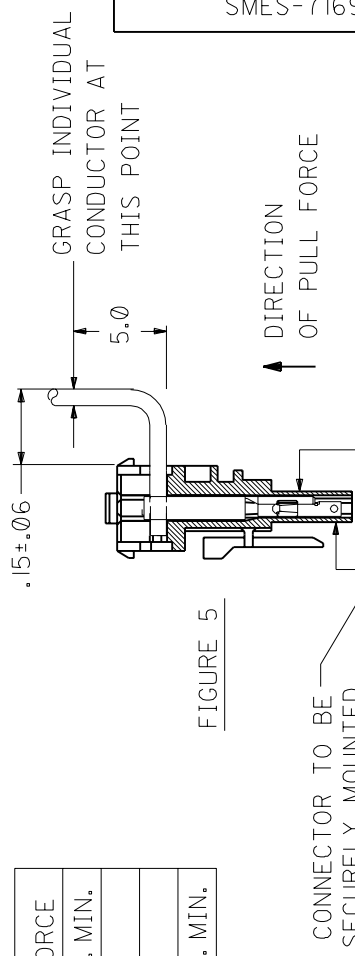


FIGURE 5

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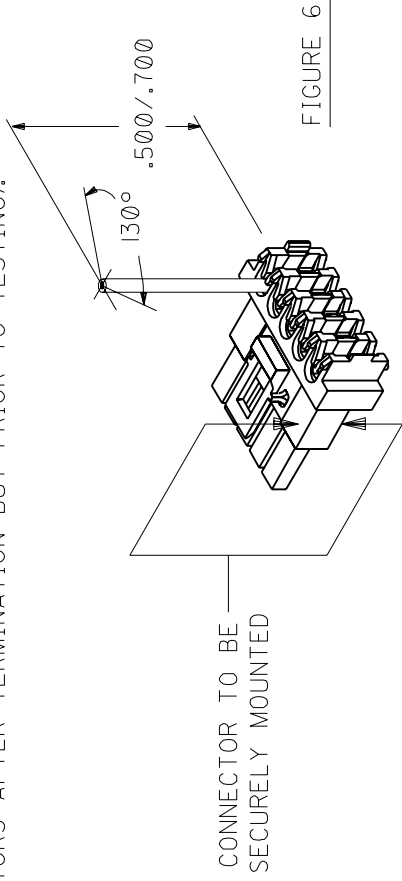


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## WIRE TERMINATION SPECIFICATION

### 5.5 TORSIONAL RESISTANCE:

CONNECTOR MUST WITHSTAND A MAXIMUM TWIST ON A TERMINATED CABLE OF 130° WITHOUT DISTURBING THE INSULATION DISPLACEMENT INTERFACE IN THE PRIMARY OR SECONDARY SLOTS (SEE FIGURE 3) (NOTE CABLE MUST BE SLIT TO FORM INDIVIDUAL CONDUCTORS AFTER TERMINATION BUT PRIOR TO TESTING).

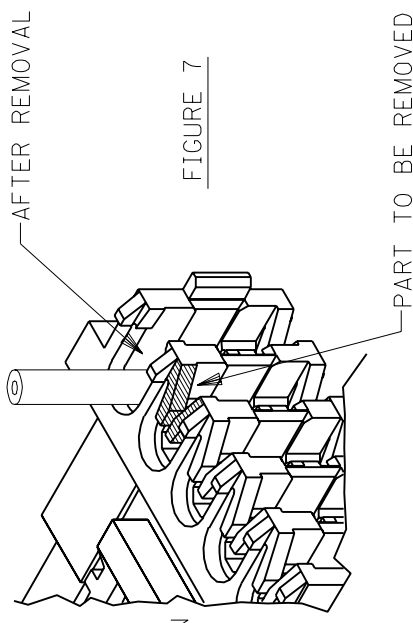


### 5.6 VISUAL INSPECTION:

AFTER TERMINATION, INSULATION DISPLACEMENT SECTION OF THE TERMINAL TO BE FREE OF TOOL MARKS FROM TERMINATION EQUIPMENT.

### 6.0 TERMINATION EVALUATION PROCEDURE:

STEP 1 - STRAIN RELIEF REMOVAL  
REMOVE SHADED PORTION OF THE STRAIN RELIEF USING A RAZOR BLADE



### STEP 2 - REMOVAL OF TERMINAL

INSERT THE REMOVAL TOOL (#HT60630A) INTO THE FRONT OF OF THE CONNECTOR (AROUND THE TERMINAL) TO DEPRESS LOCK TANGS. PUSH THE TERMINAL/WIRE OUT THE BACK OF THE CONNECTOR.

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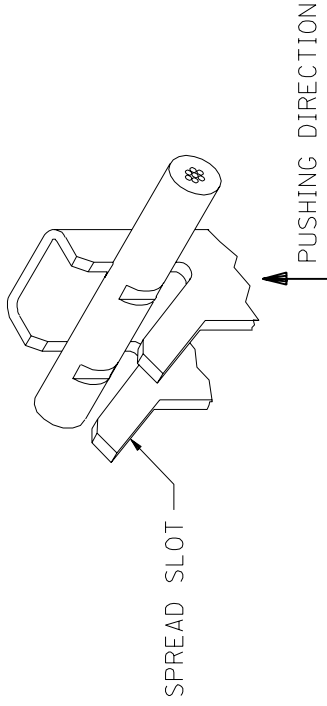
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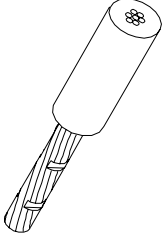
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## WIRE TERMINATION SPECIFICATION

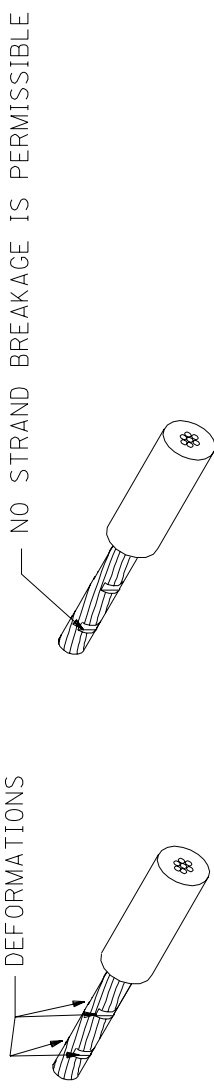
STEP 3 -CONDUCTOR REMOVAL  
USING A SMALL PAIR OF PLIERS SPREAD THE I.D.T. SLOT  
AND REMOVE CONDUCTOR BY PUSHING IN DIRECTION SHOWN



STEP 4 -REMOVING INSULATION  
INSULATION TO BE REMOVED WITHOUT DISTURBING I.D.T. AREA



STEP 5 -CONDUCTOR INSPECTION  
FOUR DEFORMATION POINTS MUST BE CLEARLY VISIBLE WHEN  
USING 10X MAGNIFICATION



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## WIRE TERMINATION SPECIFICATION

| LTR. | REVISIONS                                  |
|------|--|
| A    | RELEASED<br>PER ECR U51189<br>09/15/95 SAS |
| B    | UPDATED<br>PER ECR U70308<br>ELO 09/20/96  |

### STEP 1 -REMOVAL OF TERMINAL

INSERT THE REMOVAL TOOL(\*HT60630A) INTO THE FRONT OF OF THE CONNECTOR (AROUND THE TERMINAL) TO DEPRESS LOCK TANGS.  
PUSH THE TERMINAL/WIRE OUT THE BACK OF THE CONNECTOR.

### STEP 2 -WIRE GAGE PER CHART

| ID LETTER | WIRE GAGE |
|-----------|-----------|
| D         | 18 AWG    |
| C         | 20 AWG    |
| B         | 22 AWG    |
| A         | 24 AWG    |

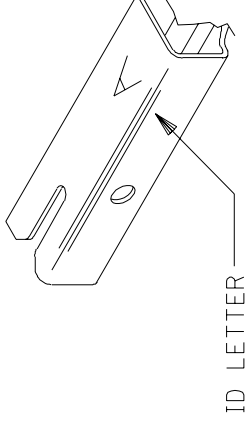


FIGURE 8

DRWG. NO. SMES-71690-0000

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