

ASSEMBLY PROCEDURE FOR THE TERMINAL END OF HIGH PRESSURE CONNECTORS

1. Orient the white dot on the rigid insulation so that it is in line with the white mark on the face of the insert in the shell. Insert the wires through the cable clamp (P-207527-53) and the rigid insulation (P-207527-38K). See Figure 1.
2. Insert the wires in the same order through the grommet seal so that the holes in the rigid and grommet line up. The dot on the grommet will be helpful in lining up. Any lubricating fluid, such as silicone oil, that is compatible for use with neoprene, can be used for lubricating the wires. Care should be exercised not to ruin the convoluted neoprene seal (P-207527-37D). Leave about 6" of wire from the face of the grommet.
3. Dress the wires and crimp the socket contacts, leaving no more than 1/32" gap between the socket contact and the conductor. See Figure 2.
4. Using the red tip of the insertion tool, insert the socket contact into the plug connector. See Figures 3 & 4.
5. Align both axially marked white dots. This will automatically allow the key on the rigid insulation to go into the rubber cavity for insulation alignment. See Figure 1.
6. Advance both insulations forward, making sure that the wires are straight and in no way are twisted. Apply lubricating oil on the face of the rigid dielectric, so the insert will not rotate, and will not result in twisted wires, when the clamp nut is tightened. Tighten by applying 20 ft. lbs. of torque on the clamp nut onto the plug shell. See Figure 4. Insure that the 20 ft. lbs. of torque is retained, and recheck this value after 20 min.
7. Bundle the wires and apply the cable clamp sector. See Figure 4.

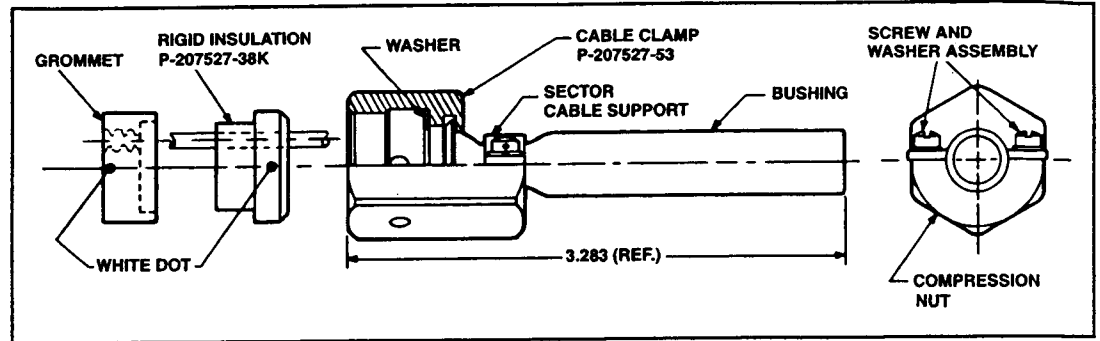


FIGURE 1

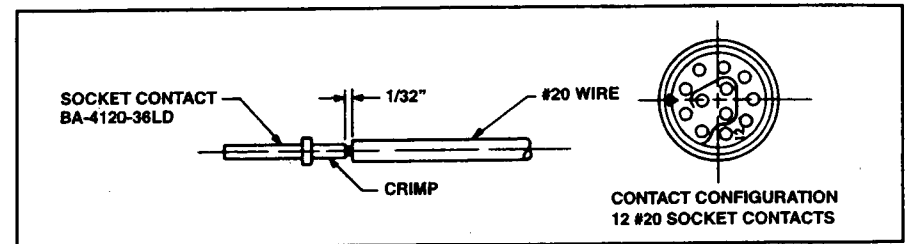


FIGURE 2

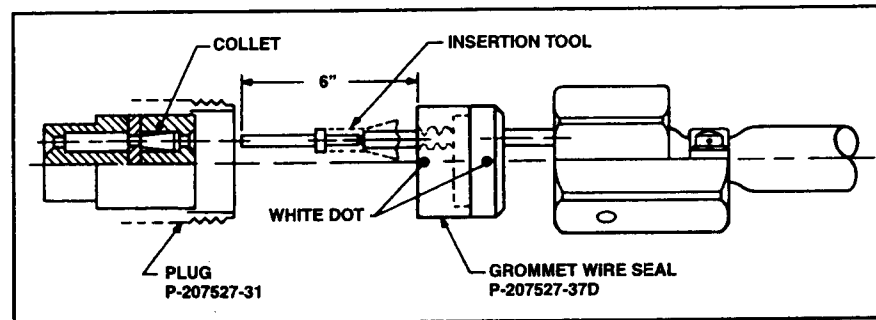


FIGURE 3

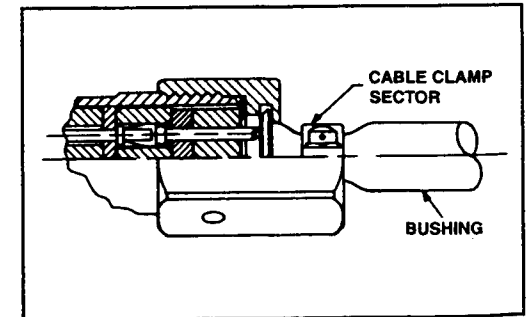


FIGURE 4

AMPHENOL CORPORATION
Amphenol Aerospace
607-563-5011
40-60 Delaware Ave.
Sidney, NY. 13838

Form No. PN-1006 4/98

Reference Drawing No. EXC-4006-209