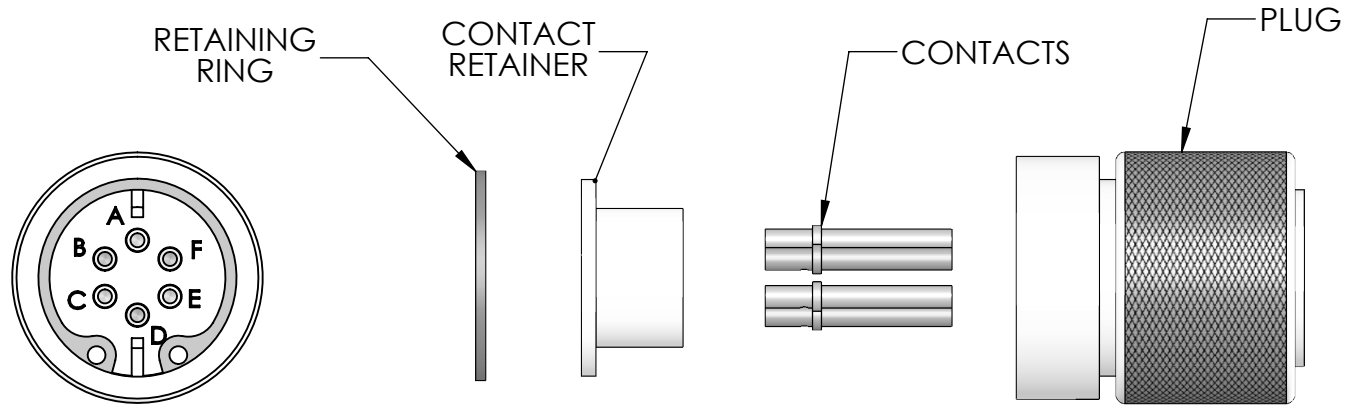


ASSEMBLY INSTRUCTIONS FOR PLUG FA23459

ASSEMBLY INSTRUCTIONS:

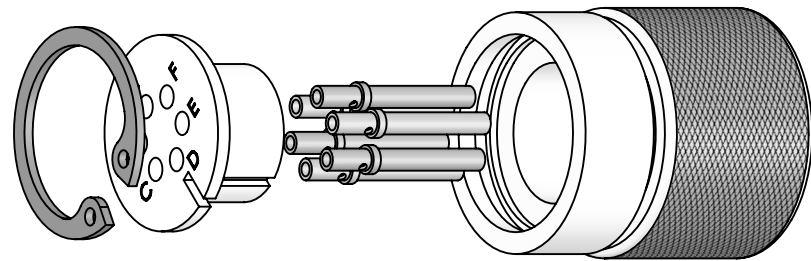
- 1- INSERT WIRES THROUGH CONTACT RETAINER AND CRIMP TO CONTACTS. USE CRIMP TOOL FP13347 (SEE TABLE FOR SETTINGS).
- 2- AFTER CRIMPING SEAT CONTACTS INTO PLUG. SEE TABLE BELOW FOR CONTACT LOCATIONS.
- 3- INSERT CONTACT RETAINER INTO PLUG
- 4- INSERT RETAINING RING INTO GROOVE IN BACK OF PLUG.



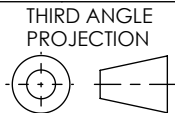
(+) CHROMEL CONTACT P/N CP13353-02 LOCATIONS A,C,E	(-) ALUMEL CONTACT P/N CP13353-03 LOCATIONS B,D,F
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CONTACT IDENTIFICATION	
MATERIAL:	COLOR BANDS:
CHROMEL	BROWN-YELLOW-BROWN
ALUMEL	BROWN-YELLOW-BLACK

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



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TITLE
**INSTRUCTION SHEET
 T/C TYPE K PLUG ASSEMBLY**



REV.	APP'D	DATE	SCALE 3:2	DIMENSIONS IN INCHES [mm]	DRAWN	CW	10/5/2020	NUMBER	REV	SHEET 1 OF 1
A	JF	06/10/2021	MSME0034-12EX		ENG APPR.	JF	06/10/2021	NS23459	A	