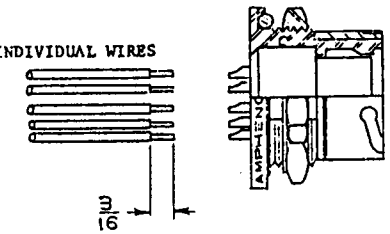
03E RECEPTACLE ASS'Y.

INDIVIDUAL WIRES



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 chlorothene or equivalent, and air dry for 30 minutes.

NOTE:
Avoid excessive use of chlorothene.

DWG. NO. FIG 67-A

REVISIONS

SYM	ZONE	DESCRIPTION	DATE	APPROVED

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

LIST OF MATERIALS OR PARTS LIST

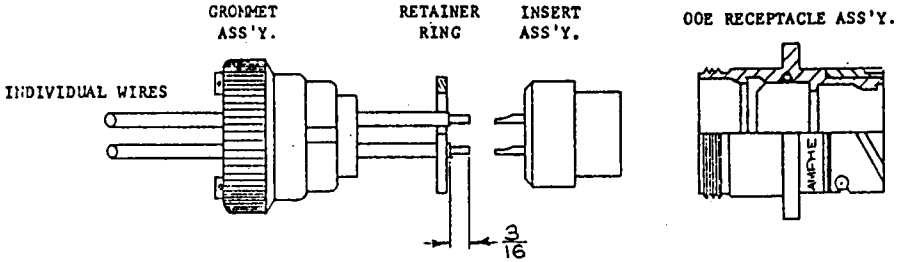
PART USED ON	DRAWN R.MARVAK	DATE 4-16-63
	CHECKED J.C.	4-16-63
	APPROVED C.H.	4-16-63
	ENGINEERING RELEASE No.	
MATERIAL	INDUSTRIAL ENGRG APPD.	
FINISH	DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.		

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

TITLE

METHOD FOR WIRING
67 SERIES 03E RECEPTACLES

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



DWG. NO. FIG 67-C

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.

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

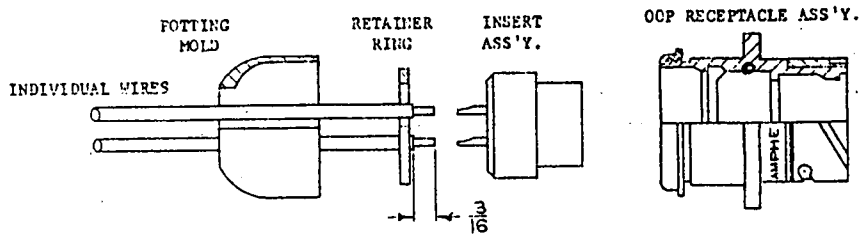
LIST OF MATERIALS OR PARTS LIST

PART USED ON	DRAWN R.MARVAK	DATE 4-16-63
	CHECKED J.C.	4-16-63
	APPROVED C. F.	4-16-63
	ENGINEERING RELEASE No.	
MATERIAL	INDUSTRIAL ENGRG APPD.	
FINISH	DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.		

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

TITLE
METHOD FOR WIRING 67
SERIES 00E RECEPTACLES

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



DWG. NO. FIG 67-D

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED

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.

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

LIST OF MATERIALS OR PARTS LIST

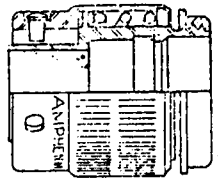
PART USED ON		DRAWN R. MARVAK	DATE 4-15-63
		CHECKED J.C. ≠ X.	4-16-63
		APPROVED C.H.	1-16-63
		ENGINEERING RELEASE No.	
MATERIAL		INDUSTRIAL ENGRG APPD.	
FINISH		DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.			

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

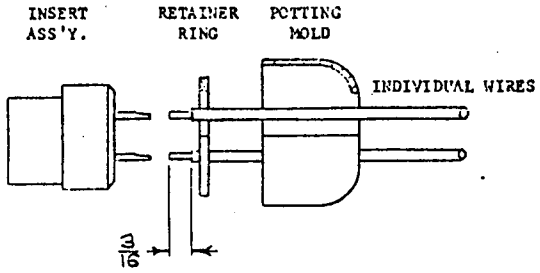
TITLE

METHOD FOR WIRING 67 SERIES
OOP RECEPTACLES

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



06P PLUG ASS'Y.



DWG. NO. FIG 67-E

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED

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.

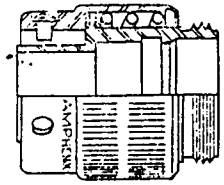
NOTE:
An alternate soldering method is to have the insert assembled into shell assembly and secured by the retainer ring prior to soldering.

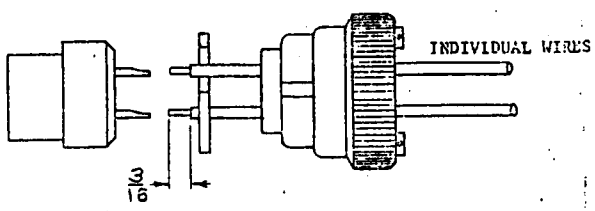
ITEM NO.	PART OR IDENTIFYING NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION

LIST OF MATERIALS OR PARTS LIST

PART USED ON		DATE	AMPHENOL-CONNECTOR DIVISION-CENTRAL OPERATION AMPHENOL-BORG ELECTRONICS CORPORATION CHICAGO, ILLINOIS
	DRAWN R.MARVAK	4-15-63	
	CHECKED J.C.	4-16-63	
	APPROVED C.H.	4-16-63	
	ENGINEERING RELEASE NO.		TITLE: METHOD FOR WIRING 67 SERIES 06P PLUGS
MATERIAL	INDUSTRIAL ENGRG APPD.		
FINISH	DESIGN ACTIVITY APPD.		CODE IDENT NO. 02660 / DWG SIZE B / DRAWING NO. FIG 67-E / REV.
EXPERIMENTAL NO.			SCALE / SHEET

06E PLUG ASSEMBLY





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.	4-16-63
	APPROVED C. H.	4-16-63
	ENGINEERING RELEASE No.	
MATERIAL	INDUSTRIAL ENGRG APPD.	
FINISH	DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.		

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

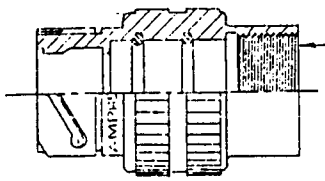
TITLE
METHOD FOR WIRING 67 SERIES
06E PLUG ASSEMBLIES

CODE IDENT NO.	DWG SIZE	DRAWING NO.	REV.
02660	B	FIG 67-F	

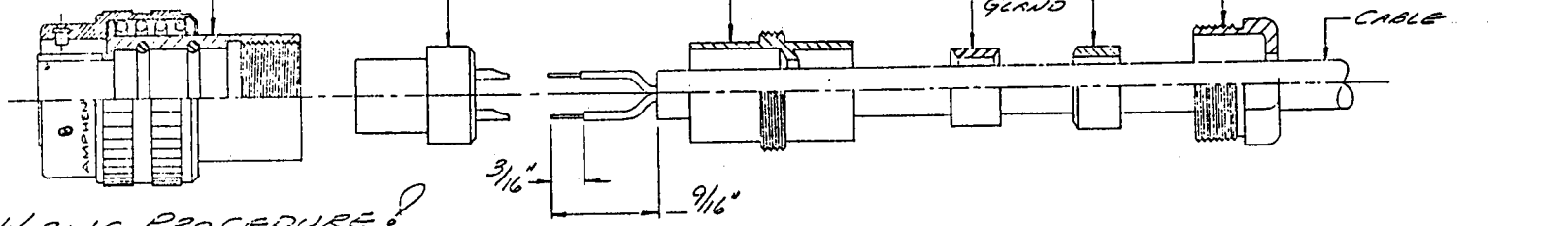
SCALE | SHEET

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED

DWG. NO. 67-G



SHELL ASSEMBLY
01J TYPE



WIRING PROCEDURE!

1. LOOSEN AND REMOVE COMPRESSION SCREW, AND SLIP ONTO CABLE.
2. REMOVE COMPRESSION RING, RUBBER GLAND AND INSERT RETAINER, AND SLIP ONTO CABLE IN THAT ORDER.
3. PREPARE THE CABLE FOR ASSEMBLY BY STRIPPING OUTER CABLE JACKET TO EXPOSE 9/16" OF INSULATED LEADS AND INNER CONDUCTOR INSULATION TO EXPOSE 3/16" OF BARE WIRE. THE CONDUCTORS CAN BE TINNED BEFORE THEY ARE SOLDERED INTO THE CONTACTS. THIS WILL PERMIT EASY ENTRANCE INTO THE SOLDER POCKETS 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 REQD	NOMENCLATURE OR DESCRIPTION

LIST OF MATERIALS OR PARTS LIST

PART USED ON	DRAWN L. W. Bennett	DATE 9-10-64
	CHECKED	
	APPROVED	
	ENGINEERING RELEASE No.	
MATERIAL	INDUSTRIAL ENGRG APPD.	
FINISH	DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.	D.O.R. 1-45-19774	

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

TITLE

METHOD FOR WIRING
67 SERIES CONNECTORS
TYPE 01J AND 06J

CODE IDENT NO.	DWG SIZE	DRAWING NO.	REV.
02660	B	67-G	

SCALE NONE SHEET 1 OF 2

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED

DWG. NO. 67-G

WIRING PROCEDURE CONTINUED FROM SHEET No 1 OF 2

6- FOR EASY SOLDERING, START WITH THE LOWEST CONTACTS AND WORK TOWARD THE TOP. IN SOME INSTANCES STARTING AT THE CENTER OF THE INSERT AND WORKING OUTWARD IN ALL DIRECTIONS MAY BE MORE DESIRABLE.

7- SLIP THE WIRED INSERT ASSEMBLY INTO THE SHELL ASSEMBLY. BE SURE TO ALIGN KEYWAY ON INSERT WITH KEY LUG IN THE SHELL.

8- REASSEMBLE THE BALANCE OF THE CONNECTOR BY INSERTING AND TIGHTENING THE INSERT RETAINER INTO THE SHELL ASSEMBLY. SLIDE THE RUBBER GLAND AND COMPRESSION RING INTO INSERT RETAINER.

9- PLACE COMPRESSION SCREW INTO POSITION, AND TIGHTEN TO EFFECT COMPLETE MOISTURE SEAL.

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

LIST OF MATERIALS OR PARTS LIST

PART USED ON	DRAWN	DATE
	CHECKED	
	APPROVED	
	ENGINEERING RELEASE No.	
MATERIAL	INDUSTRIAL ENGRG APPD.	
FINISH	DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.	D.O.R. 1-25-1977	

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

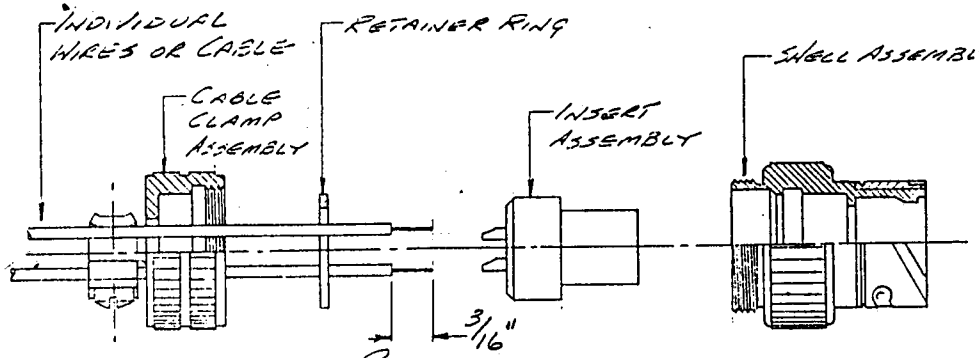
TITLE
METHOD FOR WIRING
67 SERIES CONNECTORS
TYPE 01J AND 06J

CODE IDENT NO.	DWG SIZE	DRAWING NO.	REV.
02660	B	67-G	

SCALE None SHEET 2 OF 2

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED

DWG. NO. 67-H



WIRING PROCEDURE

1. INSERT WIRES / CABLE THROUGH CABLE CLAMP ASSEMBLY AND RETAINER RING.
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 CONTACTS. THIS WILL PERMIT EASY ENTRANCE INTO THE SOLDER POCKETS 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.

SEE SHEET No 2 OF 2

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

LIST OF MATERIALS OR PARTS LIST

PART USED ON	DRAWN K. Hopkins	DATE 9-10-64
	CHECKED	
	APPROVED	
MATERIAL	ENGINEERING RELEASE No.	
	INDUSTRIAL ENGRG APPD.	
FINISH	DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.	D.O.E. 1-25-1977A	

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

TITLE
METHOD FOR WIRING
67 SERIES CONNECTORS
TYPE 01C + 06C

CODE IDENT NO.	DWG SIZE	DRAWING NO.	REV.
02660	B	67-H	

SCALE NONE SHEET 1 OF 2

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED

DWG. NO. 67-H

WIRING PROCEDURE CONTINUED FROM SHEET No 1 OF 2

5- SLIP WIRED INSERT ASSEMBLY INTO THE SHELL ASSEMBLY.
6- RETAIN INSERT ASSEMBLY IN SHELL ASSEMBLY BY SNAPPING IN RETAINER RING.
7- SLIDE CABLE CLAMP ASSEMBLY INTO PLACE AND TIGHTEN. TIGHTEN CLAMP HALVES TO EFFECT 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	DATE 2-10-64
	CHECKED	
	APPROVED	
	ENGINEERING RELEASE No.	
MATERIAL	INDUSTRIAL ENGRG APPD.	
FINISH	DESIGN ACTIVITY APPD.	
EXPERIMENTAL NO.	D.O.R. 1-25-1977	

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

TITLE
METHOD FOR WIRING 67 SERIES CONNECTORS TYPE 01C & 06C

CODE IDENT NO.	DWG SIZE	DRAWING NO.	REV.
02660	B	67-H	

SCALE NONE SHEET 2 OF 2