



Instructions for the Assembly of Scotchflex Specialty Socket Connectors

Contact Quantity	3M Socket Part No.	Grid Spacing	Strain Relief Part No.	Pull Tab Part No.	Locator Plate Part No.	Platen Part No.	Adj. Setting Presses 3440 Series and 3640	Adj. Setting Presses 3335 Series and 3339 Series
14	3407-0000	.100" x .300"	3448-3	3490-1	3443-2	3442-1A	10½	11
16	3327-0000	.100" x .300"	3448-8	3490-1	3443-31	3442-1A	10½	11
24	3450-0000	.125" x .250"	3448-2	3490-3	3443-21	3442-1A	11½	12
	3450-0001				3443-22		11	11½
28	3441-0000	.150" x .150"	3448-1	3490-3	3443-20	3442-1A	12½	13
34	3424-0000	.100" x .200"	—	—	3443-6	3442-1A	11½	12
	3471-0000		3448-5	3490-3				

General:

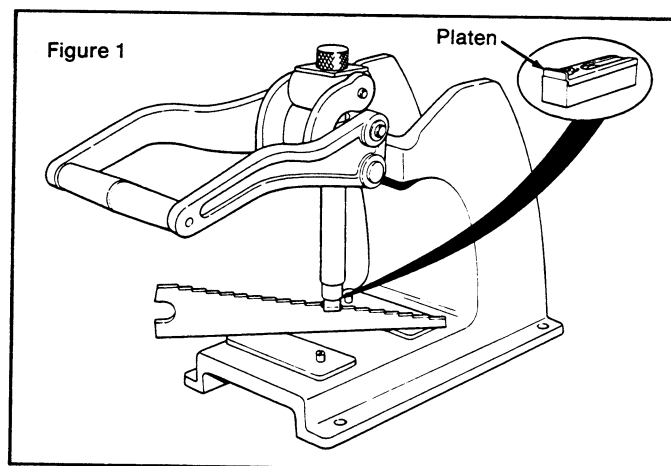
Scotchflex manual and pneumatic assembly presses and accessory tooling are recommended for the termination of Scotchflex Specialty Sockets. Scotchflex tooling is offered to reduce set-up time, to provide easier and faster assembly, and to reduce assembly error.

Connectors 3327 and 3407 are assembled with the platen perpendicular to the connector.

Connectors 3450, 3441, 3424 and 3471 are assembled with the platen parallel to the connector.

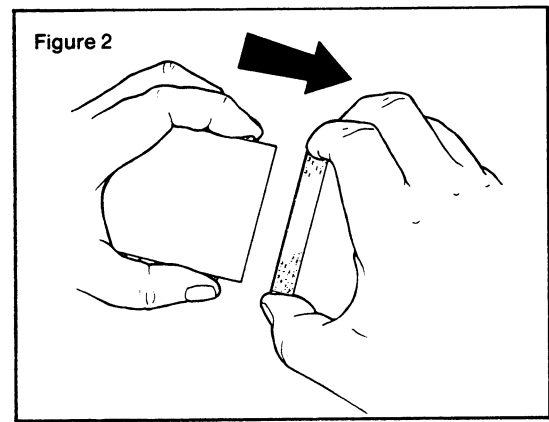
Assembly:

1. Remove the platen from the assembly press shaft and adjust the press shut height, referencing from the press table. (Figure 1)
2. Position the locator plate on the assembly press table for right, left or front cable entry.
3. Install Platen 3442-1A on the assembly press shaft.



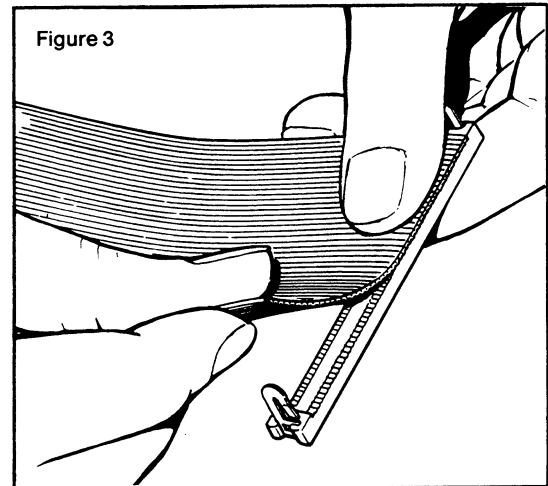
4. Remove a connector cover from the paper liner by snapping cover down against adjacent cover and then pulling laterally away from the liner. (Figure 2)

Note: Cover on 3450-0001 is individually taped. Rub thumb along length of paper liner to insure maximum adhesive transfer to the cover. Apply pressure lengthwise to liner to shift it enough to be grasped and peeled off.



5. Press ribbed side of cable into cover alignment grooves. (Figure 3) Visually inspect to insure that:

- a. Cable is properly aligned and oriented in connector cover grooves.
- b. Cable is perpendicular to cover.



6. Place the cable/cover sub-assembly within the cable-connector guides on the locator plate.

Note: Covers of connectors 3407, 3327, 3450-0000 and 3450-0001 can be placed only one way.

7. Position the connector body over the cable/cover sub-assembly.

Note: Bodies of connectors 3407, 3327, 3450-0000 and 3450-0001 can fit the cable-connector guides only one way.

8. Lower the assembly press handle fully to complete the termination.

9. Raise the assembly press handle and remove the completed assembly.

10. Visually inspect the insure that:

- a. Cable is fully seated and parallel with body.
- b. Metal cover retaining devices are completely engaged and locked onto body.

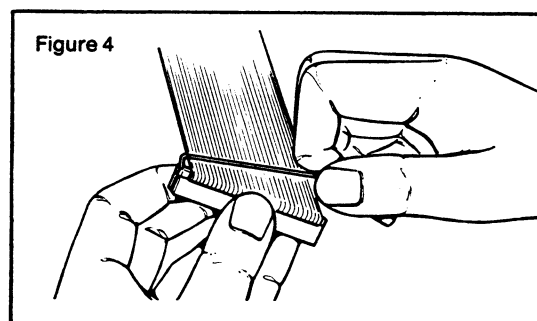
Note: Connectors 3407 and 3327 are secured by cold heading. Connector 3424 is secured by press fit.

Strain Relief:

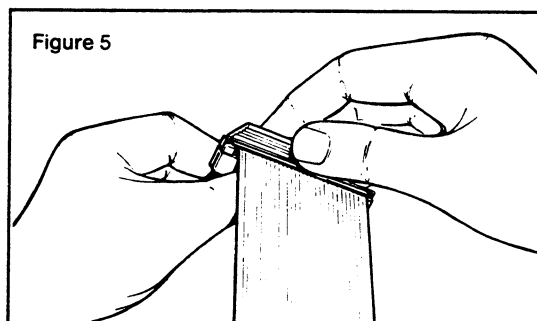
1. Bend cable back over cover.
2. Engage one end of strain relief onto the cover retaining device. (Figures 4, 5, 6)

Note: Strain Relief 3448-8 engages with the **connector body**.

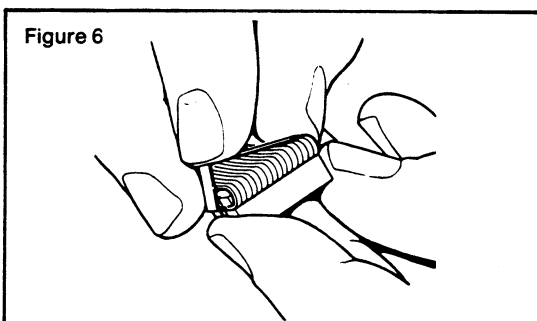
3. Apply force to the opposite end until it snaps into place. (A flat-tipped screwdriver can facilitate assembly of **wire style** strain relief.)
4. For 3448-5, hook the extruded handle beneath the strain relief wire to complete "pull" handle.



Strain Relief
3448-1, -2, -3



Strain Relief
3448-5

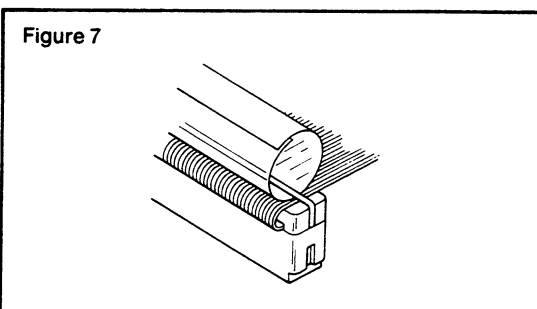


Strain Relief
3448-8

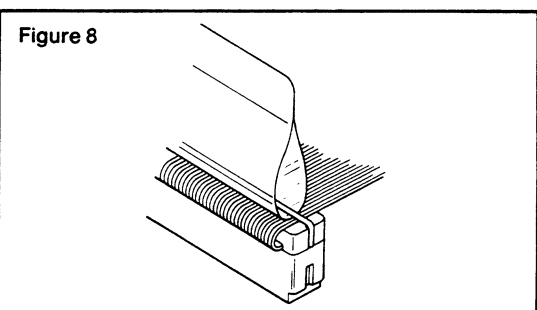
Pull Tab:

For connectors 3407, 3327, 3450, 3441, 3471.
(Figures 7 and 8)

1. Slip pull tab 3490-X beneath strain relief and center.
2. Remove the protective paper liner and attach pull tab ends in a circular or tear-drop shape.



Circular Shape



Teardrop Shape

Important Notice to Purchaser:

All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed, and the following is made in lieu of all warranties expressed or implied:

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No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.