3M[™] Locator Plate 3443-94

Instructions for the assembly of $3M^{TM}$ Socket Connectors, .100" x .100" and .100" x .200"

1.0 General

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 $3M^{\text{TM}}$ Manual and Pneumatic Assembly Presses and accessory assembly equipment are recommended for the termination of 3M socket connectors. 3M assembly equipment is offered to reduce set-up time, to provide easy and fast assembly, and to reduce assembly error. All listed socket connectors use the $3M^{\text{TM}}$ Locator Plate 3443-94 and the $3M^{\text{TM}}$ Platen 3342-9. Shut height settings for the $3M^{\text{TM}}$ Presses 3316 and 3640 use 12, for the $3M^{\text{TM}}$ Press 3335 use 12 ½, the $3M^{\text{TM}}$ Press 3830 is self-adjusting.

100" v 100" Crid System

.100" x .200" Backplane System		.100" x .100" Grid S	.100" x .100" Grid System	
Contact Quantity	3M Part number	Contact Quantity	3M Part Number	
20	3575	6	3863	
26	3501	8	3868	
34	3310	10	3473	
40	3318	14	3385	
50	3307	16	3452	
		20	3421	
		24	3626	
		26	3399	
		30	3419	
		34	3414	
		36	9436	
		40	3417	
		44	9444	
		50	3425	
		60	3334	

The 3M Locator Plate 3443-94 was designed to assemble 3M socket connectors and replaces plates 3443-54, 3443-60, and 3443-73.





2.0 Set-up procedures for sockets, cables and guides

Adjustments to plate

Various adjustments are required to the locator plate, depending on which socket connector or cable is being assembled. 3M[™] Locator Plate 3443-94 is the recommended assembly aid. (See Figure 1)

The Locator Plate 3443-94 can be used to assemble:

- .100" x .100" and .100" x .200" socket connectors with and without the center bump feature.
- Socket connectors with standard flat cable and with ground plane cable.

End guide set-up

To adjust the position of the end guide for the connector length position, lift the end guide up and move it to the left or right.

The viewing port on each end guide must align with the appropriate connector conductor size. The connector conductor size is specified by the numbers on the respective labels.

To adjust the end guide position for the .100" x .100" or .100" x .200" connector, lift and rotate the end guide 180° so that the viewing port points to the respective .100" x .100" or .100" x .200" label guide.

Standard flat cable

To assemble **standard flat cable**, the cable width is guided between:

- The narrow end guide area.
- The side of the end guide with the viewing port feature.

Ground plane cable

To assemble ground plane cable, the cable width is guided between:

- The wide end guide area.
- The side of the end guide that does not have the viewing port feature.

Center bump feature

The center bump connector does not require any special set-up procedure.



Figure 1

3.0 Shut height adjustment procedures

The shut height setting is referenced in the .100" x .200" Backplane System Chart and .100" x .100" Grid System Chart on page l. Shut height settings are guidelines for proper termination depth.

The shut height should be adjusted from the base before the $3M^{TM}$ Locator Plate is put into place. The $3M^{TM}$ Presses 3316 and 3640 are adjusted with a knob at the top of the press. The $3M^{TM}$ Press 3335 is adjusted with the collar on the press shaft, and the $3M^{TM}$ Press 3830 is self-adjusting.

- 3.1 Place the shut height gauge 3436-1D across the base of the assembly press. Lower the handle of the press until the handle casting makes contact with the press casting. (See Figure 2)
- 3.2 Determine the type of assembly press you are using:
 - With the Press 3335, lock the shut height adjustment collar toward the base of the press shaft. (See Figure 3a)
 - With the Presses 3316 and 3640 Presses, turn the shut height adjustment knob until the bottom of the press shaft contacts the desired position on the shut height gauge. (See Figure 3b)





Figure 2



Figure 3a



Figure 3b

4.0 Connector/cable assembly procedures

- 4.1 Grasp a socket cover strip between the thumb and forefinger of both hands, with the liner facing you. Rotate the outermost cover down against the adjacent cover on the strip, breaking it from the liner. Pull laterally away from the strip, leaving a clean adhesive edge on the removed cover. (See Figure 4)
- 4.2 Firmly press ribbed side of cable into alignment grooves on cover. The adhesive will help it stay in place. (See Figure 5)
- 4.3 Visually inspect to insure that:
 - Cable is properly aligned to cover grooves.
 - Cable end is flush with cover for end terminations, or perpendicular to cover for midspan terminations.
- 4.4 Place the cable/cover sub-assembly between the guides on the 3M[™] Locator Plate, cover side down. (See Figure 6)
- 4.5 Orient and position connector body contacts down over the cable/cover subassembly, engaging cover retainer devices with body slots. (See Figure 7)
- 4.6 Lower the assembly press handle fully to complete the connection.
- 4.7 Raise press handle and remove completed assembly. Visually inspect to insure that:
 - Cover is fully seated and parallel with the body.
 - Cable is properly aligned with the cover grooves.
 - Cover retaining devices are completely engaged with the body.



Figure 4



Figure 5



Figure 6



Figure 7

Customer and Technical Service

Within the U.S.: Customer Service: 800-225-5373 Technical Support: 512-984-6703

Outside of the U.S.: For customer service and technical support, please contact your local 3M Electronic Solutions Division representative.

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