



APPLICATION SPECIFICATION



LANGUAGE

ENGLISH

【1. Scope】

This assembly procedure specifies the assembling method of undermentioned component parts and cable in CMC WIRE TO WIRE PLUG CONNECTOR 32P.

【2. Product Name and Part Number】

	Description	Part No.	Color
Plug	Housing	501820-3209	Gray
	Secondary Locking	501821-3209	Black
	Alignment Plate	501822-3209	Green
	Rear Seal Cover	501823-3209	Green
	Mat Seal	501824-3209	Blue
	Coil Spring	501825-0009	---
	Wire Dress Cover (Straight)	501826-3201	Black
	Plug Terminal 0.64 0.3-0.5sq	501827-0101	---
	Plug Terminal 1.5 0.85sq	501828-0101	---
	Plug Terminal 1.5 1.25-2sq	501828-0111	---
	Sealing Plug 0.64	64325-1010	White
	Sealing Plug 1.5	64325-1023	Orange

REV.	A															
SHEET	1~19															
REVISE ON PC ONLY						TITLE:										
A						RELEASED JTR2012-0049 2011/12/19 Y.TAMAKI										
						CMC WIRE TO WIRE PLUG CONNECTOR 32P INSTRUCTION										
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	DESIGN CONTROL JTR					STATUS	Y.TAMAKI	H.KOMATSU	MA.YAMAMOTO	2011/12/19						
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【3. Applicable Connector】

Discription	Document Name
Receptacle ASSY	SD-64319-001
Receptacle 0.6 Terminal	SD-64322-001
Receptacle 1.5 Terminal	SD-64323-001

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REV.

DESCRIPTION

TITLE:

**CMC WIRE TO WIRE PLUG CONNECTOR
32P INSTRUCTION**

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DOCUMENT NUMBER

AS-501820-001

FILE NAME

AS501820001.DOC

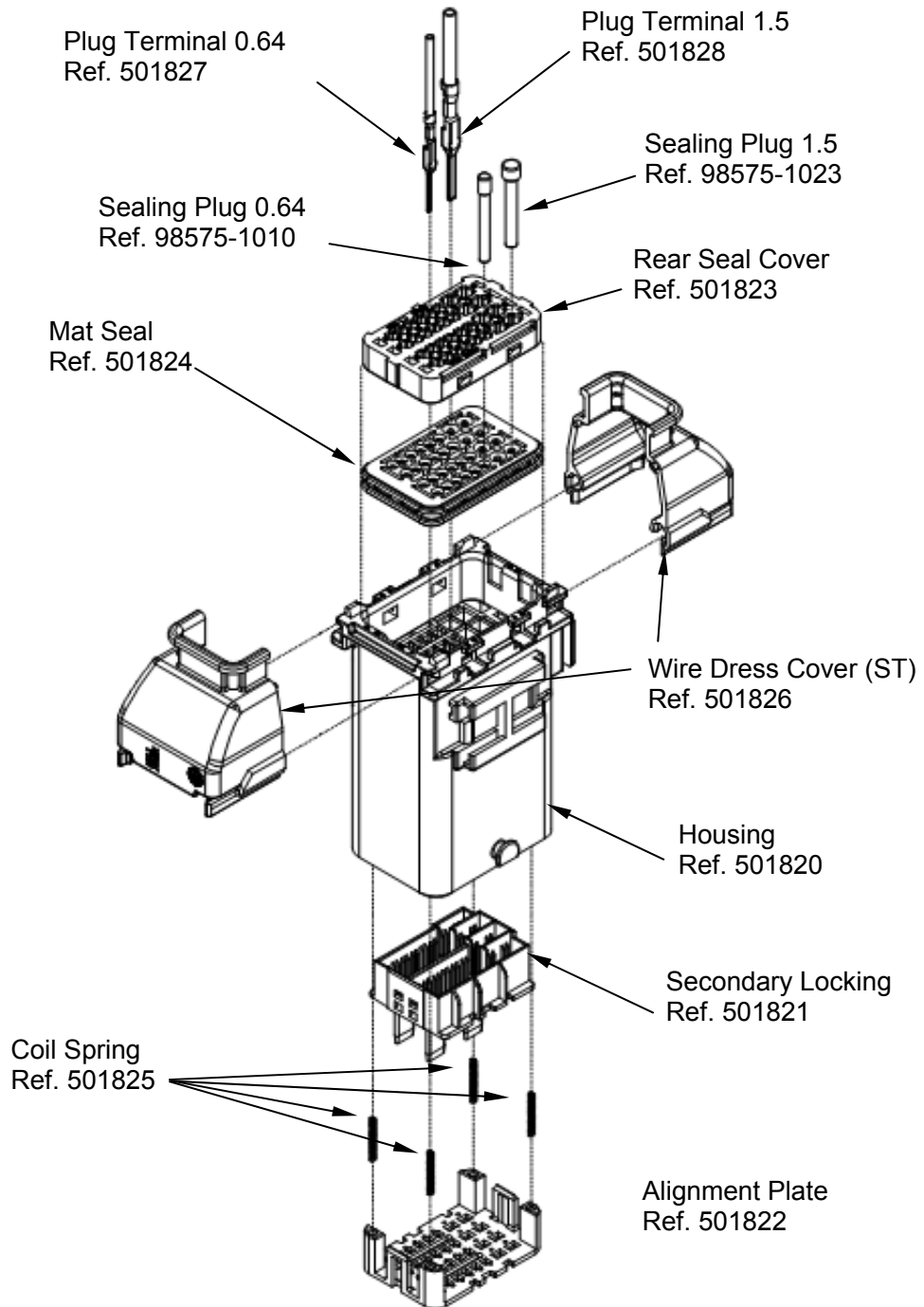
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【4. Component Formation】



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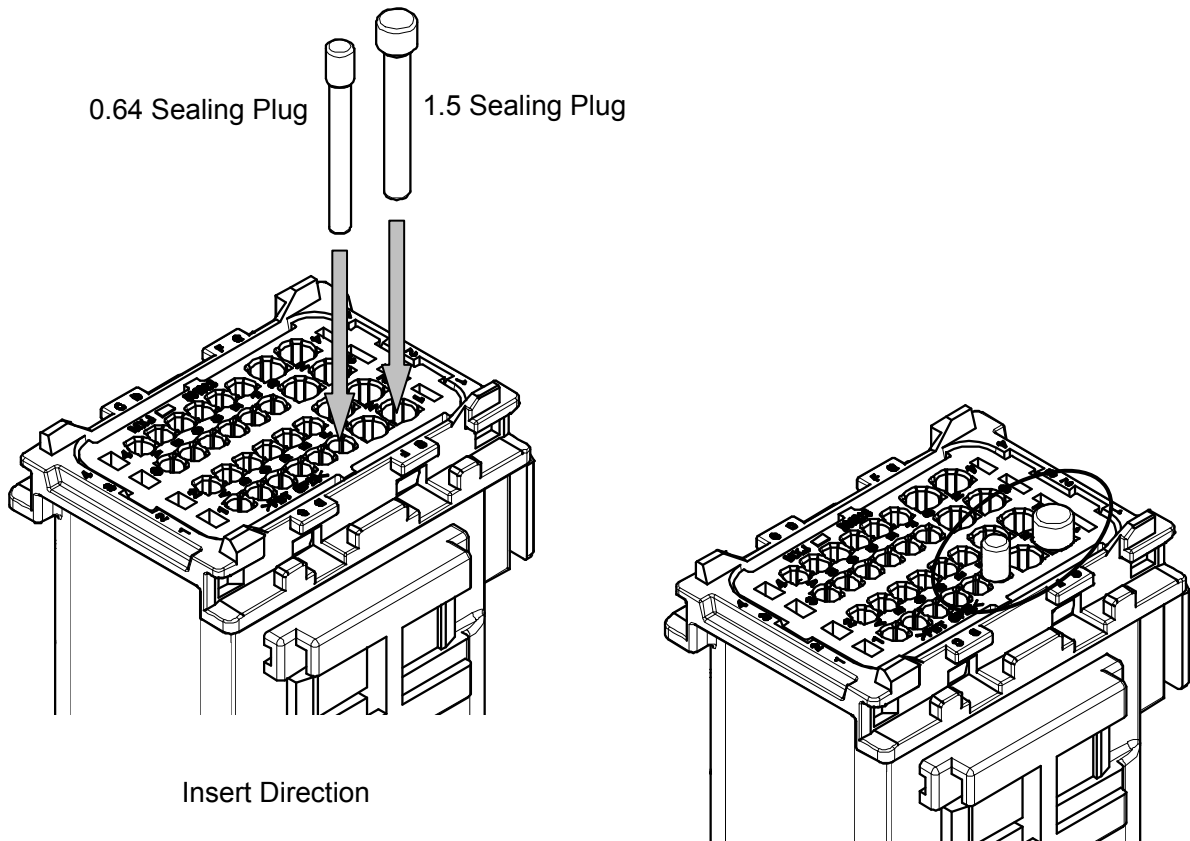
【5. Application】

5.1 Terminal Crimping

Please refer to crimp specification
(CS-501827-001, CS-501828-001)

5.2 Sealing Plug Application

Plug up unused circuit with sealing plug. Push sealing plug into core hole of rear seal cover until it stops.



Insert Direction

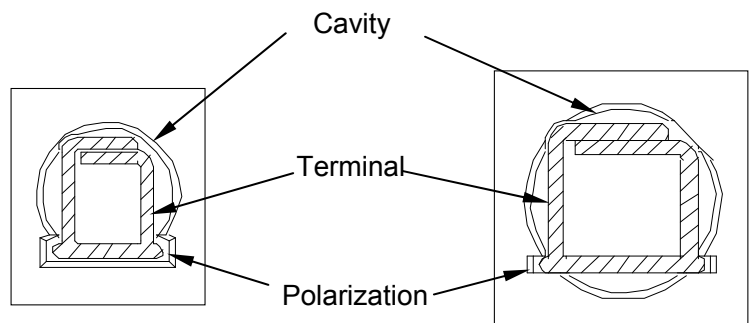
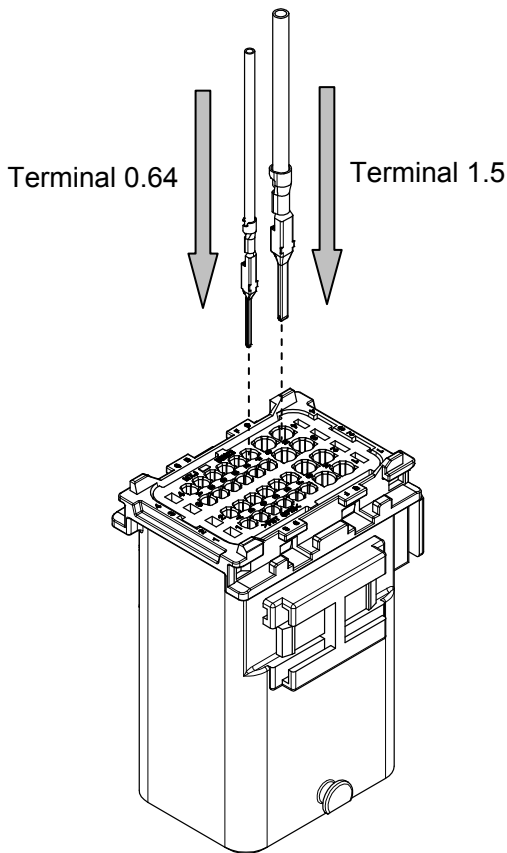
Inserted Position

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5.3 Insert Terminal to Housing Assembly

- (1) Place the plug terminals in front of their respective cavities respecting the polarization and push the wires straightly until primary lock so that the terminal may not rotate.
- (2) Make a push-pull operation to check the primary lock.



Plug Terminal 0.64

Plug Terminal 1.5

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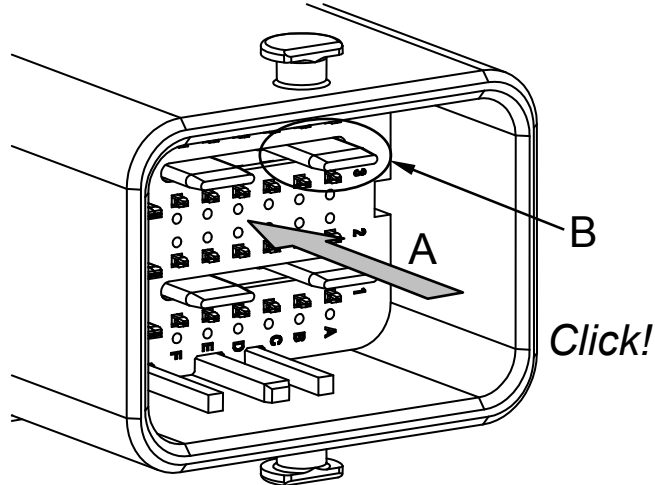


NOTES

- (1) Between the four rows 1,2,3 and 4, the 0.64 terminals are reversed at 180°.
- (2) Directions of 1.5 terminals are all same.
- (3) There needs to be no adhesion of oil to the receptacle terminal and the wires.
- (4) There needs to be no involvement of waste thread at the time of terminal insertion.
- (5) Unpack the products just before their assembly operation.
- (6) Plug terminals can support maximum 2 removals and 3 insertions without sealing damaging

5.4 Locking of Secondary Locking

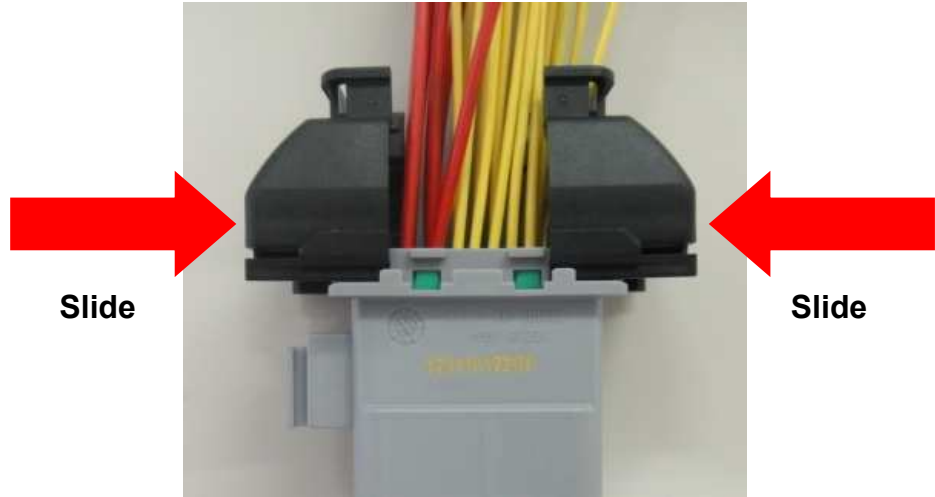
After terminal insertion, push the front face of alignment plate and displace the secondary locking until it clicks. Don't push blades on secondary locking directly.



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5.5 Application of Wire Dress Cover



Bind wires up and slide the wire dress cover until the locking of the two wire dress cover locking latches.

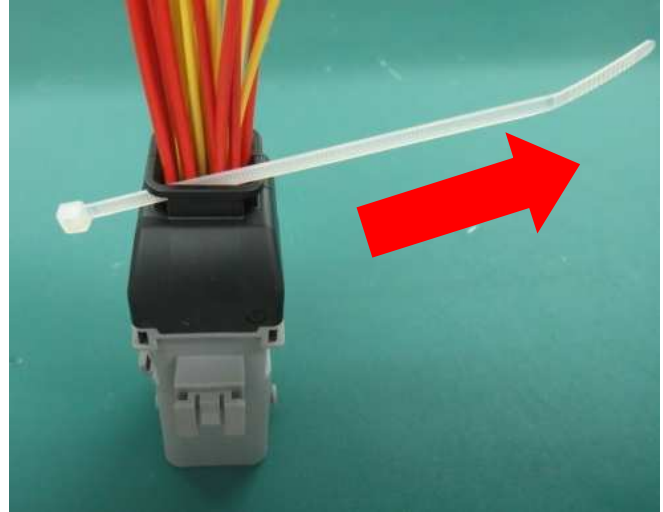


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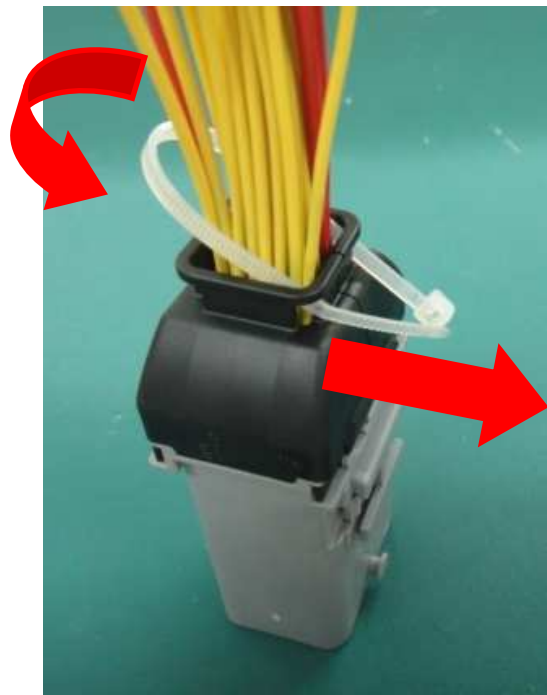


5.6 Application of Tie Wrap

(1) As the picture shown, lace a tie wrap through a hole that is at the opposite side of a lever in a wire dress cover.



(2) Tie up the wires by the tie wrap, after lace the end of tie wrap through another hole.

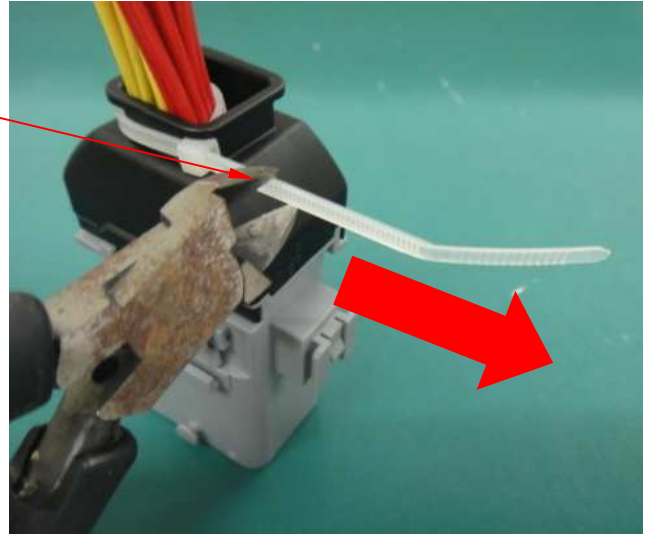


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(3) Tie up the wires at an inside of wire opening and cut off excess of the tie wrap.

Cut



NOTES

- (1) The tie wrap should be assembled by the harness maker according to the available space on the wire dress cover mentioned in this specification.
- (2) The maximum tightening to apply on the tie wrap must be defined in a way to not damage the wire cap and the wires.
- (3) It is mandatory to use the tie wrap on the wire cap.

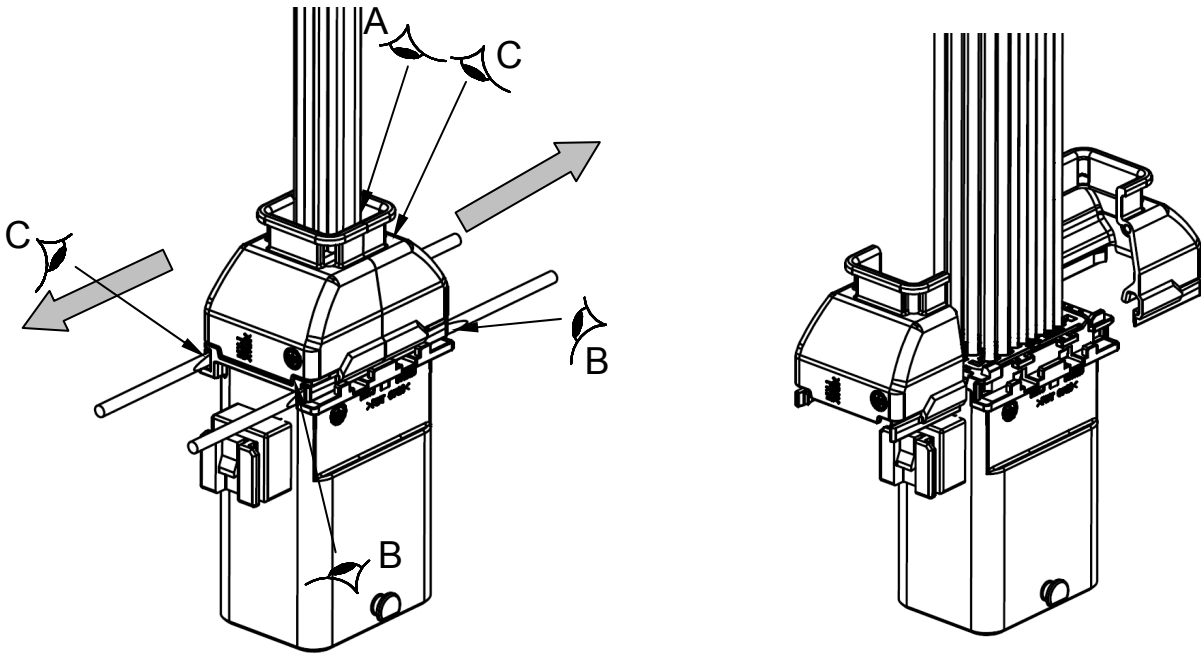
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【6. Rework Operation】

6.1 Removal of Wire Dress Cover

- (1) Cut and remove the tie wrap. (A)
- (2) Open the first locking latch of the cover with a flat-blade screwdriver (recommended dimensions of the tip of 3.0 x 0.6) and push on the wire dress cover in a vertical direction of wires.
- (3) Maintaining the pressure on the wire dress cover, repeat the previous operation on the opposite locking latch.
- (4) Slide and remove the wire dress cover.



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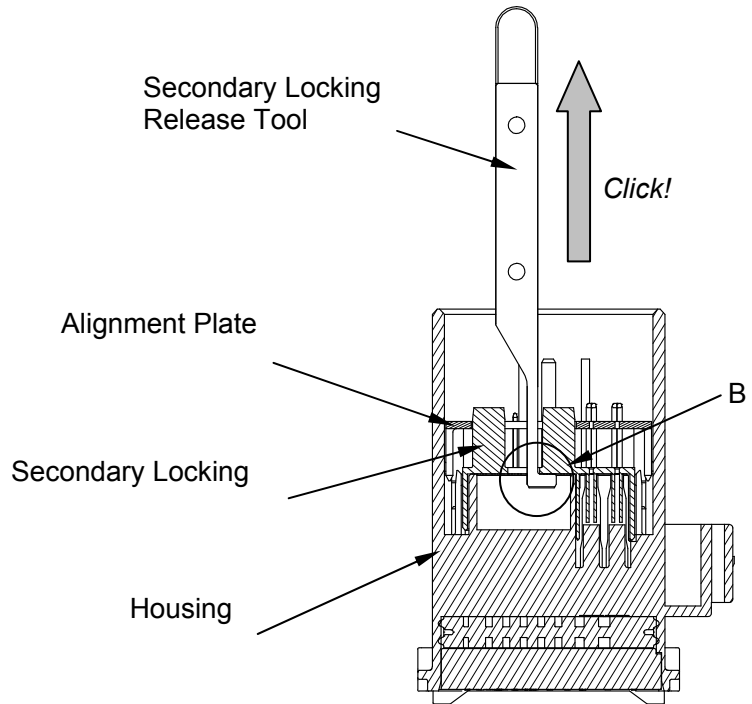
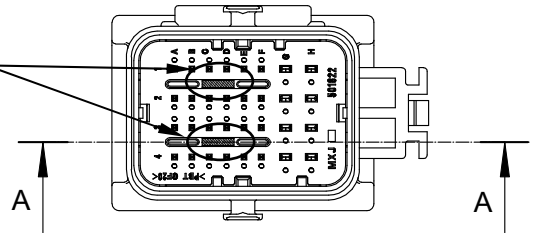


6.2 Unlocking of Secondary Locking

Discription	Product No.
Plug Secondary Locking Release Tool	578032-6100

- (1) Insert jig straightly through the hole which is located on alignment plate.
- (2) Move tip of jig and hook secondary locking and pull it out until it clicks.

Secondary Locking Release Tool Insertion hole



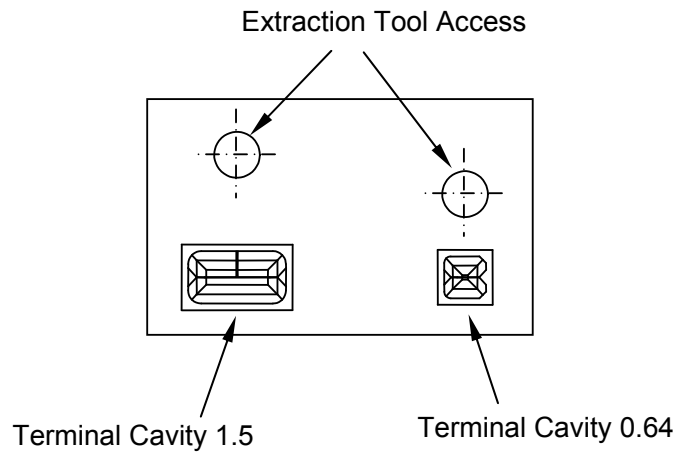
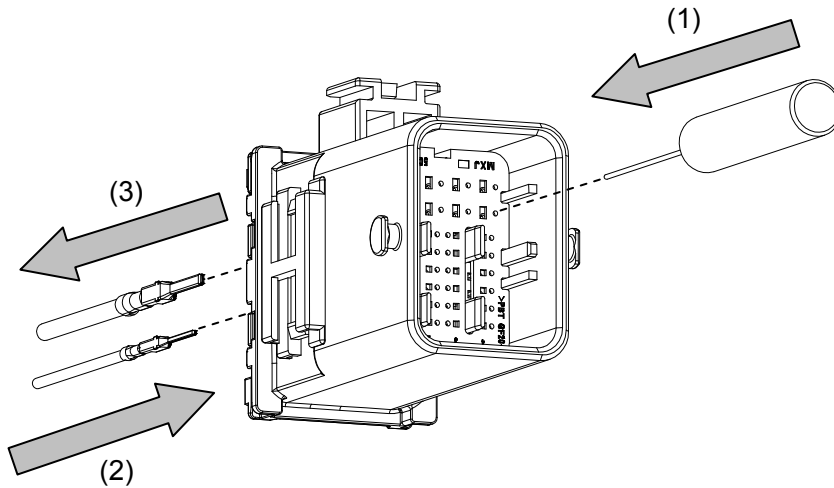
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6.3 Removal of Terminals

- (1) Insert the finger of the tooling slightly.
- (2) Push on the contact wire then on the tool.
- (3) Pull on the wire.



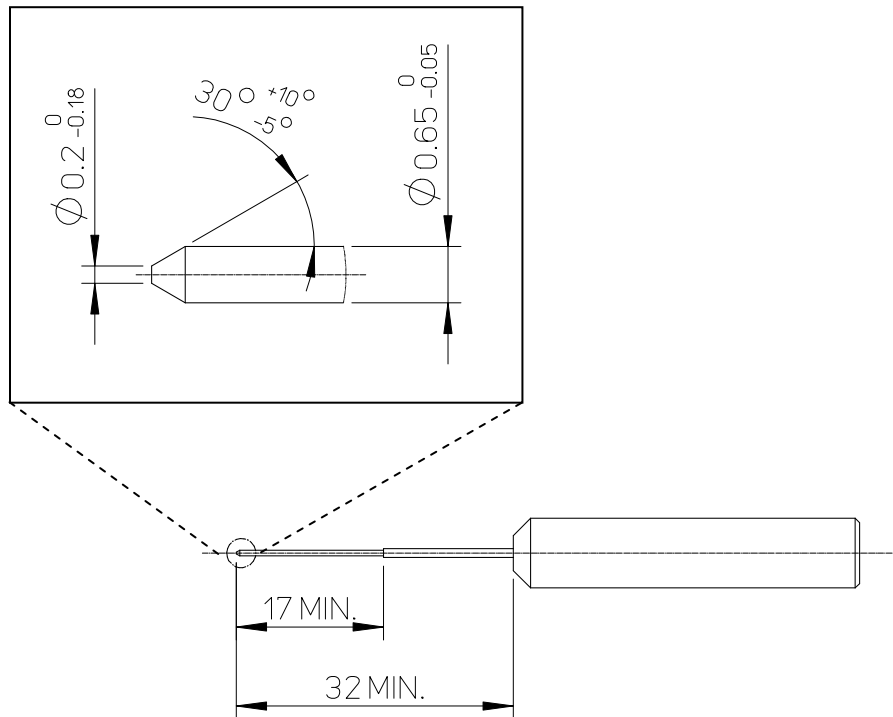
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6.4 Description of Extraction Tool

Description of tool to remove terminal from the plug housing.

Discription	Product No.
Plug Terminal Release Tool	57832-6000

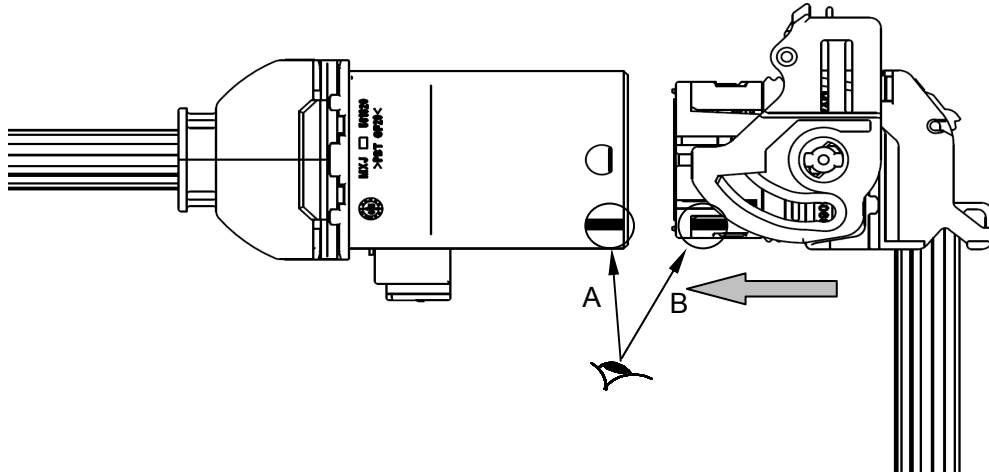


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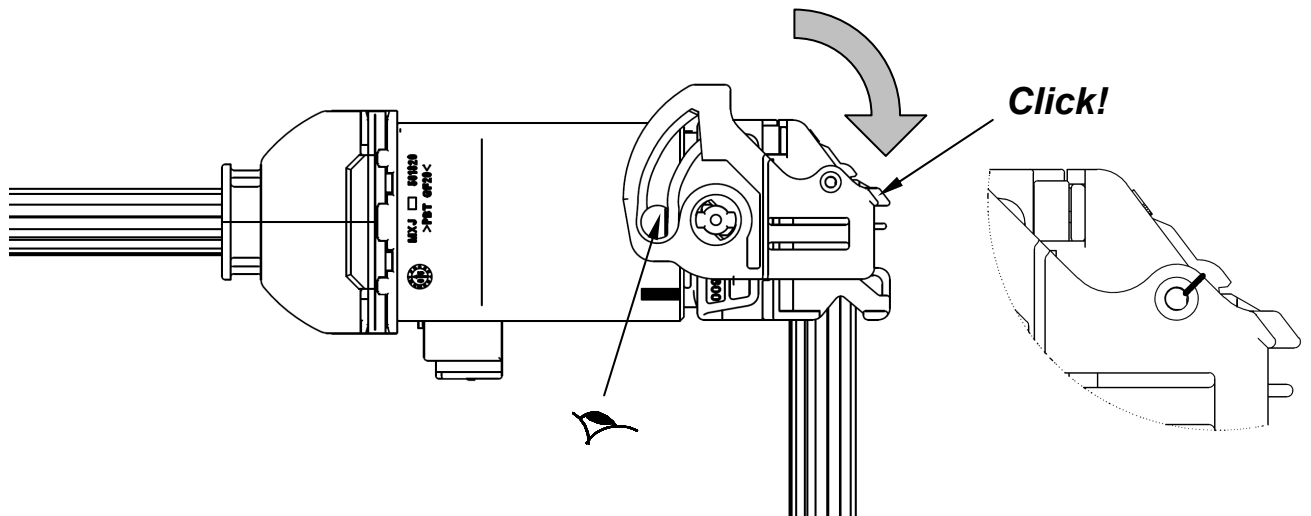


【7. Mating and Unmating Operation】

7.1 Mating Operation



(1) Place the marking position on both housing same.

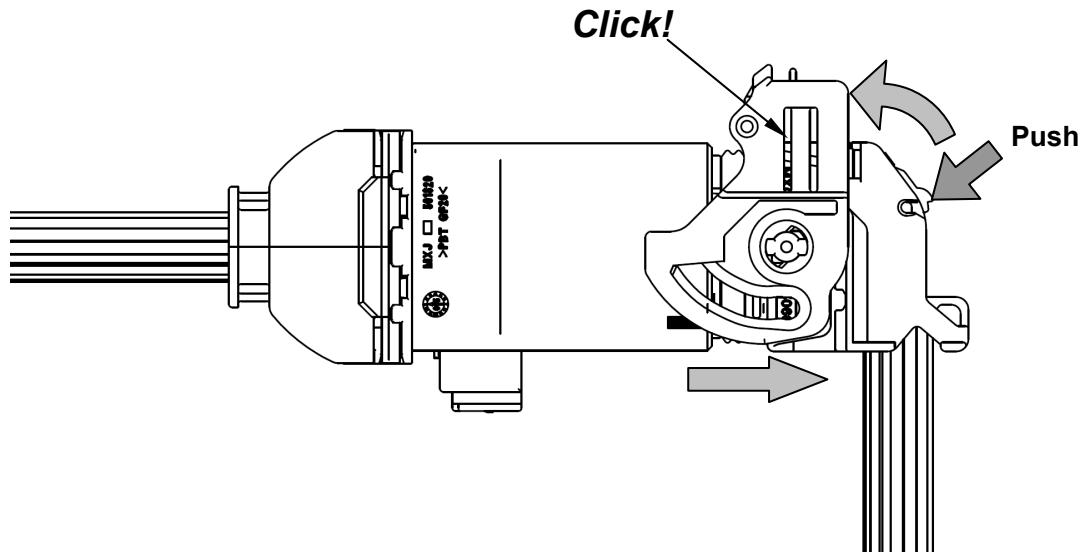


(2) Rotate the lever until it stops and locks on wire dress cover.
If necessary, place and crimp the lead seal wire Dia.1 mm MAX.

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7.2 Unmating Operation



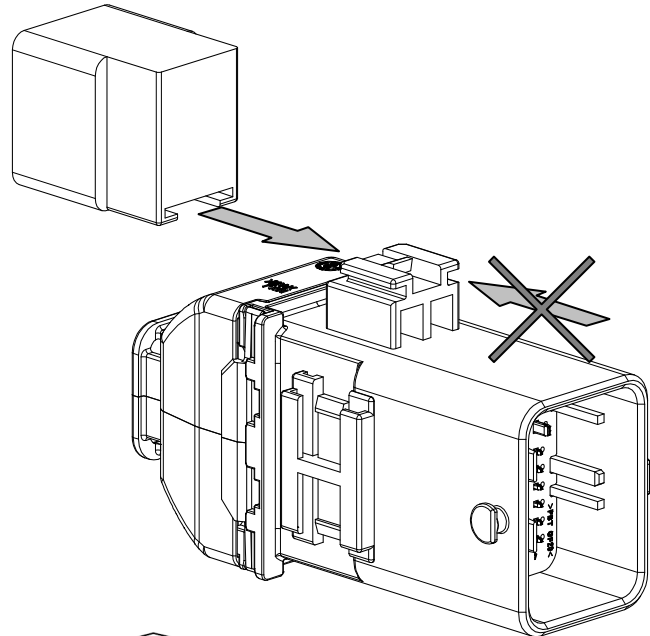
Push and release the lock on wire dress cover by finger and rotate the lever until it locks on housing side.

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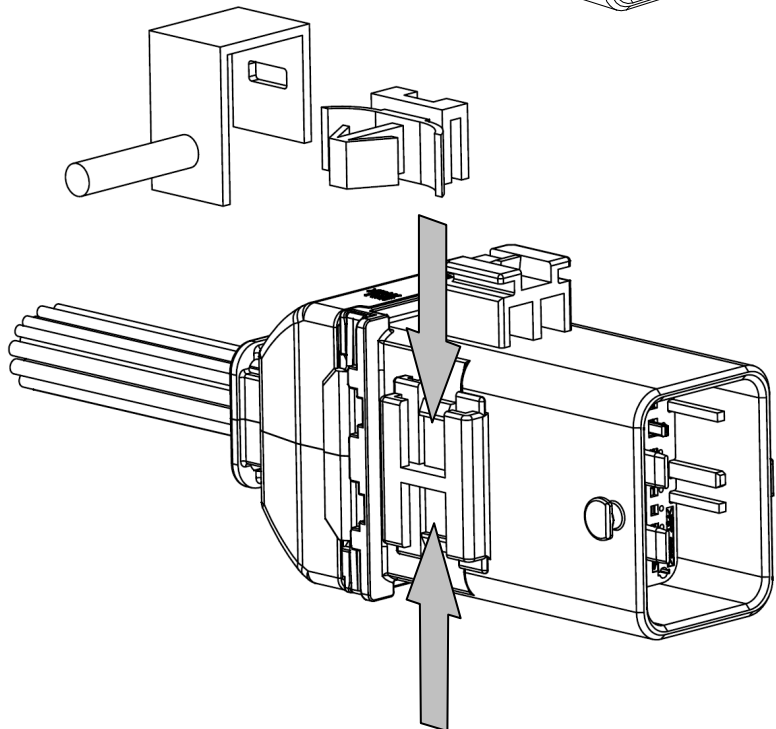


7.3 Mount of External Connector and Bracket

External connector mounting direction



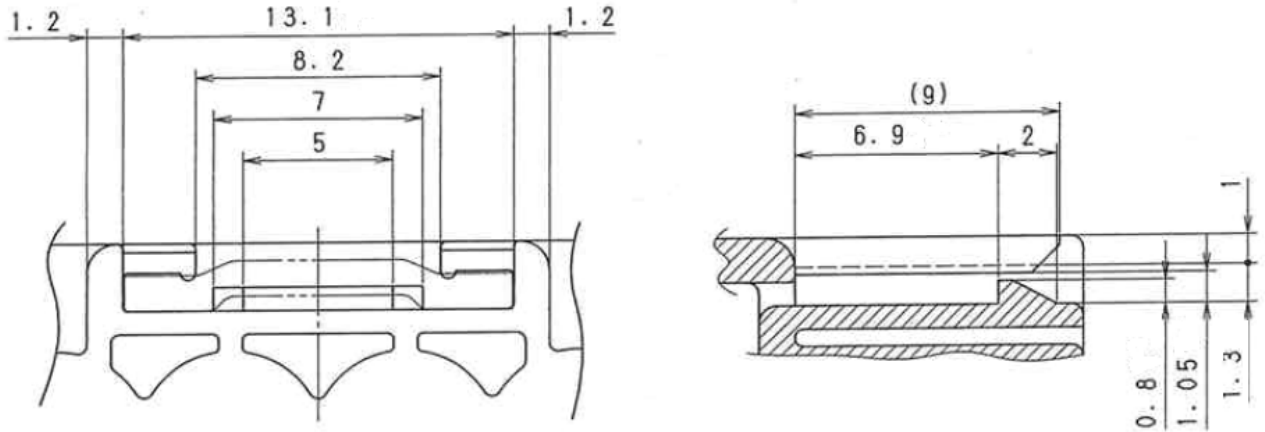
Bracket and Clip mounting direction



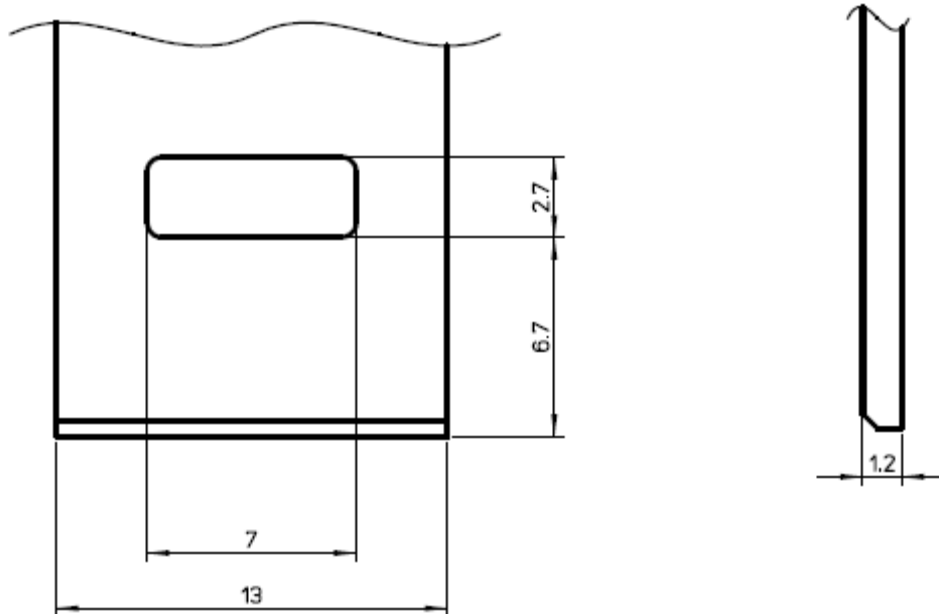
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7.4 Reference recommended dimensions of External Connector mounting part



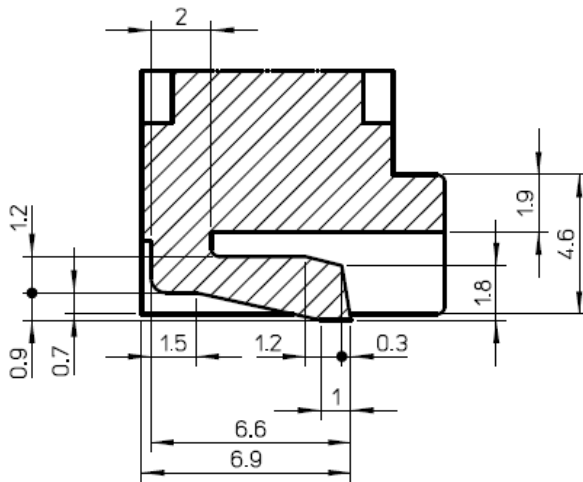
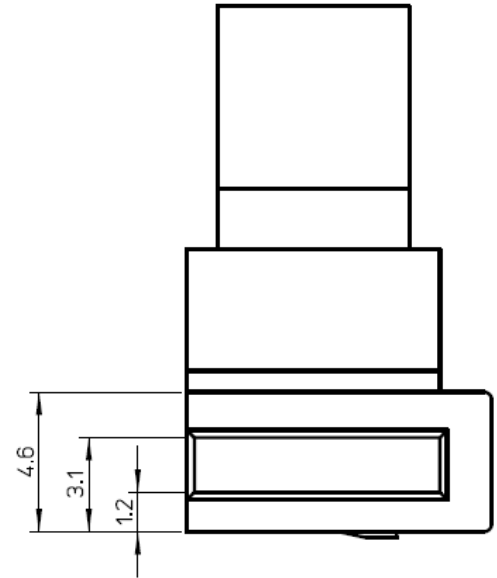
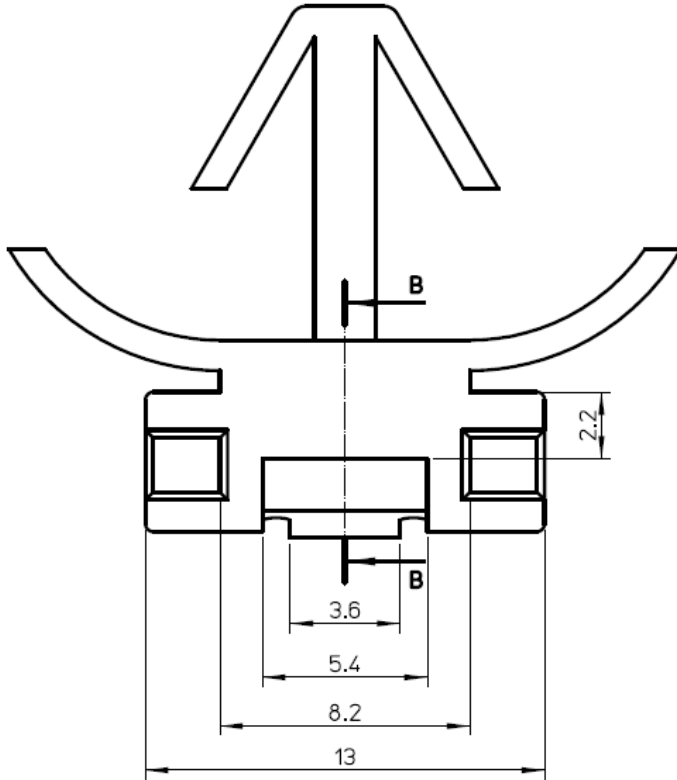
7.5 Reference recommended dimensions of Bracket mounting part



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7.6 Reference recommended dimensions of Clip mounting part



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