



Instructions for the assembly of Scotchflex D.I.P. Connectors

General:

Although any parallel action device can be used to assemble Scotchflex D.I.P. Connectors, it is recommended that one of the Scotchflex manual or pneumatic assembly presses be used. Scotchflex accessories are also recommended for ease of assembly. For more information, see your Scotchflex representative.

Table 1:

Use the following settings for height and position of each platen when assembling Scotchflex D.I.P. connectors. All adjustments settings are referenced from locator plate surface.

Number Of Contacts	Connector Part Number	Locator Plate Number	Platen Part Number	Adjustment Setting Gauge	Position of Platen
14	All versions of 3406	3443-12	3442-1A	*2	Perpendicular to Connector
				**2½	
			***3442-14	*11½	Parallel to Connector
				**12	
16	All versions of 3416	3443-13	3442-1A	*2	Perpendicular to Connector
				**2½	
			***3442-16	*11½	Parallel to Connector
				**12	
	3498-0000	3443-43	3442-1A	*2	Perpendicular to Connector
				**2½	
24	All versions of 3460	3443-10	3442-6	*2	Parallel to Connector
				**2½	
40	All versions of 3508	3443-47	3442-8	*2	Parallel to Connector
				**2½	

* Adjustment settings for Scotchflex Model 3640 assembly press.

** Adjustment settings for Scotchflex Model 3335, 3335-1, 3339, and 3339-1 assembly presses.

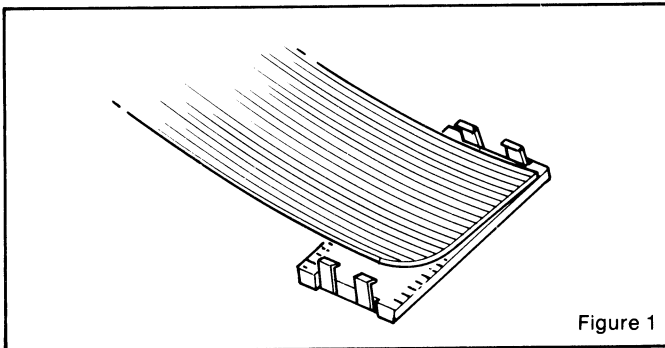
*** Platen for "riveting" covers to connector bodies for enhanced cover retention.

Set-Up:

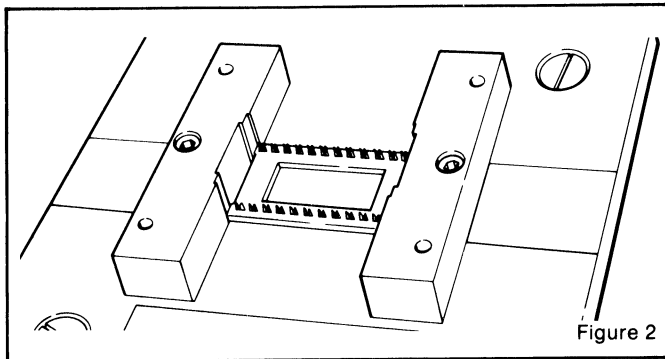
1. Refer to Table 1 to determine the appropriate locator plate and correct shut height setting of the Scotchflex assembly press. Remove platen from press and make proper shut height setting, referencing locator plate surface.
2. Replace the pressure platen, orienting as indicated in Table 1.

*Assembly:

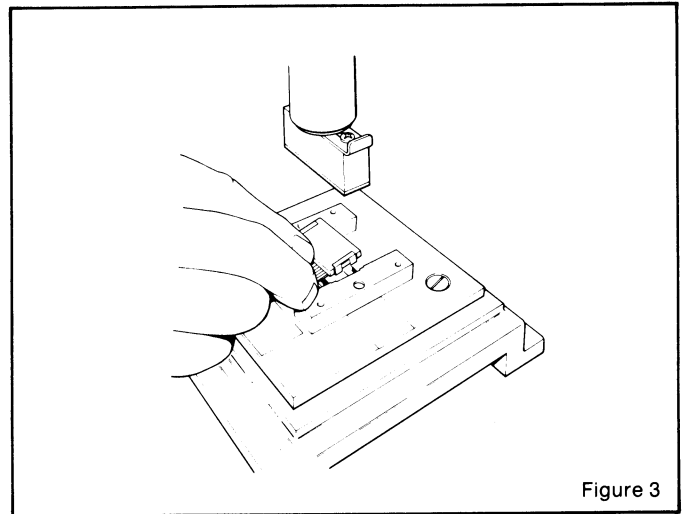
1. Rub paper liner on connector cover for maximum adhesive transfer. Remove connector cover from paper liner.
2. Press cable ribs into cover alignment grooves. (Figure 1)



3. Visually inspect to insure that:
 - a) Cable is properly aligned and oriented in cover grooves.
 - b) Cable end is flush with cover for end terminations, or the cable is perpendicular to the cover for intermediate terminations.
4. Place the connector body in position on the locator plate. (Figure 2)

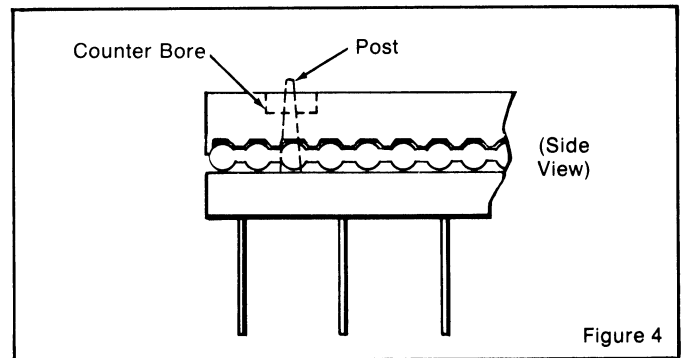


5. Place the cable-cover subassembly over the connector body. (Figure 3)



6. Lower assembly press handle fully to complete termination.
7. Raise the assembly press handle and remove completed assembly.
8. Visually inspect to ensure that:
 - a) Cover is fully seated and parallel to body.
 - b) Cable end is flush with cover for end terminations or the cable is perpendicular to the cover for intermediate terminations.
 - c) Cable is correctly aligned with cover grooves.

***Note:** Scotchflex® 3406 and 3416 D.I.P. connectors offer the option of two methods of assembly. First, standard assembly (3442-1A platen) provides improved cover retention over earlier model 14 and 16 position D.I.P. connectors. (Figure 4)



Second, by changing the platen (3442-14 for 3406, 3442-16 for 3416), "riveted" cover assembly can be accomplished. This assembly method enhances the standard cover retention of the 3406 and 3416 connectors. (Figure 5)

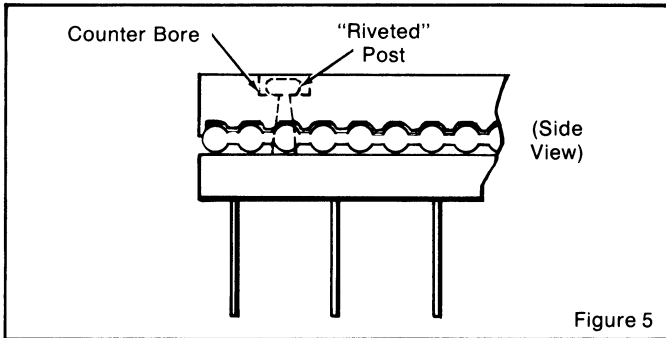


Figure 5

Refer to Table 1 for proper settings.

Strain Relief Attachment:

Scotchflex 3448-7 and 3448-8 strain reliefs are used on Scotchflex 3406 and 3416 D.I.P. connectors respectively.

1. Fold the cable back over the cover.
2. Engage one end of the clip under the body and snap the clip over the assembly, engaging the opposite end with finger pressure. This may be done with assembly in hand or in locator plate. (Figures 6a and 6b)

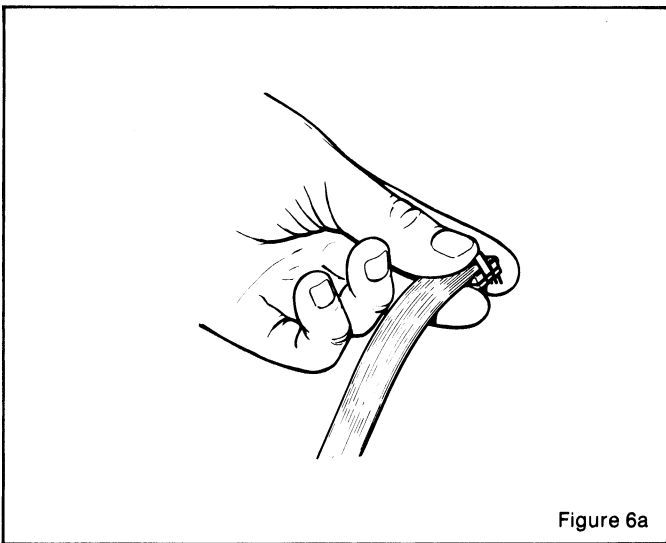


Figure 6a

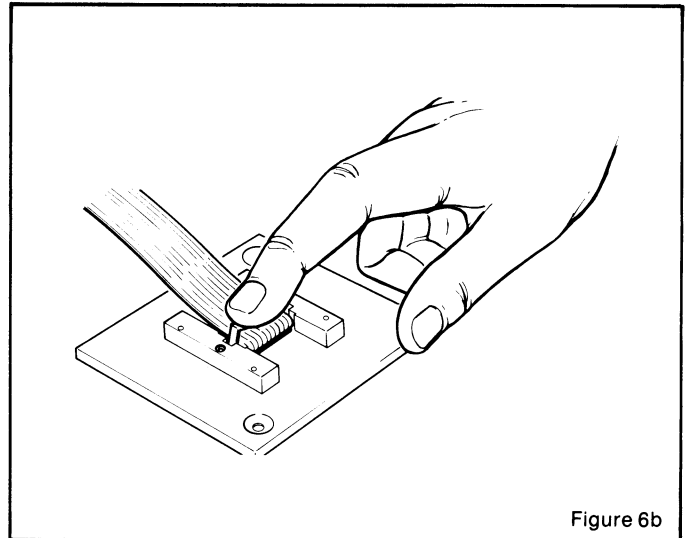


Figure 6b

Scotchflex 3448-25 and 3448-18 strain reliefs are used on Scotchflex 3460 and 3508 D.I.P. connectors respectively.

1. Snap metal strain relief clip into plastic strain relief channel. (Figure 7) Tilt clip slightly when placing in channel to ease insertion.

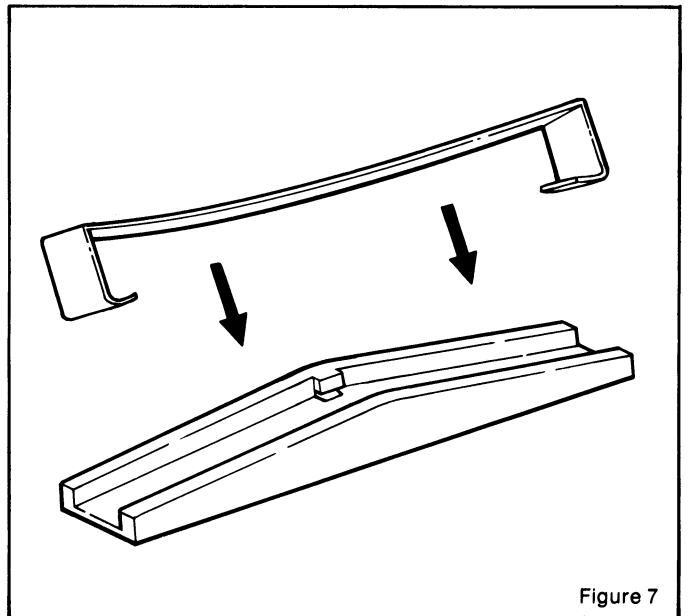


Figure 7

2. Fold the cable back over the cover.
3. Engage one end of the clip under the body and snap the clip over the assembly, engaging the opposite end with finger pressure.

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