

3443-112 Locator Plate

3442-44 Platen

3442-1A Platen

Instructions for the assembly of 8250 and 8350 D Sub Connectors.

General

3M™ Manual and Pneumatic Assembly Presses and accessory assembly equipment are recommended for the termination of D Sub Connectors. 3M assembly equipment is offered to reduce set-up time, to provide easier and faster assembly, and to reduce assembly error.

The 3443-112 Locator Plate and 3442-44 Platen were designed to assemble the 8250 D Sub Connector. The 3443-112 Locator Plate is used with the 3442-1A Platen to assemble the 8350 D Sub Connector.

Connector Part number	Locator Plate Number	Platen Part Number	3436-1A Shut Height Setting		Assembly Press
			Assembly Presses 3640/3316	Assembly Presses 3335/3339-1	
8250	*3443-112	3443-44	15	15 1/2	3830
8350	*3443-112	3443-1A	20	20 1/2	3830

*Included with the 3443-112 Locator Plate is a 3442-44 Platen. The 3442-44 Platen can also be purchased separately.

Procedures for set-up:

Adjust the shut height setting (see Figures 2 through 4).

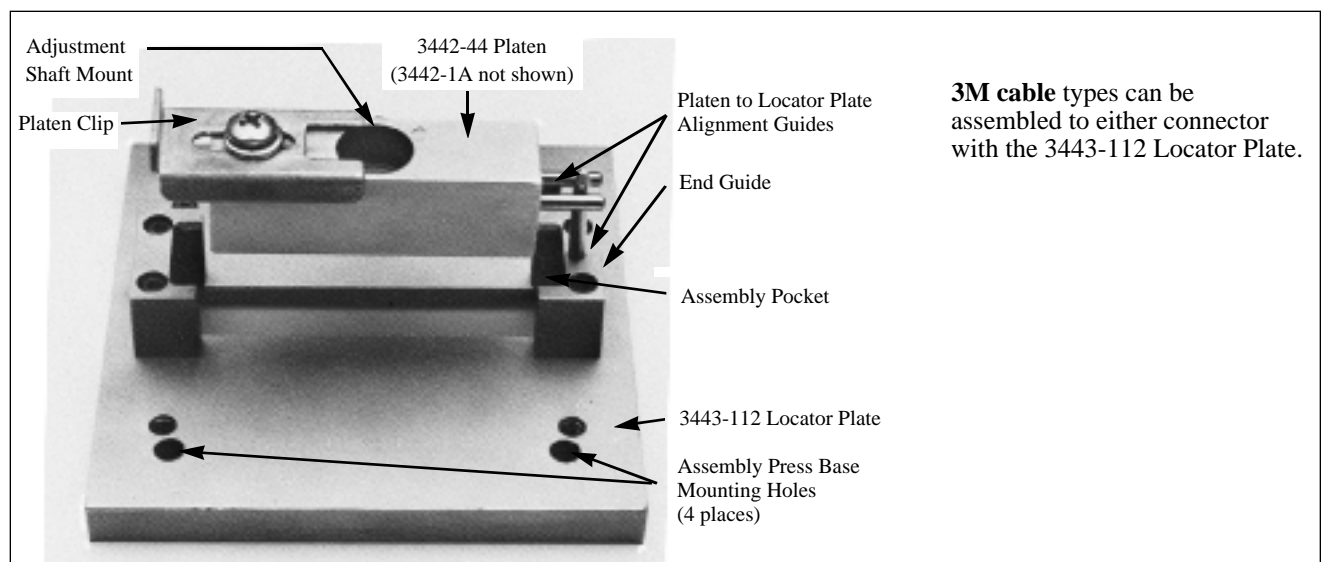


Figure 1: 3443-112 Locator Plate

Procedures for Adjusting Shut Height

Shut height settings are guidelines for proper termination depth.

The shut height adjustment is made from the base of the assembly press without the locator plate and platen in place.

1. Place the shut height gauge, 3436-1A, across the press base. (See Figures 2 and 3)
2. Lower the handle of the press until the handle casting makes contact with the press casting. (See Figure 2)
3. Rotate the shut height adjustment feature until the bottom of the shaft contacts the desired position on the gauge.
4. Install the locator plate and the appropriate platen on the press. The platen should be positioned parallel with the connector body and cover.

NOTE: See the chart on page one for the appropriate shut height setting.

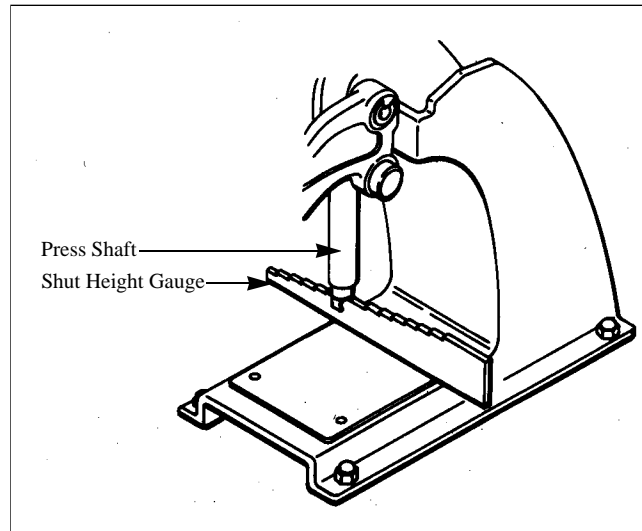


Figure 2

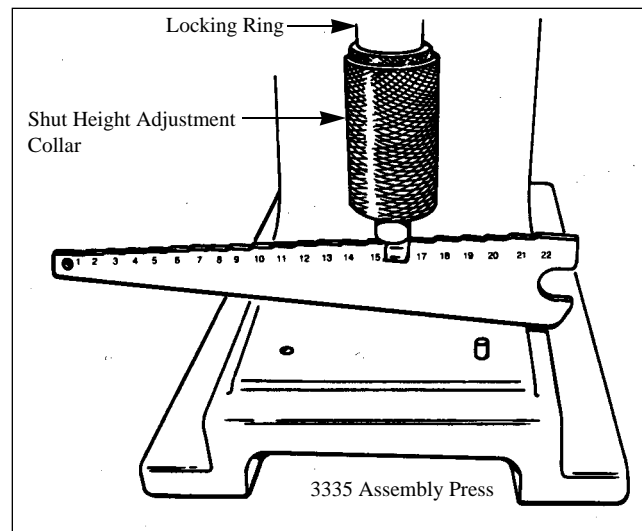


Figure 3

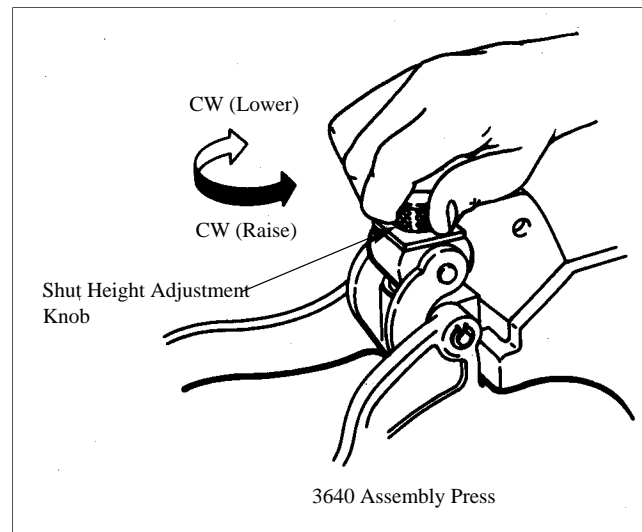


Figure 4

Procedures for Connector/Cable Assembly

1. Grasp a D Sub cover strip between thumb and forefinger of both hands, with the liner facing you. Rotate the outermost cover down against the adjacent cover on the strip, breaking it from the liner. Pull laterally away from the strip. Adhesive should be present on cover. (See Figure 5)
2. Firmly press the ribbed side of the cable into alignment grooves on cover. The adhesive will help the cable stay in place. Visually inspect to ensure that:
 - a. Cable is properly aligned to cover grooves.
 - b. Cable end is flush with the cover for end terminations or perpendicular to cover for midspan terminations. (See Figure 6)
3. Place the cable/cover sub-assembly between the guides on the locator plate, cover side down. (See Figure 7)
4. Position and orient connector body, contacts down, over the cable/cover sub-assembly, aligning cover with the body. (See Figure 7)
5. Lower the PRESS HANDLE firmly to complete the Cable/Connector Assembly. (See Figure 8)
6. Raise press handle and remove completed assembly. Visually inspect to ensure that:
 - a. Cover is fully seated and parallel with the body.
 - b. Cable is properly aligned with the cover grooves.
 - c. Cover retaining devices on the body are flush with the cover end.

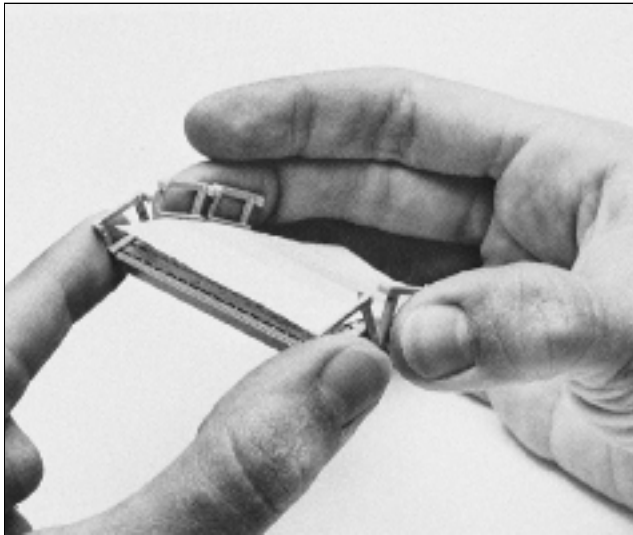


Figure 5

2

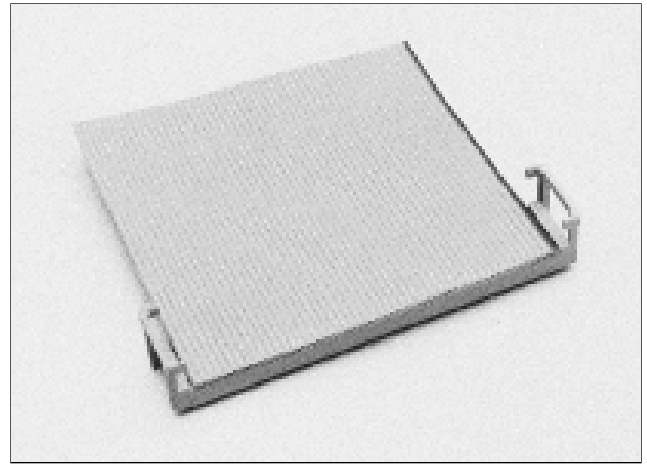


Figure 6

3

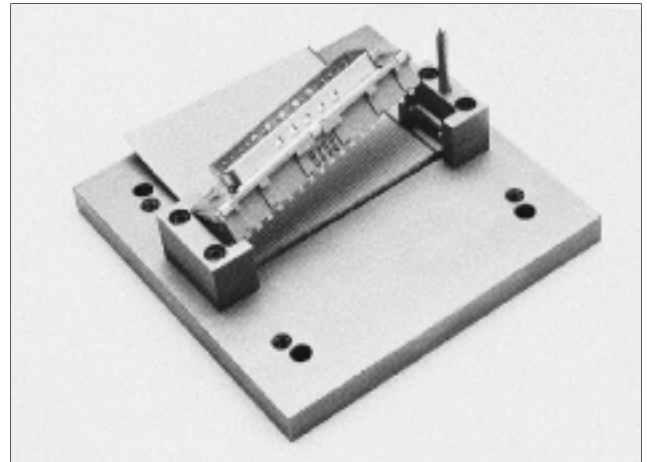


Figure 7

4

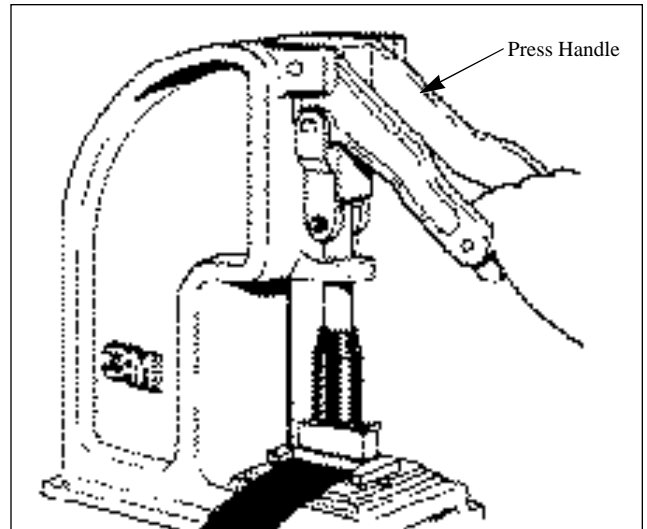


Figure 8

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