

NO OF CKTS	DIM A	DIM B
2	(2.54)	(5.44)
	.100	.214
3	(5.08)	(7.98)
	.200	.314
4	(7.62)	(10.52)
	.300	.414
5	(10.16)	(13.06)
	.400	.514
6	(12.70)	(15.60)
	.500	.614
7	(15.24)	(18.14)
	.600	.714
8	(17.78)	(20.68)
	.700	.814
9	(20.30)	(23.22)
	.800	.914
10	(22.86)	(25.76)
	.900	1.014
11	(25.40)	(28.30)
	1.000	1.114
12	(27.94)	(30.84)
	1.100	1.214
13	(30.48)	(33.38)
	1.200	1.314
14	(33.02)	(35.92)
	1.300	1.414
15	(35.56)	(38.46)
	1.400	1.514
16	(38.10)	(41.00)
	1.500	1.614
17	(40.64)	(43.54)
	1.600	1.714
18	(43.18)	(46.08)
	1.700	1.814
19	(45.72)	(48.62)
	1.800	1.914
20	(48.26)	(51.16)
	1.900	2.014
21	(50.80)	(53.70)
	2.000	2.114
22	(53.34)	(56.24)
	2.100	2.214
23	(55.88)	(58.78)
	2.200	2.314
24	(58.42)	(61.32)
	2.300	2.414
25	(60.96)	(63.86)
	2.400	2.514
26	(63.50)	(66.40)
	2.500	2.614
27	(66.04)	(68.94)
	2.600	2.714
28	(68.58)	(71.48)
	2.700	2.814

NOTES:

- MATERIAL: UNFILLED NYLON UL94V-2, MOLDED NATURAL (WHITE)
- FINISH:
 - (102) OVERALL TIN: (0.00508)/.000200 MIN. OVER COPPER: (0.00254)/.000100 MIN.
 - (208) SELECT GOLD: (0.00038)/.000015 MIN., *SELECT TIN: (0.00254)/.000100 MIN., OVERALL NICKEL UNDERPLATE: (0.00127)/.000050 MIN.
 - (228) SELECT GOLD: (0.00076)/.000030 MIN., *SELECT TIN: (0.00254)/.000100 MIN., OVERALL NICKEL UNDERPLATE: (0.00127)/.000050 MIN.
- * THE PRIMARY SHIPPING CARTON WILL BE LABELED "COMPLIANT TO RoHS DIRECTIVE 2002/95/EC AND ELV ANNEX II OF DIRECTIVE 2000/53/EC". CARTONS WITHOUT THIS LABEL MAY CONTAIN PRODUCT WITH TIN/LEAD PLATINGS.
- PRODUCT SPECIFICATION: PS-7720-001
- PACKAGING: ALL PARTS ARE TO BE BULK PACKED PER PK-40555-001 UNLESS OTHERWISE SPECIFIED IN CHART.
- FOR USE WITH (0.64)/.025 SQUARE OR ROUND PINS. INSERTION DEPTH OF (6.10/7.87)/.240/.310
- WIRE SPECIFICATIONS:
 - TERMINAL OPTION -F(***) FOR USE WITH: 24 AWG TOPCOATED WITH INSULATION DIAMETER OF (1.47)/.058
 - TERMINAL OPTION -H(***) FOR USE WITH: 24 AWG TOPCOATED WITH INSULATION DIAMETER OF (1.47)/.058
 - 24 AWG SOLID WITH INSULATION DIAMETER OF (1.47)/.058
 - 24 AWG STRANDED WITH INSULATION DIAMETER OF (1.47)/.058
 - 26 AWG TOPCOATED WITH INSULATION DIAMETER OF (1.47)/.058
- COLOR STRIPE TO RUN LENGTH OF RIB AS SHOWN.
- WIRE TERMINATION SPECIFICATION: SMES-7720-0002

A-40555- * N * *
 HOUSING OPTIONS
 BLANK=40555-N
 A=40555-AN
 B=40555-BN
 NO. OF CKTS





TERMINAL OPTIONS
 F=40554-F(102)
 H=40627-H(102)
 HA=40921-H(102)
 HB=40554-H(102)
 FA=40554-F(P909)
 HE=40554-H(P909)
 HF=41138-H(213)
 A=7691-A(102)
 HG=41138-H(209)
 HK=41138-H(P909)

REV.	DESCRIPTION	DATE
8	BQ2	
7	BO	
6	BQ	
5	BQ	
4	BK1	
3	BQ	
2	BK1	
1	BK1	
SH.	REV.	

UPDATE PER ECN
 ECN NO: UCP2005-2874
 2005/07/08
 DRAWN: ADERR
 2005/07/13
 CHKD: SSOUSEK
 APPR: FSN TH
 2005/07/15

QUALITY SYMBOLS 	GENERAL TOLERANCES (UNLESS SPECIFIED)	DIMENSION STYLE MM/IN	SCALE ---	DESIGN UNITS INCH	THIRD ANGLE PROJECTION
	4 PLACES ± --- ± --- 3 PLACES ± --- ± --- 2 PLACES ± --- ± --- 1 PLACE ± --- ± ---	DRAWN BY R/JG DATE 1985/09/16	CHECKED BY EDGLEY DATE 1985/09/16	APPROVED BY LENZ DATE 1985/09/16	TITLE INSULATION DISPLACEMENT CONNECTOR ASSEMBLY (2.54)/.100 CENTERS
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		MATERIAL NO. SEE CHART		DOCUMENT NO. SDA-40555-*N*	
THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION		SHEET NO. 1 OF 8			

	13	12	11	10	9	8	7	6	5	4	3	2	1	
	ENG. NO.	HOUSING NO	TERMINAL NO.	COLOR ID	EDP ON SHT./COL.			ENG. NO.	HOUSING NO	TERMINAL NO.	COLOR ID	EDP ON SHT./COL.		
J	A-40555-NHB	40555-N	40554-H(102)	GREEN	3 / 1							/		J
	A-40555-ANHB	40555-AN	40554-H(102)	GREEN	3 / 2							/		
	A-40555-BNHB	40555-BN	40554-H(102)	GREEN	3 / 3							/		
					/							/		
					/							/		
I	A-40555-NHE	40555-N	40554-H(P909)	GREEN	3 / 7							/		I
	A-40555-ANHE	40555-AN	40554-H(P909)	GREEN	3 / 8							/		
	A-40555-BNHE	40555-BN	40554-H(P909)	GREEN	3 / 9							/		
					/							/		
					/							/		
H					/							/		H
					/							/		
					/							/		
					/							/		
G					/							/		G
					/							/		
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F					/							/		F
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B					/							/		B
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					/							/		
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A					/							/		A

UPDATE PER ECN ECN NO: UCP2005-2874 DRAWN ADERR 2005/07/08 CHKD:SSOUSEK 2005/07/13 APPR:FSM TH 2005/07/15 BK1	QUALITY SYMBOLS  =0  =0	GENERAL TOLERANCES (UNLESS SPECIFIED) <table border="1"> <tr> <th></th> <th>mm</th> <th>INCH</th> </tr> <tr> <td>4 PLACES</td> <td>± .004</td> <td>± .00015</td> </tr> <tr> <td>3 PLACES</td> <td>± .005</td> <td>± .00020</td> </tr> <tr> <td>2 PLACES</td> <td>± .008</td> <td>± .00030</td> </tr> <tr> <td>1 PLACE</td> <td>± .010</td> <td>± .00040</td> </tr> </table>			mm	INCH	4 PLACES	± .004	± .00015	3 PLACES	± .005	± .00020	2 PLACES	± .008	± .00030	1 PLACE	± .010	± .00040	DIMENSION STYLE MM/IN	SCALE ---	DESIGN UNITS INCH	 THIRD ANGLE PROJECTION
			mm	INCH																		
		4 PLACES	± .004	± .00015																		
		3 PLACES	± .005	± .00020																		
2 PLACES	± .008	± .00030																				
1 PLACE	± .010	± .00040																				
DRAWN BY DATE SAMIEC 1991/10/28		CHECKED BY DATE EDGLEY 1991/10/28		TITLE INSULATION DISPLACEMENT CONNECTOR ASSEMBLY .100 CENTERS																		
APPROVED BY DATE LENZ 1991/10/28		MATERIAL NO. SEE CHART		DOCUMENT NO. SDA-40555-*N*																		
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		SIZE 		SHEET NO. 2 OF 8																		

	13	12	11	10	9	8	7	6	5	4	3	2	1	
	A-40555-NHB		A-40555-ANHB		A-40555-BNHB									
J	PART NO.	ENG. NO.	PART NO.	ENG. NO.	PART NO.	ENG. NO.	PART NO.	ENG. NO.	PART NO.	ENG. NO.	PART NO.	ENG. NO.	PART NO.	ENG. NO.
		A-40555-2HB		A-40555-A2HB	22-41-8024	A-40555-B2HB								
		A-40555-3HB		A-40555-A3HB	22-41-8034	A-40555-B3HB								
		A-40555-4HB		A-40555-A4HB	22-41-8044	A-40555-B4HB								
		A-40555-5HB		A-40555-A5HB	22-41-8054	A-40555-B5HB								
		A-40555-6HB		A-40555-A6HB	22-41-8064	A-40555-B6HB								
I		A-40555-7HB		A-40555-A7HB	22-41-8074	A-40555-B7HB								
		A-40555-8HB		A-40555-A8HB	22-41-8084	A-40555-B8HB								
		A-40555-9HB		A-40555-A9HB	22-41-8094	A-40555-B9HB								
		A-40555-10HB		A-40555-A10HB	22-41-8104	A-40555-B10HB								
		A-40555-11HB		A-40555-A11HB		A-40555-B11HB								
		A-40555-12HB		A-40555-A12HB	22-41-8124	A-40555-B12HB								
		A-40555-13HB		A-40555-A13HB		A-40555-B13HB								
		A-40555-14HB		A-40555-A14HB		A-40555-B14HB								
H		A-40555-15HB		A-40555-A15HB		A-40555-B15HB								
		A-40555-16HB		A-40555-A16HB	22-41-8164	A-40555-B16HB								
		A-40555-17HB		A-40555-A17HB		A-40555-B17HB								
		A-40555-18HB		A-40555-A18HB	22-41-8184	A-40555-B18HB								
		A-40555-19HB		A-40555-A19HB		A-40555-B19HB								
		A-40555-20HB		A-40555-A20HB		A-40555-B20HB								
G		A-40555-21HB		A-40555-A21HB		A-40555-B21HB								
		A-40555-22HB		A-40555-A22HB		A-40555-B22HB								
		A-40555-23HB		A-40555-A23HB		A-40555-B23HB								
		A-40555-24HB		A-40555-A24HB		A-40555-B24HB								
		A-40555-25HB		A-40555-A25HB		A-40555-B25HB								
		A-40555-26HB		A-40555-A26HB		A-40555-B26HB								
		A-40555-27HB		A-40555-A27HB		A-40555-B27HB								
F		A-40555-28HB		A-40555-A28HB		A-40555-B28HB								

	13	12	11	10	9	8	7	6	5	4	3	2	1	
	A-40555-NHE		A-40555-ANHE		A-40555-BNHE									
E	PART NO.	ENG. NO.	PART NO.	ENG. NO.	PART NO.	ENG. NO.								
	22-41-9022	A-40555-2HE	22-41-9025	A-40555-A2HE	22-41-9028	A-40555-B2HE								
	22-41-9032	A-40555-3HE	22-41-9035	A-40555-A3HE	22-41-9038	A-40555-B3HE								
	22-41-9042	A-40555-4HE	22-41-9045	A-40555-A4HE	22-41-9048	A-40555-B4HE								
	22-41-9052	A-40555-5HE	22-41-9055	A-40555-A5HE	22-41-9058	A-40555-B5HE								
	22-41-9062	A-40555-6HE	22-41-9065	A-40555-A6HE	22-41-9068	A-40555-B6HE								
D	22-41-9072	A-40555-7HE	22-41-9075	A-40555-A7HE	22-41-9078	A-40555-B7HE								
	22-41-9082	A-40555-8HE	22-41-9085	A-40555-A8HE	22-41-9088	A-40555-B8HE								
	22-41-9092	A-40555-9HE	22-41-9095	A-40555-A9HE	22-41-9098	A-40555-B9HE								
	22-41-9102	A-40555-10HE	22-41-9105	A-40555-A10HE	22-41-9108	A-40555-B10HE								
	22-41-9112	A-40555-11HE	22-41-9115	A-40555-A11HE	22-41-9118	A-40555-B11HE								
	22-41-9122	A-40555-12HE	22-41-9125	A-40555-A12HE	22-41-9128	A-40555-B12HE								
	22-41-9132	A-40555-13HE	22-41-9135	A-40555-A13HE	22-41-9138	A-40555-B13HE								
C	22-41-9142	A-40555-14HE	22-41-9145	A-40555-A14HE	22-41-9148	A-40555-B14HE								
	22-41-9152	A-40555-15HE	22-41-9155	A-40555-A15HE	22-41-9158	A-40555-B15HE								
	22-41-9162	A-40555-16HE	22-41-9165	A-40555-A16HE	22-41-9168	A-40555-B16HE								
	22-41-9172	A-40555-17HE	22-41-9175	A-40555-A17HE	22-41-9178	A-40555-B17HE								
	22-41-9182	A-40555-18HE	22-41-9185	A-40555-A18HE	22-41-9188	A-40555-B18HE								
	22-41-9192	A-40555-19HE	22-41-9195	A-40555-A19HE	22-41-9198	A-40555-B19HE								
	22-41-9202	A-40555-20HE	22-41-9205	A-40555-A20HE	22-41-9208	A-40555-B20HE								
B	22-41-9212	A-40555-21HE	22-41-9215	A-40555-A21HE	22-41-9218	A-40555-B21HE								
	22-41-9222	A-40555-22HE	22-41-9225	A-40555-A22HE	22-41-9228	A-40555-B22HE								
	22-41-9232	A-40555-23HE	22-41-9235	A-40555-A23HE	22-41-9238	A-40555-B23HE								
	22-41-9242	A-40555-24HE	22-41-9245	A-40555-A24HE	22-41-9248	A-40555-B24HE								
	22-41-9252	A-40555-25HE	22-41-9255	A-40555-A25HE	22-41-9258	A-40555-B25HE								
	22-41-9262	A-40555-26HE	22-41-9265	A-40555-A26HE	22-41-9268	A-40555-B26HE								
	22-41-9272	A-40555-27HE	22-41-9275	A-40555-A27HE	22-41-9278	A-40555-B27HE								
A	22-41-9282	A-40555-28HE	22-41-9285	A-40555-A28HE	22-41-9288	A-40555-B28HE								

UPDATE TITLE BLOCK
 EC NO: UCP2005-2874
 DRAWN/ADDER 2005/07/08
 CHKD:SSOUSEK 2005/07/13
 APPR:FSM TH 2005/07/15
 DESCRIPTION
 REV

QUALITY SYMBOLS
 ▽=0
 ▽=0
 GENERAL TOLERANCES (UNLESS SPECIFIED)
 mm INCH
 4 PLACES ± --- ± ---
 3 PLACES ± --- ± ---
 2 PLACES ± --- ± ---
 1 PLACE ± --- ± ---
 ANGULAR ±1/2°
 DRAFT WHERE APPLICABLE
 MUST REMAIN WITHIN DIMENSIONS

DIMENSION STYLE
 MM/IN
 DRAWN BY DATE
 SAMIEC 1991/10/28
 CHECKED BY DATE
 EDGLEY 1991/10/28
 APPROVED BY DATE
 LENZ 1991/10/28
 MATERIAL NO.
 SEE CHART
 THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION

SCALE ---
 DESIGN UNITS INCH
 THIRD ANGLE PROJECTION
 INSULATION DISPLACEMENT CONNECTOR ASSEMBLY .100 CENTERS
 MOLEX MOLEX INCORPORATED
 DOCUMENT NO. SDA-40555-*N*
 SHEET NO. 3 OF 8

ENGINEERING SPECIFICATION

ENGLISH



WIRE TERMINATION SPECIFICATION

1.0 SCOPE:
THIS SPECIFICATION IS DESIGNED TO INSURE THE PROPER PERFORMANCE OF THE 7720 AND THE 40555 SERIES I.D.T. CONNECTOR SYSTEMS.

2.0 APPLICABLE DRAWINGS:
PRODUCTS CONFORMING TO THIS SPECIFICATION ARE NOTED ON THE INDIVIDUAL SALES DRAWINGS.

3.0 CONDUCTOR REQUIREMENTS:

3.1 CONDUCTOR:

- 28-24 AWG SOLID TINNED COPPER WIRE
- 28-22 AWG (7 STRAND) CONCENTRIC STRANDED TINNED COPPER WIRE
- 28-24 AWG (7 STRAND) CONCENTRIC STRANDED TOPCOATED OR FUSED COPPER WIRE

3.2 INSULATION:

- DISCRETE WIRE:
UL STYLE 1007 OR 1061 WITH PCV INSULATION. INSULATION DIA. OF (1.52)/.060 MAX. WHEN TERMINATING WIRES ONE POSITION AT A TIME, OR (1.27)/.050 DIA. MAX. WHEN MASS TERMINATING.
- MOLEX CABLE:
UL STYLE 2651 (STRANDED WIRE MUST HAVE 7 STRANDS) ON (2.54)/.100 CENTERS. MOLEX CABLE NUMBERS 24241, 7767, 8997, 7234, 7307, 24226, 7560, 8996
SEE FIGURES 1 AND 2 FOR CABLE PREPARATION.

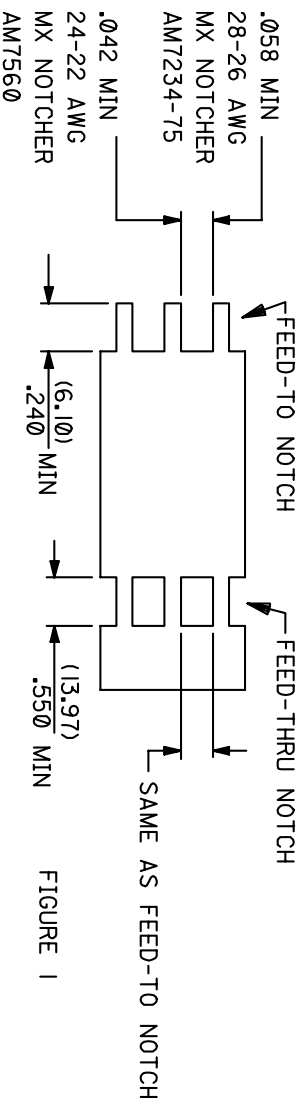
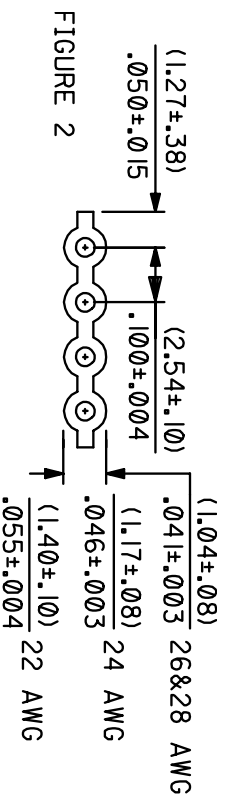


FIGURE 1

SHT	1	2	3	4	5	6													
REVISE ON PC ONLY							TITLE												
D							WIRE TERMINATION SPECIFICATION												
UPDATE EC U50393 9-9-96 SAMIEC							THIS DOCUMENT CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION												
REV	DESCRIPTION						WRITTEN BY:	CHECKED BY:	APPROVED BY:	DATE: YR / MO / DAY									
DESIGN CONTROL	STATUS						SAMIEC	R EDGLEY	B LENZ	96 /02/08									
LISLE	M																		

DOCUMENT NO.	SMES-7720-0002	FILE	77200002	SHT NO.	1 OF 6
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4.0 CONDUCTOR REQUIREMENTS: SEE FIGURE 3

4.1 CONDUCTOR SIZE IDENTIFICATION:

- TERMINALS STAMPED WITH THE LETTER "A" ACCEPT MOLEX CABLE NO.'S.
- 7234- 26 AWG SOLID TINNED COPPER 24241- 26 AWG STRANDED TINNED COPPER
- 7307- 28 AWG STRANDED TINNED COPPER 7767- 28 AWG STRANDED TOPCOAT COPPER

TERMINALS STAMPED WITH THE LETTER "A" ACCEPT WIRE THAT MEETS REQUIREMENTS IN SECTION 3.0

- 28 AWG STRANDED TINNED COPPER 28 AWG SOLID TINNED COPPER
- 28 AWG STRANDED TOPCOATED COPPER 26 AWG STRANDED TINNED COPPER
- 26 AWG SOLID TINNED COPPER

TERMINALS STAMPED WITH THE LETTER "H" ACCEPT MOLEX CABLE NO.'S..

- 8996- 26 AWG STRANDED TOPCOATED COPPER
- 8997- 24 AWG STRANDED TOPCOATED COPPER
- 24226- 24 AWG STRANDED TINNED COPPER

TERMINALS STAMPED WITH THE LETTER "H" ACCEPT WIRE THAT MEETS REQUIREMENTS IN SECTION 3.0

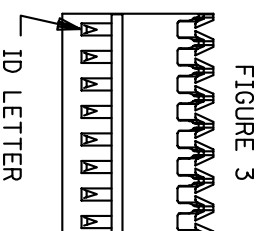
- 24 AWG SOLID TINNED COPPER 26 AWG STRANDED TOPCOATED COPPER
- 24 AWG STRANDED TINNED COPPER 24 AWG STRANDED TOPCOATED COPPER

TERMINALS STAMPED WITH THE LETTER "F" ACCEPT MOLEX CABLE NO.'S.

7560- 22 AWG STRANDED TINNED COPPER

TERMINALS STAMPED WITH THE LETTER "F" ACCEPT WIRE THAT MEETS REQUIREMENTS IN SECTION 3.0 WHEN USED IN ASSEMBLY A-7720-W*

22 AWG STRANDED TINNED COPPER



D	SEE SHEET 1
REV	DESCRIPTION

THIS DOCUMENT CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION

DOCUMENT NO.	SMS-7720-0002	FILE NAME	SHEET
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5.0 MOLEX TERMINATION TOOLING: REQUIRED FOR TERMINATING 22 AWG CONDUCTORS
 DISCRETE WIRE = CAM4 / 62300-0100

CABLE = AM 8640 / 011-20-0412
 AM8640B / 011-20-0771

6.0 TERMINATION REQUIREMENTS:

6.1 CABLE INSERTION DEPTH:

CABLE SHOULD BE INSERTED TO DEPTH WHERE THE MOLDED WIRE STRAIN RELIEF'S CAN RETURN TO THEIR NORMAL POSITION, AND A GAP IS MAINTAINED BETWEEN THE WIRE AND THE BOTTOM OF THE STRAIN RELIEF WINDOW, AS SHOWN IN FIGURE 4.

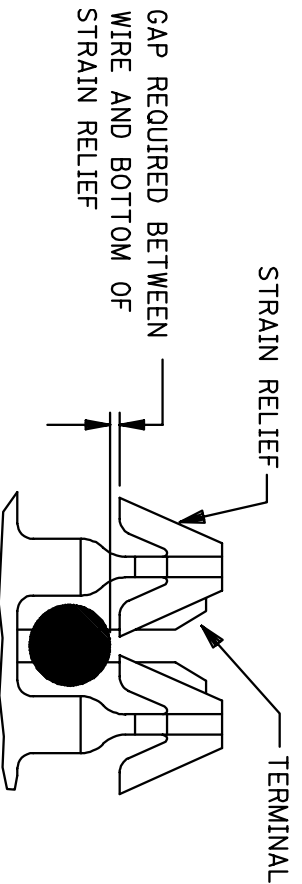


FIGURE 4

6.2 EXPOSED CONDUCTOR
 EXPOSED CONDUCTORS SHALL NOT EXCEED THE LIMITS SPECIFIED IN
 FIGURE 5 AFTER TERMINATION

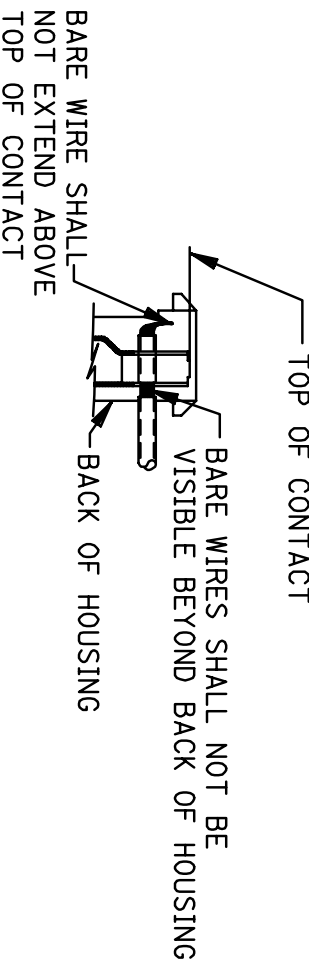


FIGURE 5

<p>D SEE SHEET 1</p>	<p>THIS DOCUMENT CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION</p>
<p>REV DESCRIPTION</p>	

<p>DOCUMENT NO. SMES-7720-0002</p>	<p>FILE NAME</p>	<p>SHEET</p>
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6.3 THE WIRE MUST BE DISPLACED IN BOTH INSULATION DISPLACEMENT SLOTS AND MUST PROTRUDE THROUGH THE SECONDARY SLOT BY (.63)/.025 MIN. AS SHOWN IN FIGURE 6.

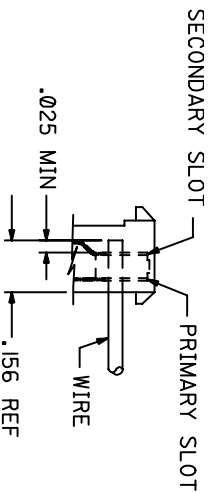


FIGURE 6

6.4 HORIZONTAL PULL OUT FORCE:
THE CONNECTOR MUST MAINTAIN THE FOLLOWING MIN. PULL OUT VALUES WHEN A FORCE IS APPLIED AT A RATE OF 1 INCH PER MINUTE TO THE CABLE IN A DIRECTION PERPENDICULAR TO THE INSULATION DISPLACEMENT SECTION, AS SHOWN IN FIGURE 7. (NOTE CABLE MUST BE SLIT TO FORM INDIVIDUAL CONDUCTORS AFTER TERMINATION BUT PRIOR TO TESTING.)

AWG	PULL FORCE
24 AWG	8.0 LBS MIN
26 AWG	4.6 LBS MIN
28 AWG	3.9 LBS MIN

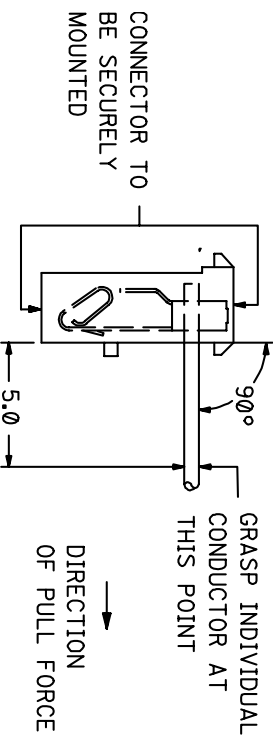


FIGURE 7

6.5 VERTICAL PULL OUT FORCE
THE CONNECTOR MUST MAINTAIN THE FOLLOWING MIN. PULL OUT VALUES WHEN A FORCE IS APPLIED AT A RATE OF 1 INCH PER MINUTE TO THE CABLE IN A DIRECTION PARALLEL TO THE INSULATION DISPLACEMENT SECTION, AS SHOWN IN FIGURE 8. (NOTE CABLE MUST BE SLIT TO FORM INDIVIDUAL CONDUCTORS AFTER TERMINATION BUT PRIOR TO TESTING. TEST IS PERFORMED WITHOUT STRAIN RELIEF COVERS.)

AWG	PULL FORCE
22 AWG	TO BE DETERMINED
24 AWG	1.5 LBS MIN.
26 AWG	1.5 LBS MIN.
28 AWG	1.5 LBS MIN.

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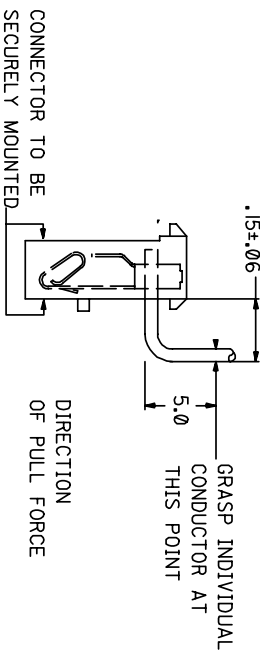


FIGURE 8

6.6 TORSIONAL RESISTANCE

CONNECTOR MUST WITHSTAND A MAXIMUM TWIST ON A TERMINATED CABLE OF 130 DEG. WITHOUT DISTURBING THE INSULATION DISPLACEMENT INTERFACE IN THE PRIMARY OR SECONDARY SLOTS (SEE FIGURE 9). (NOTE CABLE MUST BE SLIT TO FORM INDIVIDUAL CONDUCTORS AFTER TERMINATION BUT PRIOR TO TESTING).

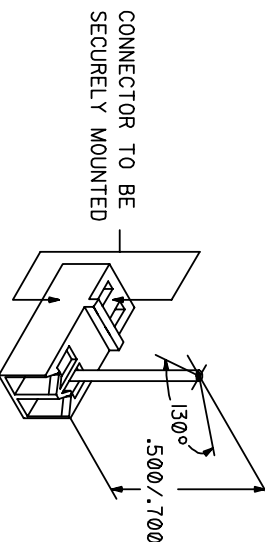


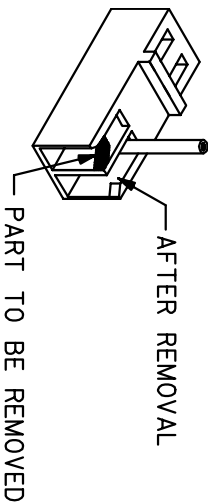
FIGURE 9

6.7 VISUAL INSPECTION:

AFTER TERMINATION, INSULATION DISPLACEMENT SECTION OF THE TERMINAL TO BE FREE OF TOOL MARKS FROM TERMINATION EQUIPMENT.

TERMINATION EVALUATION PROCEDURE

- STEP 1 STRAIN RELIEF REMOVAL - REMOVE SHADED PORTION OF THE STRAIN RELIEF USING A RAZOR BLADE



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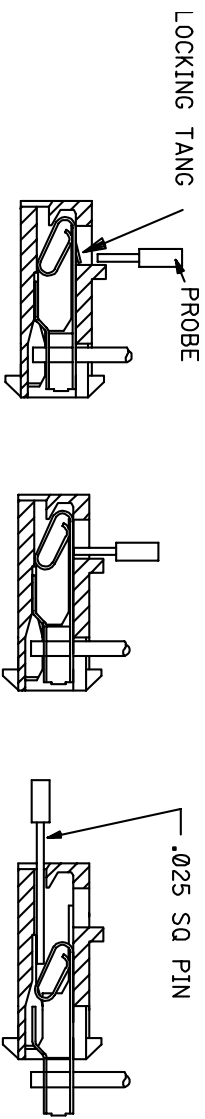
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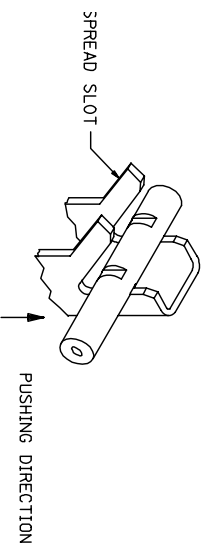
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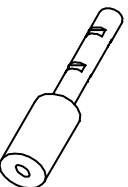
STEP 2 REMOVAL OF TERMINAL - INSERT PROBE INTO LOCKING TANG WINDOW AND DEPRESS THE LOCKING TANG UNTIL IT CLEARS HOUSING, THEN PUSH THE TERMINAL OUT OF THE HOUSING USING A BLUNT .025 SQ. PIN



STEP 3 CONDUCTOR REMOVAL - USING A SMALL PAIR OF PLIERS SPREAD THE I.D.T. SLOT AND REMOVE CONDUCTOR BY PUSHING IN DIRECTION SHOWN.



STEP 4 REMOVING INSULATION - INSULATION TO BE REMOVED WITHOUT DISTURBING I.D.T. AREA



STEP 5 CONDUCTOR INSPECTION - FOUR DEFORMATION POINTS MUST BE CLEARLY VISIBLE WHEN USING 10X MAGNIFICATION.



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