

AIR SIDE CRIMP PLUG ASSEMBLY FOR FA19649

FIG 1

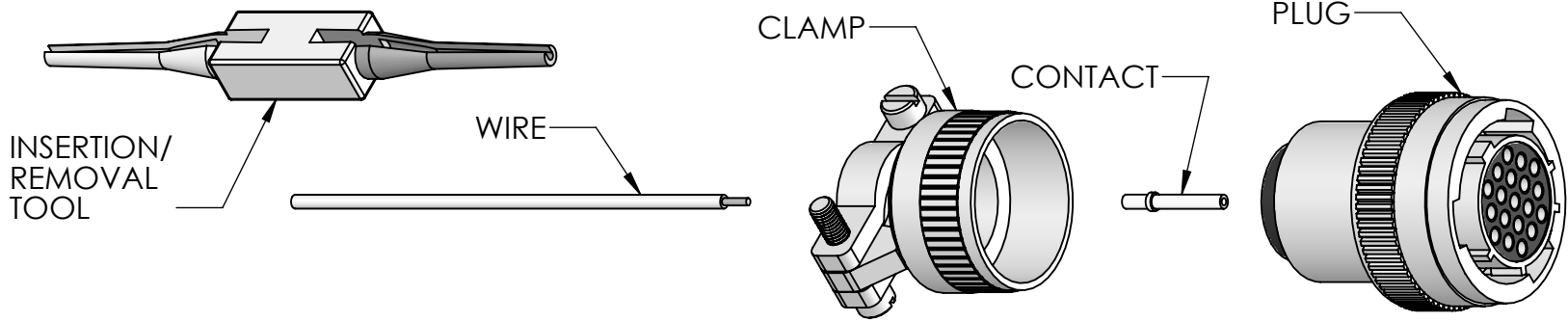
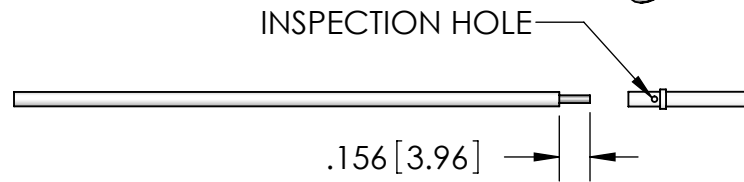


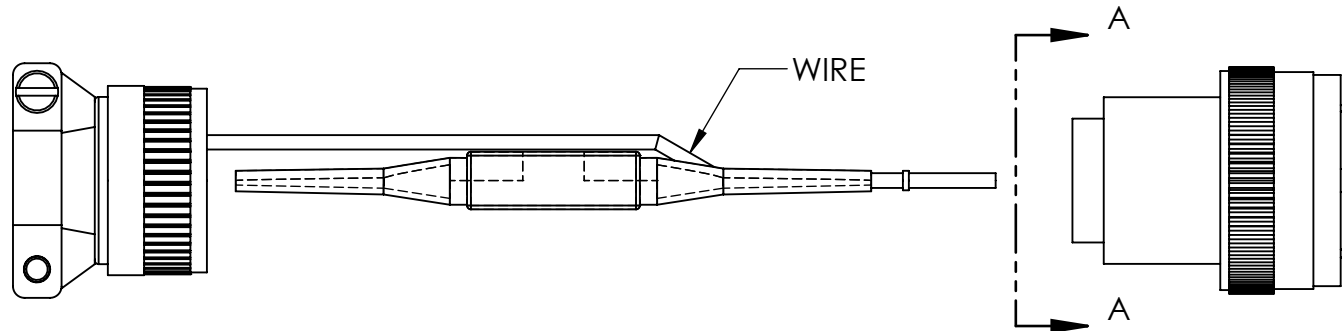
FIG 2



FP13347 CRIMP TOOL SETTING	
WIRE AWG	TOOL SETTING
20	4
22	3
24	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 SST P/N FP13347 (SEE TABLE FOR SETTING). CENTER CRIMP BETWEEN END OF CONTACT AND INSPECTION HOLE.

FIG 3

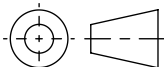


SLIDE CONTACT AND WIRE THROUGH CLAMP. THEN SLIDE CONTACT AND WIRE INTO RED END OF INSERTION TOOL. BEGINNING FROM THE CENTER CAVITY AND WORKING OUTWARDS IN A CIRCULAR PATTERN, INSERT WIRED CONTACTS INTO PLUG. (SEE FIG 4 VIEW A-A ON SHEET 2 FOR CONTACT LOCATIONS.) PUSH TOOL STRAIGHT INTO CAVITY UNTIL CONTACT SNAPS INTO POSITION. A LIGHT PULL ON THE WIRE WILL ASSURE THAT THE CONTACT IS SECURELY IN POSITION. REMOVE INSERTION TOOL AND REPEAT.

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THIRD ANGLE PROJECTION



TITLE:

**INSTRUCTION SHEET
9 PAIR T/C PLUG ASSEMBLY**



**SOLID SEALING
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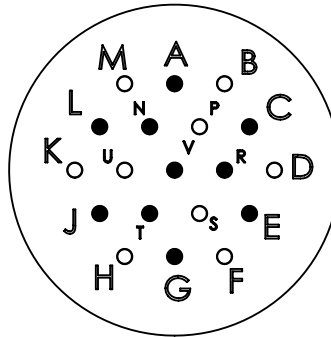
REV.	APP'D	DATE	SCALE 1:1	DIMENSIONS IN INCHES [mm]	DRAWN	JS	07/19/2011	NUMBER:
D	JF	06/10/2021	NS19649-11		ENG APPR.	JS	07/19/2011	

NS19649

REV: **D**

SHEET 1 OF 2

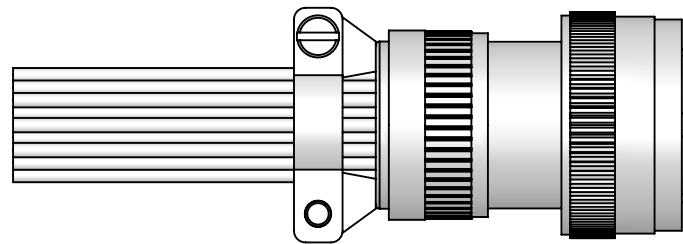
**FIG 4
VIEW A-A**



CONTACT LOCATIONS

LOCATION	CONTACT MATERIAL	CONTACT P/N	COLOR BANDS
SHADED	CHROMEL (+)	CP13353-02	BROWN-YELLOW-BROWN
UNSHADED	ALUMEL (-)	CP13353-03	BROWN-YELLOW-BLACK

FIG 5



TIGHTEN CLAMP ONTO PLUG

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D	JF	06/10/2021	MPC10374-11		ENG APPR.	JS	07/19/2011		
								SHEET 2 OF 2	