

AIR SIDE CRIMP PLUG ASSEMBLY FOR FA19814

FIG 1

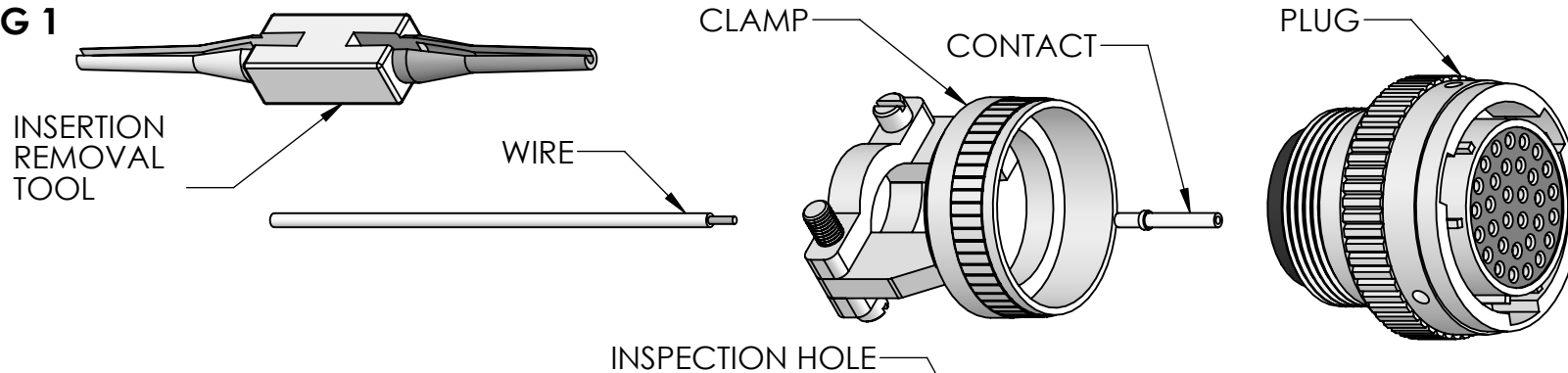


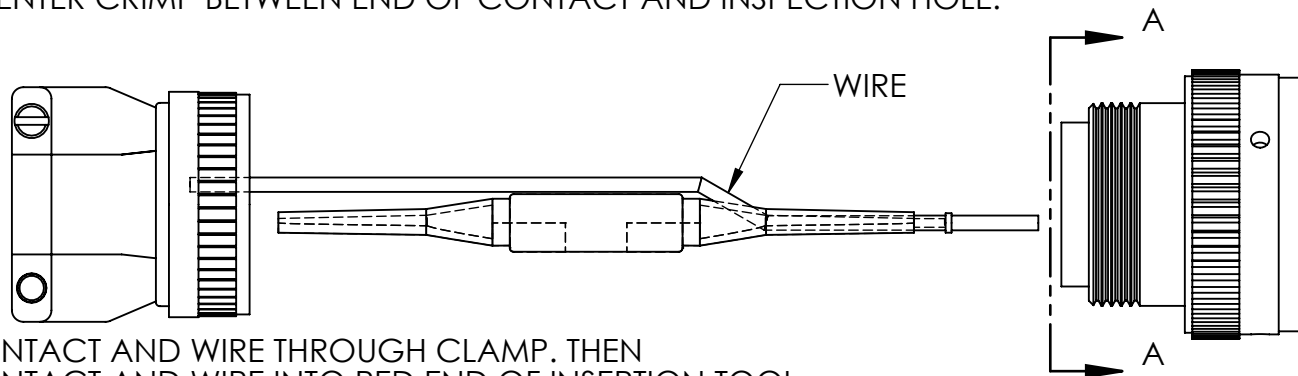
FIG 2



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 SETTINGS). CENTER CRIMP BETWEEN END OF CONTACT AND INSPECTION HOLE.

FP13347 CRIMP TOOL SETTING	
WIRE AWG	TOOL SETTING
20	4
22	3
24	2

FIG 3



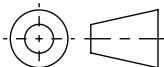
SEE SHEET 2 FOR CONTACT LOCATIONS

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
16 PAIR T/C PLUG ASSEMBLY**



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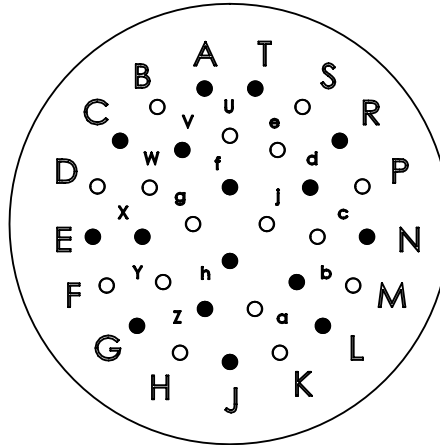
REV.	APP'D	DATE	SCALE 1:1	DIMENSIONS IN INCHES [mm]	DRAWN	JS	12/9/2008	NUMBER:
C	JF	06/10/2021	NS19814-11		ENG APPR.	OG	02/10/2009	

NS19814

REV: **C**

SHEET 1 OF 2

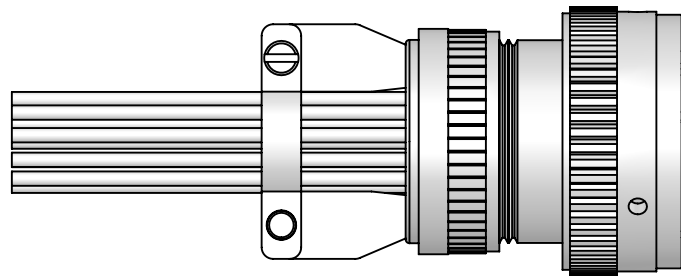
**FIG 4
VIEW A-A**



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

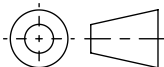


TIGHTEN CLAMP ONTO PLUG.

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SHEET 2 OF 2