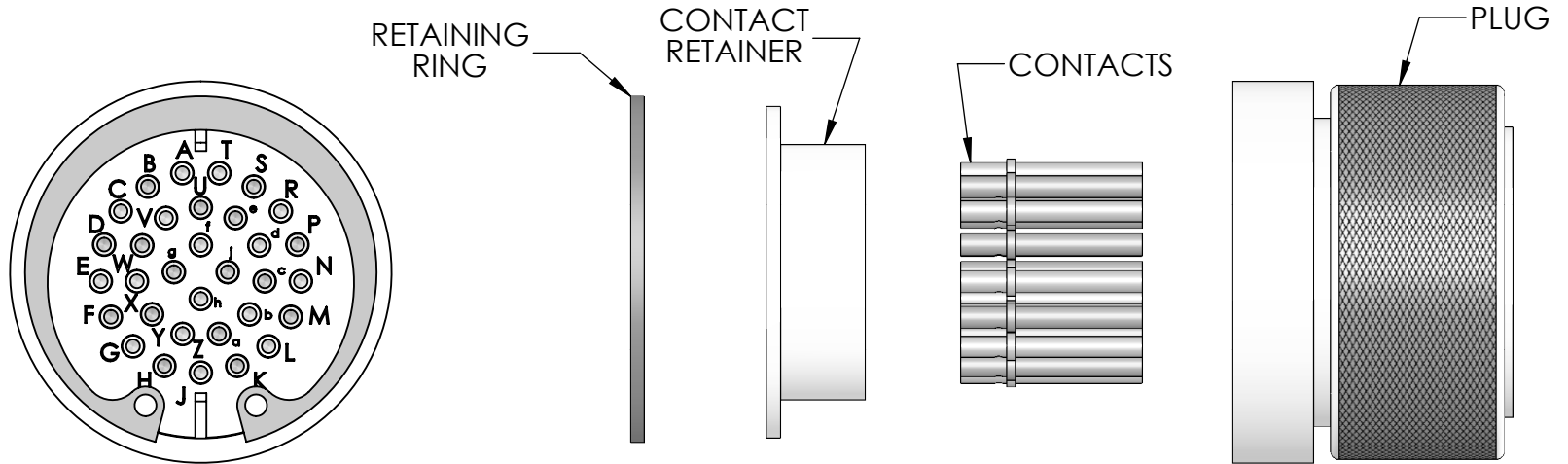


ASSEMBLY INSTRUCTIONS FOR PLUG FA19815

ASSEMBLY INSTRUCTIONS:

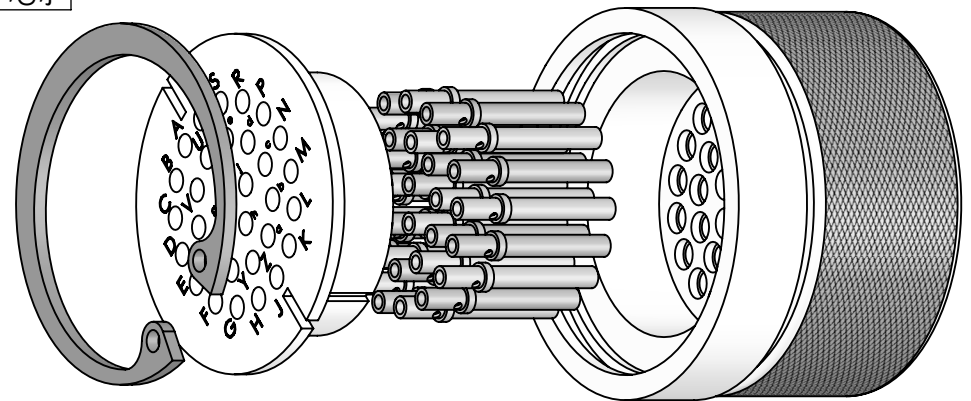
- 1- INSERT WIRES THROUGH CONTACT RETAINER AND CRIMP TO CONTACTS. USE CRIMP TOOL FP13347 (SEE TABLE FOR SETTINGS).
- 2- AFTER CRIMPING SEAT CONTACTS INTO PLUG. SEE TABLE BELOW FOR CONTACT LOCATIONS.
- 3- INSERT CONTACT RETAINER INTO PLUG
- 4- INSERT RETAINING RING INTO GROOVE IN BACK OF PLUG.



(+) CHROMEL CONTACT P/N CP13353-02 LOCATIONS A,C,E,G,J,L,N,R,T,V,X,Z,b,d,f,h	(-) ALUMEL CONTACT P/N CP13353-03 LOCATIONS B,D,F,H,K,M,P,S,U,W,Y,a,c,e,g,j
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CONTACT IDENTIFICATION	
MATERIAL:	COLOR BANDS:
CHROMEL	BROWN-YELLOW-BROWN
ALUMEL	BROWN-YELLOW-BLACK

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



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 16 PAIR T/C TYPE K PLUG							
REV.	APP'D	DATE	SCALE 3:2	DIMENSIONS IN INCHES [mm]	DRAWN	JS	11/21/2008	NUMBER:	NS19815	REV:	C	SHEET 1 OF 1
C	JF	06/10/2021	MSME007-02EX		ENG APPR.	OG	12/05/2008					