



# Delta Connectors

## Assembly Using 3M™ Locator Plate 3443-106N

### Instructions



The 3M Locator Plate 3443-106N is designed to aid in the assembly of the preassembled and two-piece 3M™ Delta Connector and pin 9 through 37 position connectors. End-to-end, as well as daisy chain assemblies, can be made. Set-up and assembly instructions are based on termination procedures with the 3M manual and pneumatic presses.

#### **Locator Plate Includes**

- Instruction sheet
- One mounting screw
- Mounting studs for cable guides

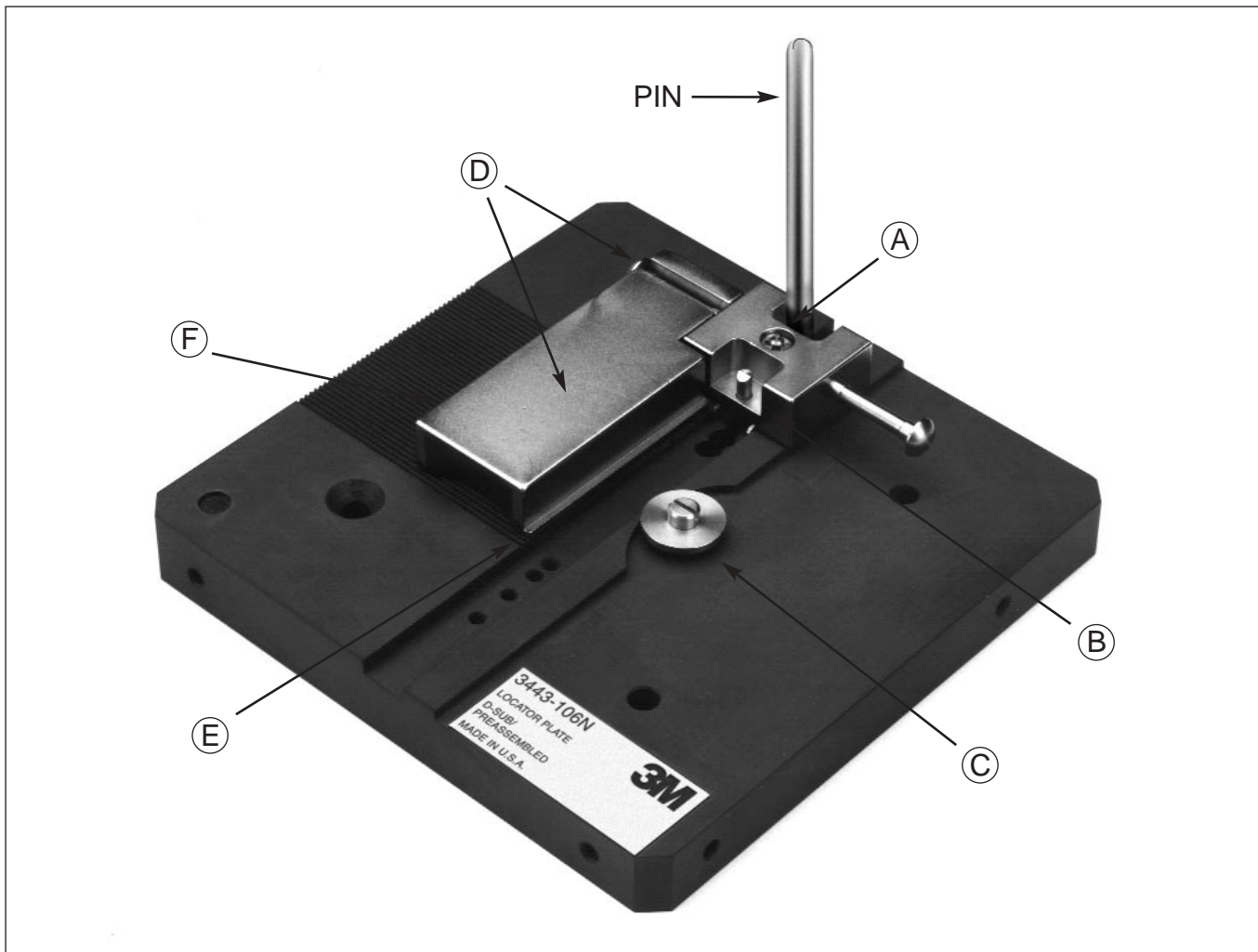
**Note:** *For the one-piece preassembled connector, all locator plate part options are listed on the last page of the assembly instructions.*

## Tool Preparation

### Shut Height Setting

Connector	Assembly Press		
	3640 3316	3335 3339-1	3830
82XX 83XX	21 21	21.5 21.5	Self-Adjusting

Adjust the shut height setting before installing the Locator Plate and Platen using the 3M™ Shut Height Gauge 3436-1.



**Note:** *If the staging platform (optional) is used, please refer to that instruction sheet for mounting instructions.*

## Preassembled Connector Assembly Procedure

### Set-up

1. Adjust the end block according to the flange style and connector size. (A)

**Thru-hole style:** Rotate the end block so that the locating pin is facing the inside of the locator plate. The pin has to be removed so that the end block can be rotated. Then reassemble the pin. The pin is used to guide the platen during harness assembly. (B)

### Floating bushing and threaded insert style:

Rotate the end block so that the locating pin is facing the outside of the locator plate.

2. Install the cable stop insert 3664-B. (C)
3. Install the cable guide on the mounting stud. Refer to the last page for the appropriate guide. (D)
4. Place the locator plate on the press and affix it using the locking screw provided.
5. Place the platen on the assembly press. Refer to the last page for the appropriate platen.

### Assembly

1. Cut required cable length using one of the 3M cutting tools.
2. Remove the connector from the packing strip.
3. Slide the connector onto the guiding groove and into the end block. (E)
4. Slide the cable under the cable guide. If the cable should not enter into the connector smoothly, check the flatness of the cable. (F)
5. Complete the assembly by bringing the press handle to the full downward position.
6. Raise the press handle and cable guide, then remove completed assembly.
7. Visually inspect to insure that:
  - a. The cover is fully seated. If not, check the shut height setting.
  - b. The cable is correctly aligned in the cover. If not, check end guide adjustment.

## Two-Piece Connector Assembly Procedure

### Set-up

1. Follow steps 1, 4 and 5 of the preassembled set-up instructions.

### Assembly

1. Grasp 3M™ Delta Cover Strip between thumb and forefinger. While holding the adjacent cover, pull laterally away from strip leaving the adhesive with a smooth clean edge.
2. Press cable ribs into cover alignment grooves.
3. Visually inspect to insure that the cable is properly aligned and oriented into cover grooves.
4. Engage cable/cover subassembly with connector body. Place subassembly in the locator plate with the connector body facing up.
5. Complete the assembly by bringing the press handle to the full downward position.
6. Raise the press handle and remove the completed assembly.
7. Visually inspect to insure that:
  - a. The cover is fully seated. If not, check the shut height setting.
  - b. The cable is correctly aligned in the cover. If not, check end guide adjustment.

## Standard Two-Piece Connector

The 3M™ Locator Plate 3443-106N and the Platen listed below is all that is needed for the assembly of the standard two-piece connector.

Connector Number	Locator Plate	Platen	Cable Guide	Cable Stop Open Cover	Cable Stop Closed Cover
8209	3443-106N	3442-39N	3664-09	3664-B	N/A
8309	3443-106N	3442-9	3664-09	3664-B	N/A
8215	3443-106N	3442-39N	3664-15	3664-B	N/A
8315	3443-106N	3442-9	3664-15	3664-B	N/A
8225	3443-106N	3442-41N	3664-25	3664-B	N/A
8325	3443-106N	3442-9	3664-25	3664-B	N/A
8237	3443-106N	3442-41N	3664-37	3664-B	N/A
8337	3443-106N	3442-9	3664-37	3664-B	N/A

**Note:** *Replacement studs are available for the cable guides, part number 3664-C. Optional End Block, 3664-A, for connectors with floating bushings and threaded inserts is also available.*

### CAUTION

The 82XX series connector must use the 3M™ 3442-39N Platen. The 3442-39N platen has three blade-like protrusions on the surface of the platen. These blades must fit inside the metal shell of the connector and the connector pins must fit in the grooves between the blades when the platen engages the connector. Make sure that there is good alignment between the connector and the platen to assure that the shell or pins of the connector are not damaged during termination.

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