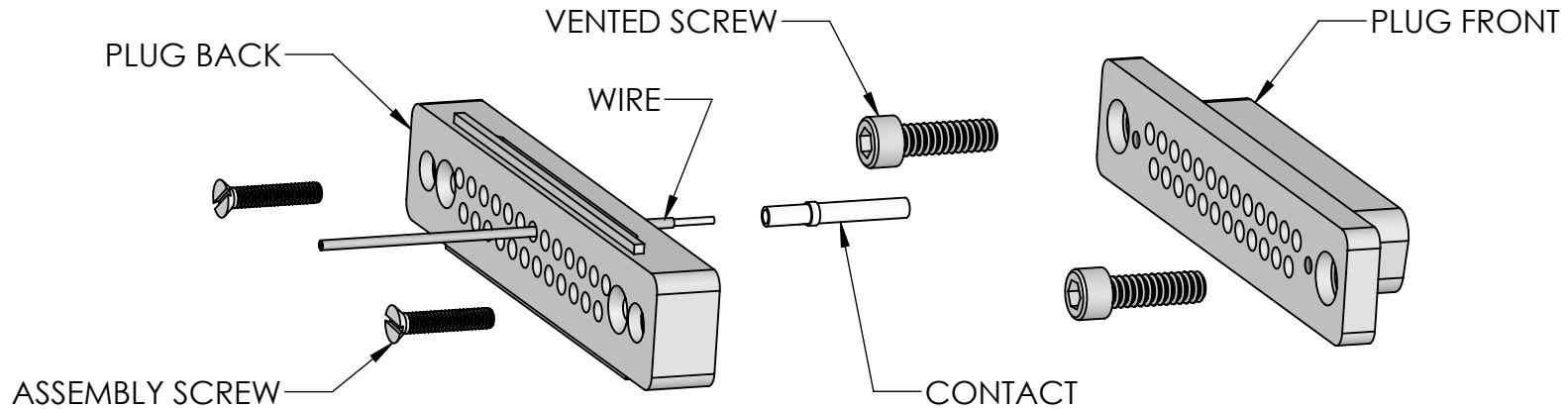
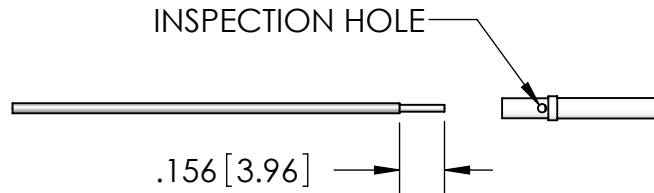


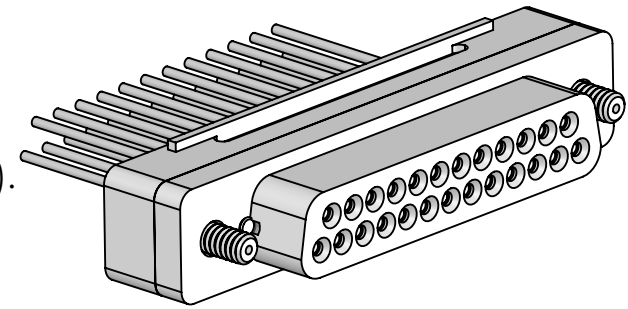
# SUB D VACUUM SIDE PLUG TO WIRE ASSEMBLY



**FIG 2**



**FIG 3**



FEED WIRE THROUGH PLUG BACK (AND NUT IF HOOD IS INCLUDED SEE SHEET 2). STRIP END OF WIRE TO DIMENSION SHOWN. INSERT WIRE FULLY INTO CONTACT, WIRE SHOULD BE VISIBLE IN INSPECTION HOLE. CRIMP WIRE TO CONTACT USING CRIMP TOOL (SEE TABLE). CENTER CRIMP BETWEEN END OF CONTACT AND INSPECTION HOLE.

SHEET 1 APPLIES TO:

No. OF PINS	PLUG P/N	WIRE SIZE AWG	FP13347 SETTING	FP31723* SETTING
9	FA13603	20	4	-
15	FA13604	20	4	-
15 HD	FA42809	22	-	3
25	FA13605	20	4	-
26 HD	FA37797	22	-	3
37	FA16705	20	4	-
50	FA13606	20	4	-
62 HD	FA17947	22	-	3

INSERT VENTED SCREWS INTO COUNTERBORES IN PLUG FRONT. THEN INSERT CONTACTS INTO PLUG FRONT HOLES. ALIGN PLUG BACK AND PLUG FRONT. INSERT ASSEMBLY SCREWS IN PLUG BACK AND TIGHTEN.

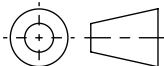
**\*\*FOR VACUUM PLUGS WITH BACKSHELL INCLUDED SEE SHEET 2 FOR ASSEMBLY INSTRUCTIONS**

\*CRIMP TOOL FP31723 REQUIRES LOCATOR FP32470.

PROPRIETARY AND CONFIDENTIAL

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SOLID SEALING TECHNOLOGY. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SOLID SEALING TECHNOLOGY IS PROHIBITED.

THIRD ANGLE PROJECTION



TITLE:

INSTRUCTION SHEET  
SUB D VACUUM PLUG



**SOLID SEALING TECHNOLOGY**

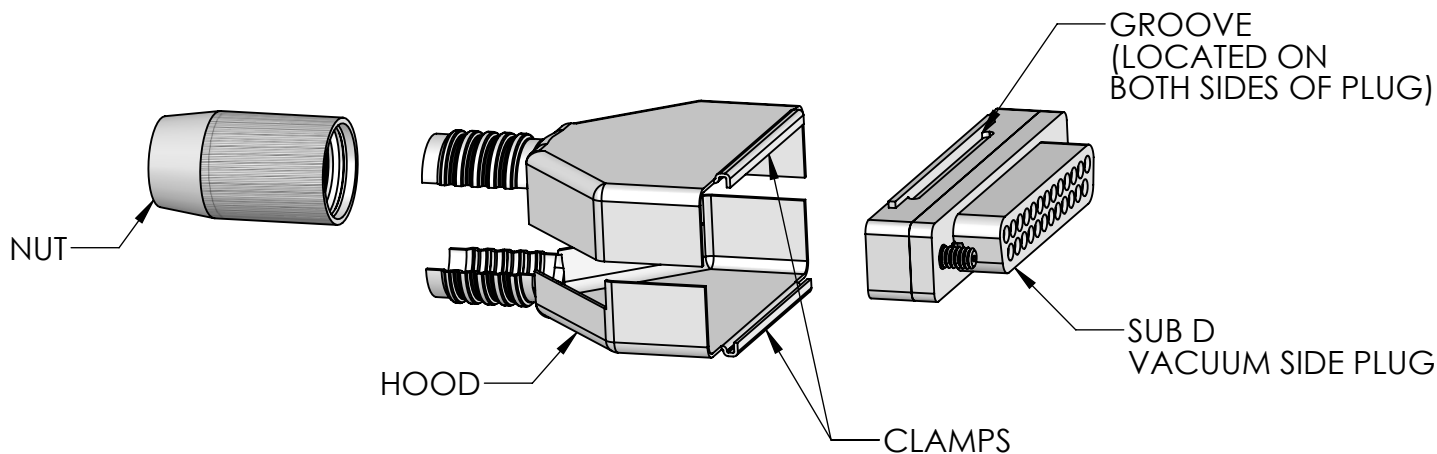
REV.	APP'D	DATE	SCALE 1.5:1	DIMENSIONS IN INCHES [mm]	DRAWN	JS	4/24/2009	NUMBER:
E	JF	09/22/2021	NS13605-13		ENG APPR.	MH	04/28/2009	

NS13605

REV: E

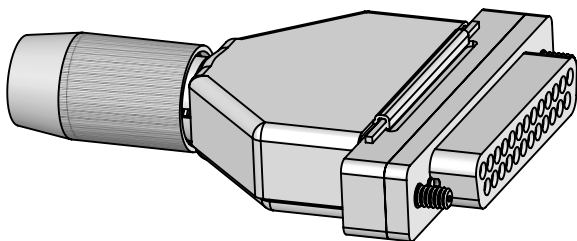
SHEET 1 OF 2

## SUB D VACUUM SIDE PLUG WITH BACKSHELL ASSEMBLY



### ASSEMBLY INSTRUCTIONS WITH BACKSHELL:

- 1- SLIDE WIRES THROUGH NUT BEFORE ASSEMBLING VACUUM PLUG. REFER TO INSTRUCTIONS ON SHEET 1 ON HOW TO ASSEMBLE VACUUM PLUG.
- 2- ATTACH CLAMPS ON HOOD TO GROOVES ON TOP AND BOTTOM OF PLUG. THEN SNAP HOOD TOGETHER.
- 3- TIGHTEN NUT OVER BACK OF HOOD.



(WIRES NOT SHOWN)

### SHEET 2 APPLIES TO:

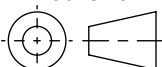
No. OF PINS	PLUG P/N	WIRE SIZE AWG	FP13347 SETTING	FP31723* SETTING
9	KT13603	20	4	-
15	KT13604	20	4	-
25	KT13605	20	4	-
26 HD	KT37797	22	-	3
37	KT16705	20	4	-

\*CRIMP TOOL FP31723 REQUIRES LOCATOR FP32470.

PROPRIETARY AND CONFIDENTIAL

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SOLID SEALING TECHNOLOGY. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SOLID SEALING TECHNOLOGY IS PROHIBITED.

THIRD ANGLE PROJECTION



TITLE:

## INSTRUCTION SHEET SUB D VACUUM PLUG



**SOLID SEALING  
TECHNOLOGY**

REV.	APP'D	DATE	SCALE 1.5:1	DIMENSIONS IN INCHES [mm]	DRAWN	JS	4/24/2009	NUMBER:
E	JF	09/22/2021	NS18774-12		ENG APPR.	MH	04/28/2009	NS13605

REV:

E

SHEET 2 OF 2