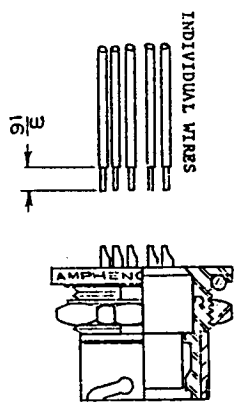


03E RECEPTACLE ASS'Y.



WIRING TECHNIQUE:

Prepare the wire for assembly by stripping the insulation to expose 3/16" of bare wire. The conductors can be tinned before they are soldered into the contact solder cups. This will permit easy entrance into the solder cups and will eliminate the possibility of loose strands.

Fill solder pockets with solder.

For easy soldering, start with the lowest contact and work toward the top.

After soldering is complete, clean area to be potted with chloroethene or equivalent, and air dry for 30 minutes.

NOTE:
Avoid excessive use of chloroethene.

DWG. NO. FIG 67-A

REVISIONS		DATE	APPROVED
SYM	ZONE	DESCRIPTION	

ITEM NO.	PART OR IDENTIFYING NO.	QTY	NON-ENCLATURE OR DESCRIPTION

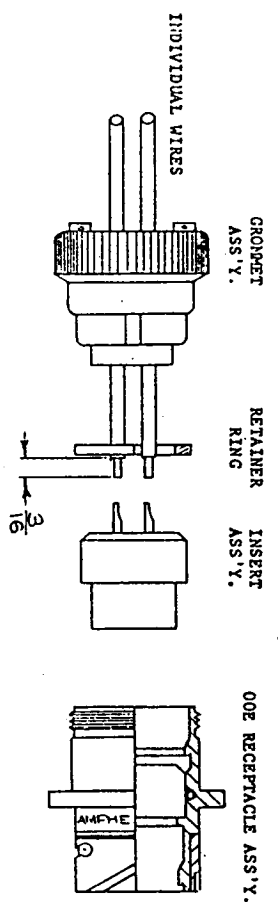
LIST OF MATERIALS OR PARTS LIST

PART USED ON	DRAWN R. MARVAK	DATE	4-16-63	TITLE	AMPHENOL-CONNECTOR DIVISION-CENTRAL OPERATION AMPHENOL-BORG ELECTRONICS CORPORATION CHICAGO, ILLINOIS
	CHECKED J.C. FX		4-16-63		
	APPROVED C.H.		4-16-63		
MATERIAL	ENGINEERING RELEASE				
	INDUSTRIAL ENGRG APPD.				
FINISH	DESIGN ACTIVITY APPD.				
EXPERIMENTAL NO.					

METHOD FOR WIRING
67 SERIES 03E RECEPTACLES

CODE IDENT NO.	02660	DWG SIZE	B	DRAWING NO.	FIG 67-A
SCALE					
SHEET					

REVISIONS		DATE	APPROVED
SYM	ZONE	DESCRIPTION	



- WIRING TECHNIQUE:
1. Insert individual wires through wire holes of grommet. (Ultra insulation may be coated with a suitable lubricant for easier grommet loading.)
 2. Prepare individual wires for soldering by stripping insulation back to expose 3/16" of bare wire. Conductors may be solder tinned before they are soldered into the contact solder cups. This will permit easy entrance into the solder cups and will eliminate the possibility of loose strands.
 3. Fill solder pockets with solder.
 4. For easier soldering, position insert with open portion of solder pocket up. Begin soldering with the lowest row of contacts and work toward the top.
 5. Slip wired insert assembly into the shell. Be sure to align keyway of insert with key lug in shell.
 6. Retain insert assembly in shell by snapping in retainer ring.
 7. Slide grommet assembly into place and tighten to affect moisture seal.

NOTE:
Alternate soldering method is to have insert assembled into shell assembly and secured by the retainer ring, prior to soldering.

ITEM NO.	PART OR IDENTIFYING NO.	QTY	RECD	NOMENCLATURE OR DESCRIPTION
LIST OF MATERIALS OR PARTS LIST				
	4-16-63			AMPHENOL-CONNECTOR DIVISION-CENTRAL OPERATION
	4-16-63			AMPHENOL-BORG ELECTRONICS CORPORATION
	4-16-63			CHICAGO, ILLINOIS
METHOD FOR WIRING 67 SERIES OOE RECEPTACLES				
PART USED ON		DRAWN R.MARVAK		
CHECKED J.C.		4-16-63		
APPROVED C.H.		4-16-63		
ENGINEERING RELEASE NO.				
INDUSTRIAL ENGRG APPD.				
DESIGN ACTIVITY APPD.				
FINISH		CODE IDENT NO.		DWG SIZE
EXPERIMENTAL NO.		02660		B
		SCALE		DRAWING NO.
				FIG 67-C
				REV.
				SHEET

4

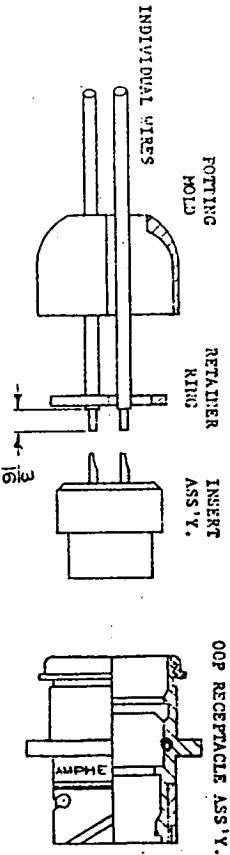
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REVISIONS

SYM	ZONE	DESCRIPTION	DATE	APPROVED



DWG. NO. FIG 67-D

WIRING TECHNIQUE:

1. Insert individual wires through pottling mold.
2. Prepare individual wires for soldering by stripping insulation back to expose 3/16" of bare wire. Conductors may be solder tinned before they are soldered into the solder cups. This will permit easy entrance into the solder cups and will eliminate the possibility of loose strands.
3. Fill solder pockets with solder.
4. For easier soldering, position insert with open portion of solder pocket up. Begin soldering with the lowest row of contacts and work toward the top.
5. Slip wired insert assembly into the shell. Be sure to align keyway of insert with key lug in shell.
6. Retain insert assembly in shell by snapping in retainer ring.
7. Assemble pottling mold onto shell assembly and fill with suitable pottling compound.

NOTE:
An alternate soldering method is to have the insert assembled into shell assembly and secured by the retainer ring prior to soldering.

ITEM NO.	PART OR IDENTIFYING NO.	QTY	NOMENCLATURE OR DESCRIPTION

PART USED ON		DRAWN R. MARVAK	
CHECKED J.C. Z.X.		DATE 4-15-63	
APPROVED C.H.		DATE 1-12-63	
MATERIAL		ENGINEERING RELEASE	
FINISH		INDUSTRIAL ENGRG APPD.	
EXPERIMENTAL NO.		DESIGN ACTIVITY APPD.	

LIST OF MATERIALS OR PARTS LIST			
AMPHENOL-CONNECTOR DIVISION-CENTRAL OPERATION			
AMPHENOL-BORG ELECTRONICS CORPORATION			
CHICAGO, ILLINOIS			
TITLE			
METHOD FOR WIRING 67 SERIES			
OOP RECEPTACLES			
CODE IDENT NO.	DWG NO.	DWG SIZE	REV.
02660	B	B	
SCALE	FIG 67-D	DRAWING NO. SHEET	

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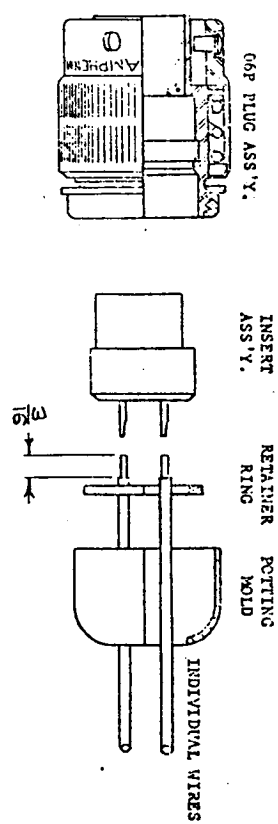
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WIRING TECHNIQUE:

1. Insert individual wires through potting mold.
2. Prepare individual wires for soldering by stripping insulation back to expose 3/16" of bare wire. Conductors may be solder tinned before they are soldered into the solder cups. This will permit easy entrance into the solder cups and will eliminate the possibility of loose strands.
3. Fill solder pockets with solder.
4. For easier soldering, position insert with open portion of solder pocket up. Begin soldering with the lowest row of contacts and work toward the top.
5. Slip wired insert assembly into the shell. Be sure to align keyway of insert with key lug in shell.
6. Retain insert assembly in shell by snapping in retainer ring.
7. Assemble potting mold onto shell assembly and fill with suitable potting compound.

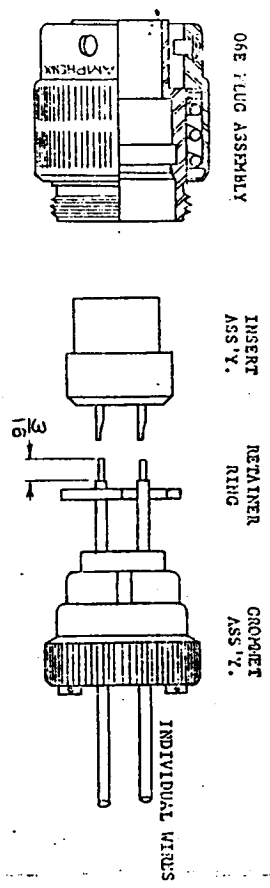
NOTE:
An alternate soldering method is to have the insert assembled into shell assembly and secured by the retainer ring prior to soldering.

DWG. No. FIG 67-E

REVISIONS		DATE	APPROVED
SYL	ZONE	DESCRIPTION	

ITEM NO.	PART OR IDENTIFYING NO.	QTY	RECD	NOMENCLATURE OR DESCRIPTION
LIST OF MATERIALS OR PARTS LIST				
METHOD FOR WIRING 67 SERIES 06P PLUGS				
PART USED ON DRAWN R. MARVAK CHECKED J. C. F. Y. APPROVED E. M.		DATE 4-15-63 4-16-63 4-16-63		
AMPHENOL-CONNECTOR DIVISION-CENTRAL OPERATION AMPHENOL-BORG ELECTRONICS CORPORATION CHICAGO, ILLINOIS				
MATERIAL ENGINEERING RELEASE NO. INDUSTRIAL ENGRG APPO. NO. DESIGN ACTIVITY APPO.				
FINISH EXPERIMENTAL NO.		CODE IDENT NO. 02660		DWG SIZE B
		DRAWING NO. FIG 67-E		REV. SHEET

A B C D



DWG. NO. FIG 67-P

SYM	ZONE	DESCRIPTION	DATE	APPROVED

WIRING TECHNIQUE:

1. Insert individual wires through wire holes of grommet. (Wire insulation may be coated with a suitable lubricant for easier grommet loading.)
2. Prepare individual wires for soldering by stripping insulation back to expose 3/16" of bare wire. Conductors may be solder tinned before they are soldered into the contact solder cups. This will permit easy entrance into the solder cups and will eliminate the possibility of loose strands.
3. Fill solder pockets with solder.
4. For easier soldering, position insert with open portion of solder pocket up. Begin soldering with the lowest row of contacts and work toward the top.
5. Slip wired insert assembly into the shell. Be sure to align keyway of insert with key lug in shell.
6. Retain insert assembly in shell by snapping in retainer ring.
7. Slide grommet assembly into place and tighten to affect moisture seal. (Note plug assembly with dummy receptacle or fixture in order that inner plug shell does not rotate when tightening grommet nut.)

NOTE:
Alternate soldering method is to have insert assembled into shell assembly and secured by the retainer ring, prior to soldering.

ITEM NO.	PART OR IDENTIFYING NO.	QTY	RECD	NOMENCLATURE OR DESCRIPTION

LIST OF MATERIALS OR PARTS LIST

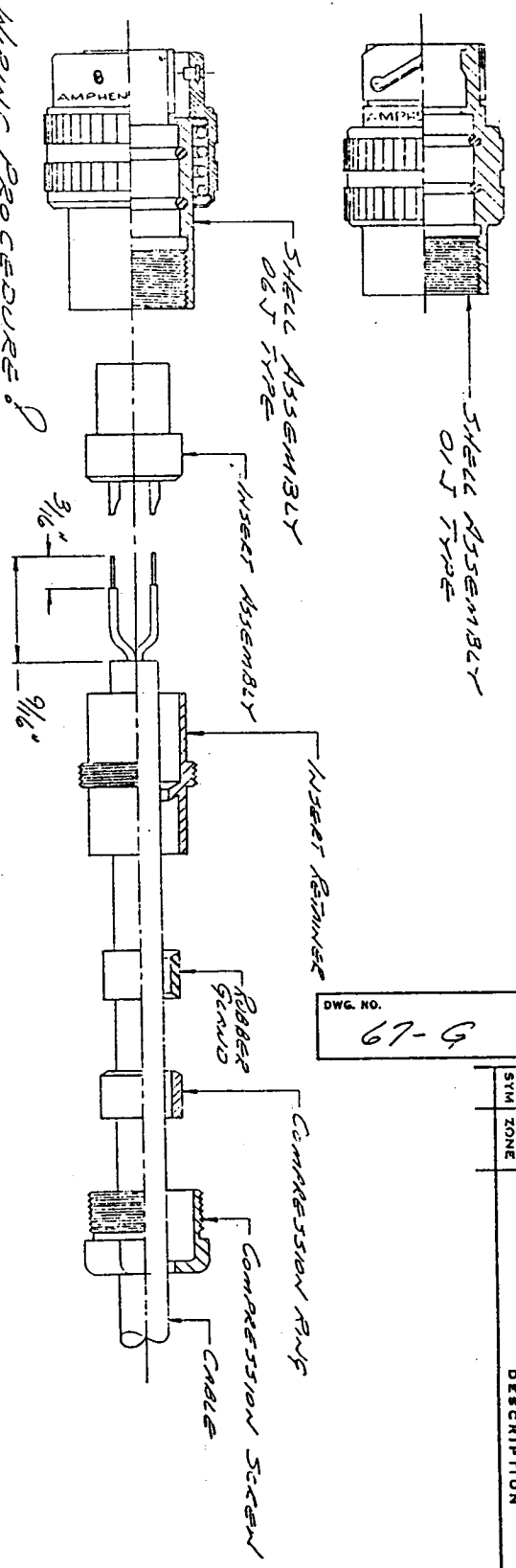
AMPHENOL-CONNECTOR DIVISION-CENTRAL OPERATION
AMPHENOL-BORG ELECTRONICS CORPORATION
CHICAGO, ILLINOIS

METHOD FOR WIRING 67 SERIES
06E PLUG ASSEMBLIES

PART USED ON		DRAWN R. MARVAK	DATE 4-15-63	TITLE	
CHECKED J.C. FX		4-16-63	4-16-63	METHOD FOR WIRING 67 SERIES 06E PLUG ASSEMBLIES	
APPROVED C.H.					
MATERIAL		ENGINEERING RELEASE		CODE IDENT NO. 02660	
INDUSTRIAL ENGRG APPD.				DWG SIZE B	
DESIGN ACTIVITY APPD.				DRAWING NO. FIG 67-P	
FINISH				SCALE	
EXPERIMENTAL NO.				REV. SHEET	

REVISIONS		DATE	APPROVED
SYM	ZONE	DESCRIPTION	

DWG. NO. 67-9



WIRING PROCEDURE

1. BOOZEY AND REMOVE COMPRESSION SCREEN AND SLIP AWAY CABLE.
2. REMOVE COMPRESSION RING, RUBBER GROUND AND INSERT RESTRAINER, AND SLIP AWAY CABLE IN THAT ORDER.
3. PREPARE THE CABLE BY STRIPPING OUTER CABLE JACKET TO EXPOSE 3/16" OF INSULATED LEADS AND INNER CONDUCTOR INSULATION TO EXPOSE 3/16" OF BARE WIRE. THE CONDUCTORS CAN BE TURNED BEHIND THEM AND SOLDERED INTO THE CONTACTS. THIS WILL PERMIT EASY REMOVAL AND THE SOLDERED CONTACTS AND WILL ELIMINATE THE POSSIBILITY OF LOOSE STRANDS.
4. REMOVE INSERT ASSEMBLY.
5. FILL SOLDER POCKETS WITH SOLDER.

SEE SHEET NO 2 OF 2

ITEM NO.	PART OR IDENTIFYING NO.	QTY	NOMENCLATURE OR DESCRIPTION
LIST OF MATERIALS OR PARTS LIST			

PART USED ON		DRAWN <i>[Signature]</i> DATE 9-10-44	
MATERIAL		CHECKED	
FINISH		APPROVED	
EXPERIMENTAL NO.		ENGINEERING RELEASE	
		INDUSTRIAL ENGRG APPD.	
		DESIGN ACTIVITY APPD.	
		CODE IDENT NO. 02660	
		DWG SIZE B	
		DRAWING NO. 67-9	
		SCALE 16:1	
		SHEET 1 OF 2	

METHOD FOR WIRING 67 SERIES CONNECTORS TYPE OJ AND OJ

A DIVISION OF AMPHENOL-BORG ELECTRONICS CORPORATION CHICAGO, ILLINOIS

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REVISIONS		DATE	APPROVED
SYM	ZONE	DESCRIPTION	

DWG. NO. 67-9

WIRING PROCEDURE CONTINUED FROM SHEET NO 1 OF 2

6. FOR EASY SOODERING, START WITH THE LOWEST CONTACTS AND WORK TOWARD THE TOP. IN SOME INSTANCES STARTING AT THE CENTER OF THE ASSEMBLY AND WORKING OUTWARD WILL BE MORE DESIRABLE.

7. FIND THE WIRED ASSEMBLY INTO THE SHELL ASSEMBLY. BE SURE TO ALIGN KEYS ON ASSEMBLY WITH KEY LOG IN THE SHELL.

8. REASSEMBLE THE FRAME AT THE CONNECTOR BY ASSEMBLING AND TIGHTENING THE ASSEMBLY INTO THE SHELL ASSEMBLY. SLIDE THE RUBBER STRAP AND COMPRESSION RING AND ASSEMBLY KEYS INTO PLACE AND COMPRESSION RING AND RUBBER STRAP TO EXACT CONTACTS. PLACE COMPRESSION RING AND RUBBER STRAP TO EXACT CONTACTS.

ITEM NO.	PART OR IDENTIFYING NO.	QTY	NONENCLATURE OR DESCRIPTION

LIST OF MATERIALS OR PARTS LIST

A MP HENOL,
A DIVISION OF AMPHENOL-BORG ELECTRONICS CORPORATION
CHICAGO, ILLINOIS

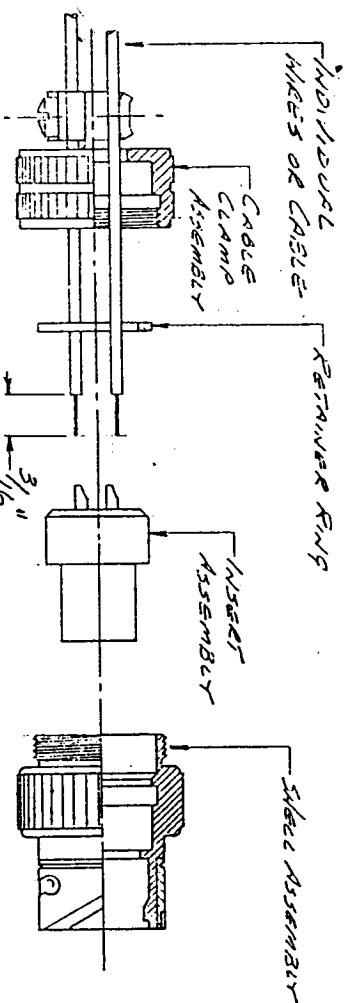
PART USED ON	DRAWN <i>[Signature]</i> DATE <i>[Date]</i>	TITLE	CODE IDENT. NO.	DWG. SIZE	DRAWING NO.	REV.
	CHECKED <i>[Signature]</i>	A DIVISION OF AMPHENOL-BORG ELECTRONICS CORPORATION CHICAGO, ILLINOIS	02660	B	67-9	
	APPROVED <i>[Signature]</i>	METHOD FOR WIRING 67 SERIES CONNECTORS TYPE OJ AND OJ1				
MATERIAL	ENGINEERING RELEASE NO.					
	INDUSTRIAL ENGRG APPD.					
FINISH	DESIGN ACTIVITY APPD.					
EXPERIMENTAL NO.	D.O.R. 1-25-1974					

SCALE 16:1

SHEET 2 OF 2

REVISIONS		DATE	APPROVED
SYN	ZONE	DESCRIPTION	

DWG. NO. **67-H**



WIRING PROCEDURES:

1. INSERT WIRES / CABLE THROUGH CABLE CLAMP ASSEMBLY AND RETAINER RING.
2. REPAIR INDIVIDUAL WIRES FOR SOLDERING BY STRIPPING INSULATION BACK TO EXPOSE 3/16" OF BARE WIRE. CONDUCTORS MAY BE SOLDER TINED BEFORE THEY ARE SOLDERED INTO THE CONTACTS THIS WILL PERMIT EASY ENTRY AND EXIT WITH THE SOLDER POCKETS AND WILL GUARANTEE THE POSSIBILITY OF LOOSE STANDARDS.
3. FILL SOLDER POCKETS WITH SOLDER.
4. FOR EASIER SOLDERING, POSITION INSERT WITH OPEN PORTION OF SOLDER PACKET UP. BEGIN SOLDERING WITH THE LOWEST ROW OF CONTACTS AND WORK TOWARD THE TOP.

SEE SHEET NO 2 OF 2

ITEM NO.	PART OR IDENTIFYING NO.	QTY	NON-ENCLOSURE OR DESCRIPTION
LIST OF MATERIALS OR PARTS LIST			

AMPHENOL
A DIVISION OF AMPHENOL-BORG ELECTRONICS CORPORATION
CHICAGO, ILLINOIS

PART USED ON		DRAWN <i>[Signature]</i> DATE 9-10-64
CHECKED		APPROVED
ENGINEERING RELEASE		INDUSTRIAL ENGRG APPD.
FINISH		DESIGN ACTIVITY APPD.
EXPERIMENTAL NO.		D.O.E. 1-25-1977A
TITLE		METHOD FOR WIRING 67 SERIES CONVERTORS TYPE OIC + O6C
CODE IDENT NO.	DWG SIZE	DRAWING NO.
02660	B	67-H
SCALE None	SHEET 1 of 2	REV.

REVISIONS		
SYM ZONE	DESCRIPTION	DATE APPROVED

DWG. NO. **67-H**

WIRING PROCEDURES CONTINUED FROM SHEET NO 1 OF 2

- 5- SCREW WIRED INSERT ASSEMBLY INTO THE SHELL ASSEMBLY
- 6- RETAIN INSERT ASSEMBLY IN SHELL ASSEMBLY BY SHAPPING IN RETAINER RING.
- 7- SOLDER CABLE CLAMP ASSEMBLY INTO PLACE AND TIGHTEN. TIGHTEN CLAMP HALVES TO EXERT A STRAIN RELIEF.

NOTE: ALTERNATE SOLDERING METHOD IS TO HAVE INSERT ASSEMBLED INTO SHELL ASSEMBLY AND SECURED BY THE RETAINER RING PRIOR TO SOLDERING.

ITEM NO.	PART OR IDENTIFYING NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION

LIST OF MATERIALS OR PARTS LIST

PART USED ON	DRAWN <i>[Signature]</i>	DATE <i>2-2-54</i>	TITLE METHOD FOR WIRING 67 SERIES CONNECTORS TYPE OIC 4 06C
	CHECKED		
MATERIAL	ENGINEERING RELEASE NO.		CODE IDENT NO. 02660
	INDUSTRIAL ENGRG APPD.		
FINISH	DESIGN ACTIVITY APPD.		DWG SIZE B
EXPERIMENTAL NO.	<i>D.O.R.</i>	<i>1-R5-19774</i>	DRAWING NO. 67-H

AMPHENOL
A DIVISION OF AMPHENOL-BORG ELECTRONICS CORPORATION
CHICAGO, ILLINOIS

SCALE *None* SHEET **2 of 2**