



Pak 25E, LE and R Assembly Application Tools

Instructions

The assembly of 3M™ PAK 25 connectors and 3M™ 3754 Cable can be accomplished when using the 3M™ 3443-127 Series Locator Plates and the 3M™ 3640 or 3335 Assembly Press.

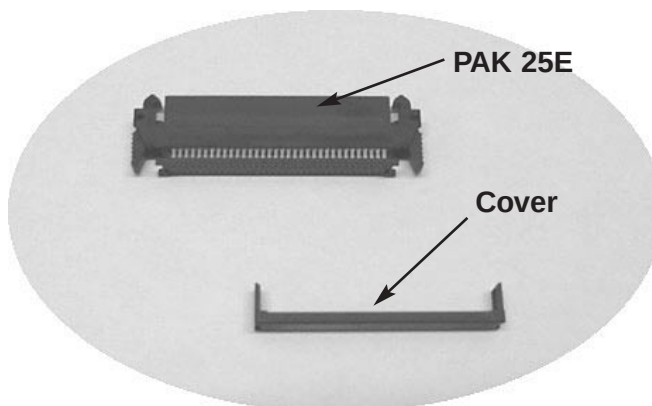
Tools required:

PAK25E, LE and R Application Tools

PAK 25E, LE & R	3M Locator Plate	Stock Numbers	3M Shut Height Gage	
			25E and 25R	25LE
20/32 Pos.	3443-127A	80-4000-1617-8	3436-1H Shut height setting: 3640 Press = 17 1/2 3335 Press = 18	3436-1G Shut height setting: 3640 Press = 13 3335 Press = 13 1/2
26/40 Pos.	3443-127B	80-4000-1618-6		
30/50 Pos.	3443-127C	80-4000-1619-4		
34/60 Pos.	3443-127D	80-4000-1620-2		
52-68 Pos.	3443-127E	80-4000-1621-0		
80/100 Pos.	3443-127F	80-4000-1622-8		

Product #	Description	Stock Number
3640	Assembly Press	80-6100-7882-8
3335 (alternate to the 3640)	Assembly Press	80-6100-3208-0
3436-1H	Shut Height Gage	78-8118-0907-4 (used with PAK 25E and 25R)
3436-1G	Shut Height Gage	78-8118-0906-6 (used with PAK 25LE)
3442-126	Platen	80-6104-7838-2

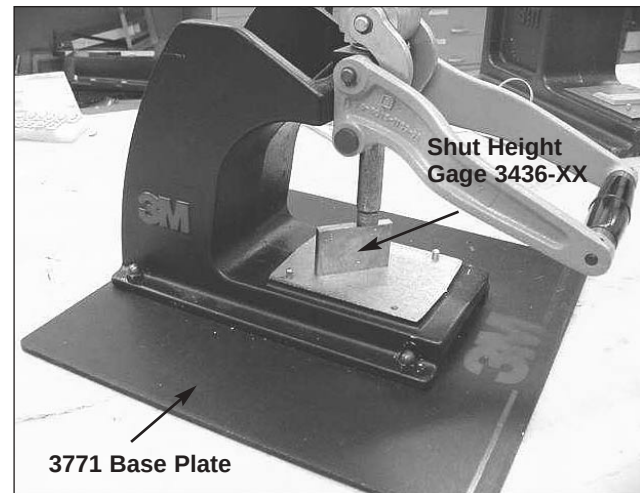
PAK 25 Series Connector



Assembly Press Setup

1. The appropriate 3M™ 3436-1X Shut Height Gauge was shipped with the locator plate. The setting height is inscribed on the side of the gauge. Select the gauge end with the same marking selected in step one. From the chart on page one, determine the appropriate shut height gauge setting for the connector style and press that you are using.
2. Place the shut height gauge on the base of the press and lightly bring down the shaft of the press onto the surface of the shut height gauge. Adjust the shaft length by turning the adjusting knob on the top of the shaft (3640) or the adjusting collar on the lower portion of the shaft of the press (3335) so that the press handle comes completely down with only a small amount of pressure from the press shaft on the shut height gauge. On the 3335 only, tighten the locking collar. The shut height distance is now set.
3. Place the 3442-126 platen on the end of the press shaft and lock it in place by sliding the holding clamp on the platen into the groove on the press shaft. Your assembly press is now set up.

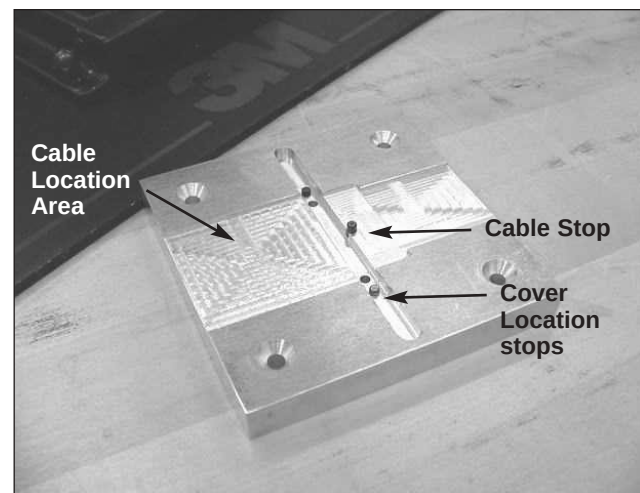
Note: The 3M™ 3640 Assembly Press in the picture is shown with the separately purchased 3M™ 3771 Base Plate which adds stabilization to the press. Its use is optional. The 3M™ 3335 Heavy Duty Press is also applicable, but not shown.



Assembly Press Setup

Locator Plate Setup

1. Determine if you will be terminating the cable at its end or along the length of the cable (daisy-chain).
2. For end terminations, place the cable stop into the hole in the locator plate as shown. For daisy-chain terminations, do not put the cable stop in place.
3. Place the two cover location stops into position on the locator plate as shown. The position toward the outside edge is for the higher pin count connector. The position toward the center is for the lower pin count connector.
4. The locator plate can now be positioned on the press base under the platen. Some operators prefer to place the locator plate into the press after they have prepped the cable and connector for termination. If you prefer this method, be sure that the cable and connector do not move when you place the locator plate into place on the press.

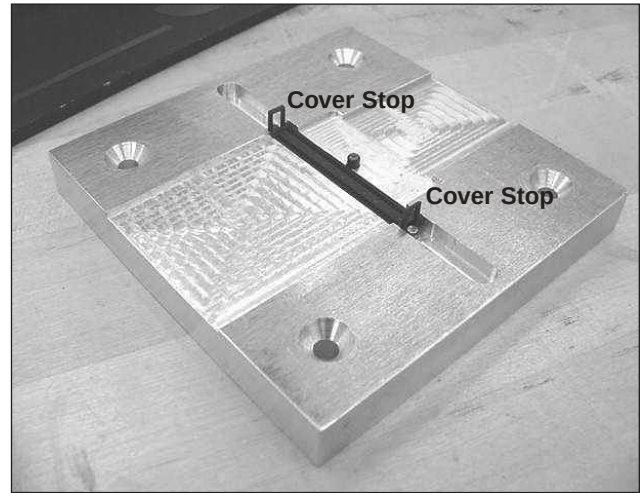


Locator Plate Setup

Connector Assembly

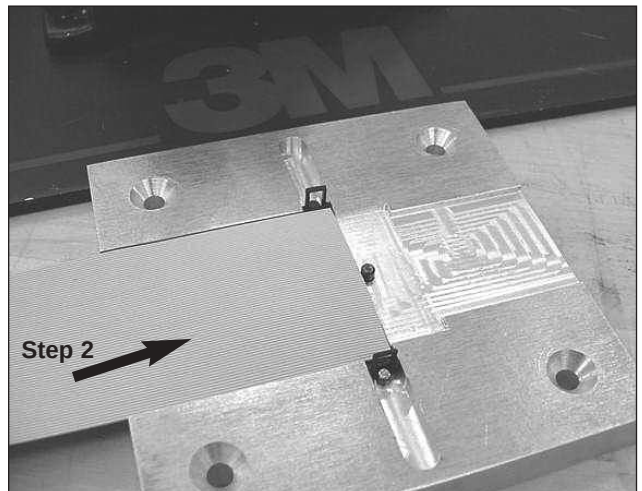
Note: For clarity, the pictures show the cable and connectors being positioned on the locator plate while it is on the table top. This can also be done while the plate is in position on the press.

1. Place the cover in the groove on the locator plate and between the two cover stops.



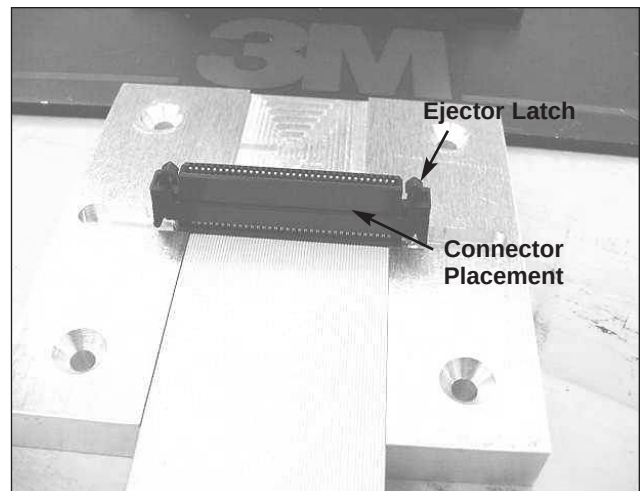
Connector Assembly Step 1

2. Place the cable in the cable track, on top of the cover and up against the cable stop (end termination). Maintain pressure on the cable with your hand to keep the cable in position.



Connector Assembly Step 2

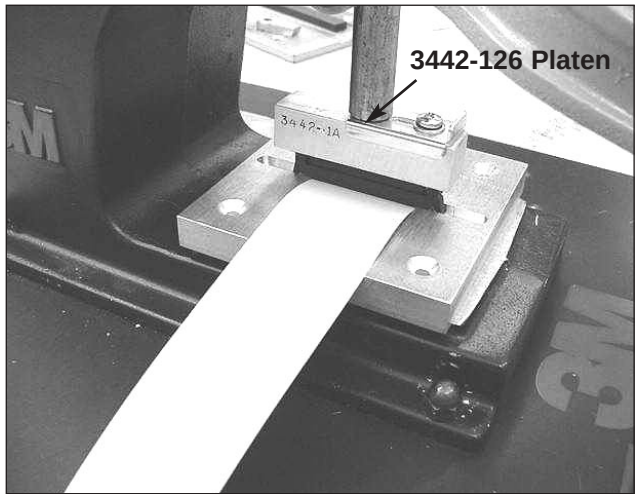
3. Make sure that the tips of the ejector latch on the connector are pushed in toward the center of the connector.
4. Place the connector body on top of the cable engaging the protruding cover latches with the appropriate slots on the connector body. The connector may be pressed down by hand for an initial placement. You will hear a clicking sound when the connector has been pressed down an appropriate distance.
5. If you did the assembly on the table top, place the locator plate and cable and connector together onto the base of the assembly press. Be sure that the cable does not move and that the connector does not slip out of the groove on the locator plate.



Connector Assembly Steps 3, 4, 5

6. To complete the assembly, push the assembly press handle down until the press handle stops against the press frame. This will press the connector onto the cable permanently.
7. Lift the press handle and remove the terminated connector and cable from the locator plate.
8. Inspect the finished assembly to assure that the cover latches are latched fully. If the cover latches are not completely latched, a minor shut height adjustment may be required.

 **Caution: Do not over terminate!**



Connector Assembly Step 6

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