

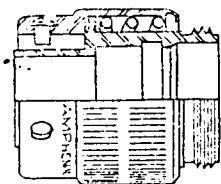
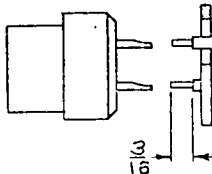
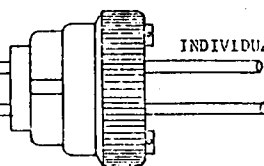
4

3

2

1

06E PLUG ASSEMBLY

INSERT  
ASS'Y.RETAINER  
RINGGROMMET  
ASS'Y.

INDIVIDUAL WIRES

0.100

DWG. NO.  
FIG 67-F

## REVISIONS

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. (Mate 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 REQD	NOMENCLATURE OR DESCRIPTION
LIST OF MATERIALS OR PARTS LIST			
PART USED ON		DRAWN R. MARVAK	DATE 4-15-63
CHECKED J. C. J. X		4-16-63	AMPHENOL-CONNECTOR DIVISION-CENTRAL OPERATION AMPHENOL-BORG ELECTRONICS CORPORATION CHICAGO, ILLINOIS
APPROVED C. H.		4-16-63	
MATERIAL		ENGINEERING RELEASE No. INDUSTRIAL ENGRG APPD.	
FINISH		DESIGN ACTIVITY APPD.	TITLE METHOD FOR WIRING 67 SERIES 06E PLUG ASSEMBLIES
EXPERIMENTAL NO.			CODE IDENT NO. 02660
			DWG SIZE B
			DRAWING NO. FIG 67-F
			REV.
		SCALE	SHEET

4

3

2

1