

AMPHENOL® / MATRIX® “MINIMATE” CONNECTOR ASSEMBLY INSTRUCTIONS

MINIMATE ASSEMBLY

The Amphenol/Matrix Minimate connector is a high reliability connector and will meet or exceed all of its design requirements when properly assembled. The correct procedure and tools must be used during the assembly of this connector in order to maintain the reliability; the same as with any other high reliability product.

To assemble the Minimate connector, the following tools are required:

1. Crimp tool (See Table 1)
2. Insertion tool - part number 90-0001-002
3. Removal tool - part number 90-002-022
4. Insulation stripper (Hot wire preferred)

Step A: Cut wire to desired length.

Step B: Strip insulation off end of the wire that will be crimped to the contact.
Stripping length is $.115 \pm .010$.

Step C: Adjust crimp tool to the A.W.G. wire size that is to be crimped.

Step D: Place contact into the crimp tool. Insert wire into the crimp pot of the contact. Push the wire in until it bottoms, then crimp the contact.

Step E: After crimping, the wire end is visible thru the inspection hole.

INSERTION OF CONTACTS

Insert the crimped contact into the selected cavity on the rear of the rubber grommet. Using finger tips, push the contact into the rubber until approximately 1/2 of the crimp pot is exposed (See Figure 1). The metal tool tip is then placed against the rear of the contact, and with a gentle force, push contact into the locked position (See Figure 2).

CAUTION

When using the insertion tool, do not allow contact to be displaced sideways or tilted. The contact must be kept in a straight line with the cavity during insertion.

REMOVAL OF CONTACTS

Hold the removal tool with finger tips (See Figure 3). Place the tube of the removal tool over

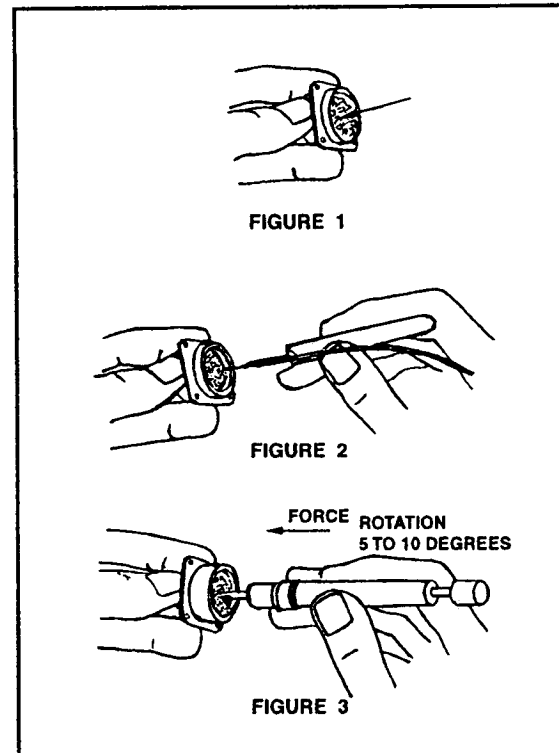
the contact to be removed. Rotate the tool approximately 5 to 10 degrees, back and forth, applying pressure while rotating. The tube is spring loaded and will slide into the handle when pressure is being applied. This action will place the contact in the unlocked position (See Figure 3). The contact can then be removed easily.

CAUTION

Do not tilt tool when removing contact.

Table 1: Crimping Tools

Tool	Locator/Positioner
Daniels MS3198-1 Daniels MH780 Daniels MH750, 760	Locator A-101 Locator A-101 Locator P-101
Buchanan 11331 Buchanan 612118	Positioner 612112 Locator 612593



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