

3M Instruction Guide: 3M™ Locator Plate 3443-81-XX, 3D-Printed

Instructions for the assembly of 3M™ Ribbon Cable Wiremount Socket Assembly, 451 Series

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1.0 General

1.1 The assembly of 3M Ribbon Cable Wiremount Socket Assemblies, 451 Series, 0.050" x 0.050" sockets and 3M™ Round Conductor Flat Cable 0.025" can be accomplished when using the 3M Locator Plates. 3443-81-XX Series; 3D-Printed Base Plate 3443-81-00; and the 3M™ Assembly Press, 3640 or 3335 Models.

3M™ Connector Part No.	3M™ Locator Plate No.	3M™ Platen part No.	3436-1K Shut Height Setting	
			3M™ Assembly Press 3640 / 3316	3M™ Assembly Press 3335
45104	3443-81-04	3442-9	7	7.5
45106	3443-81-06	3442-9	7	7.5
45108	3443-81-08	3442-9	7	7.5
45110	3443-81-10	3442-9	7	7.5
45112	3443-81-12	3442-9	7	7.5
45114	3443-81-14	3442-9	7	7.5
45116	3443-81-16	3442-9	7	7.5
45120	3443-81-20	3442-9	7	7.5
45126	3443-81-26	3442-9	7	7.5
45130	3443-81-30	3442-9	7	7.5
45134	3443-81-34	3442-9	7	7.5
45140	3443-81-40	3442-9	7	7.5
45150	3443-81-50	3442-9	7	7.5

2.0 Procedures for Set-up

2.1 Adjust the shut height settings. (See Figures 2-4)

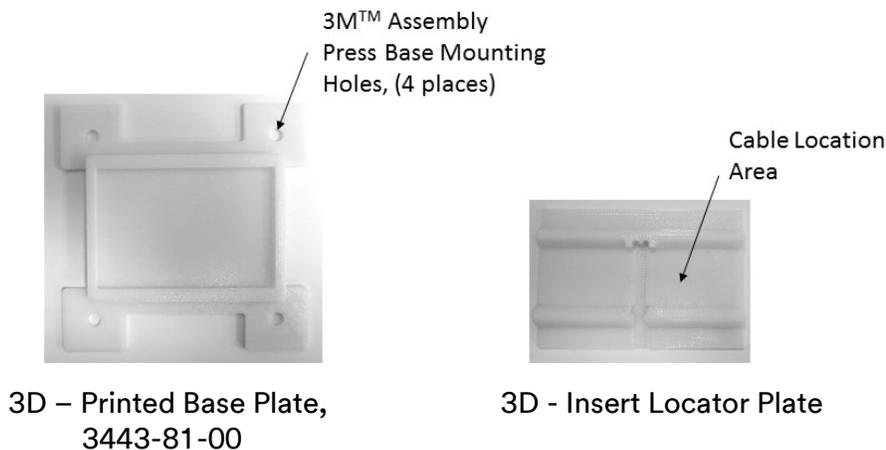


Figure 1
Base Plate and Insert Locator Plate

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3.0 Procedures for Adjusting Shut Height

The Shut height should be adjusted from the base before the locator plate is put into place. The 3M™ Assembly Presses 3316 and 3640 are adjusted with a knob at the top of the press. The 3M™ Assembly Press 3335 is adjusted with the collar on the press shaft, and the 3M™ Assembly Press 3830 is self-adjusting.

- 3.1 The shut height adjustment is made from the base of the assembly press without the locator plate or platen in place.
- 3.2 Lower the handle of the press until the handle casting makes contact with the press casting. (See Figure 2)
- 3.3 Place the shut height gauge across the press base. (See Figure 2)



Figure 2

- 3.4 Rotate the shut height to lower or raise adjustment feature until the bottom of the shaft contacts the desired position on the shut height gauge. (See Figures 3 and 4)



Figure 3



Figure 4

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- 3.5 Install the 3M™ base plate, and appropriate locator plate insert on the press. (See Figure 5) Add platen by positioning it parallel with the connector body and cover. (See Figure 9)



Figure 5

4.0 Procedures for Cable Preparation

Before assembly of the connector can take plate, the cable must be prepared.

- 4.1 Place the cover into the locator plate. (See Figure 6)



Figure 6

- 4.2 Place the properly sized ribbon cable into the cover in the locator plate. (See Figure 7)

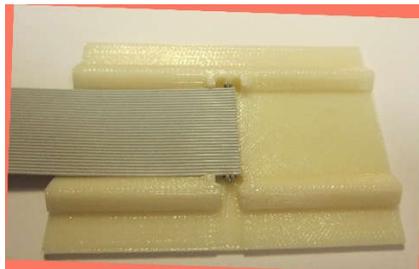


Figure 7

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5.0 Procedures for Cable Termination

After the cable is prepared it is ready for termination.

- 5.1 Place the socket connector onto the cover over the cable, verifying the pin 1 indicator is in the correct position. (See Figure 8)

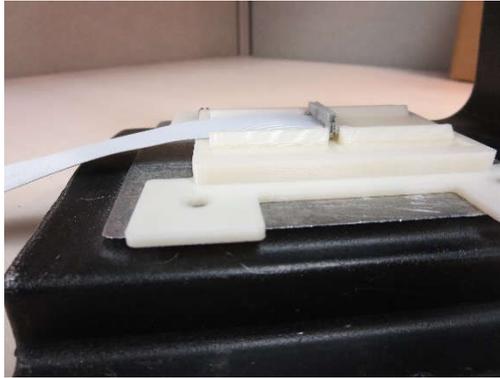


Figure 8

- 5.2 Bring the handle of the press down until the IDC's press into cable and the connector fully seats into the cover. (See figure 9)

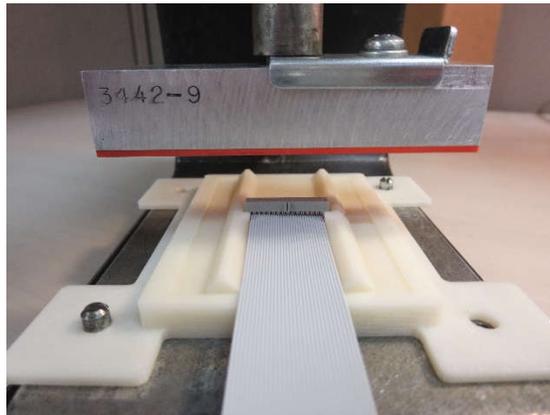


Figure 9

- 5.3 Visually inspect termination to ensure that:
- Cover is fully seated and parallel to the body.
 - Cable is properly aligned with the cover.
 - Cover retaining devices on the body are flush with the cover end.
- (See Figure 10)

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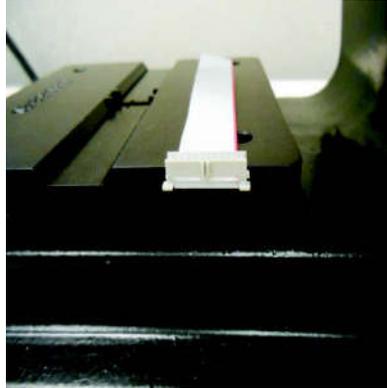


Figure 10
(Metal fixture shown)

6.0 Strain Relief Attachment

6.1 Fold the cable back over the cover. (See Figure 11)

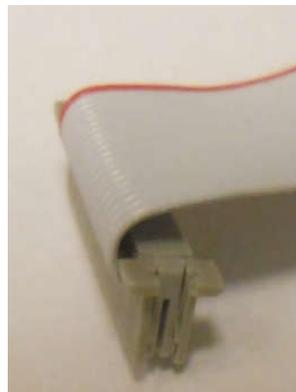


Figure 11

6.2 Place the strain relief in the connector over the cable, sliding the strain relief into the slots of the connector. (See Figure 12)



Figure 12

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- 6.3 Press the strain relief down until the strain relief snaps into the correct position on the connector. (See Figure 13)

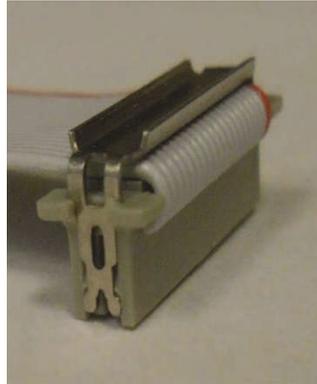


Figure 13

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