

# 3M™ Locator Plate 3443-107N

## Instructions for the assembly of .100" x .100" preassembled socket connectors

### 1.0 General

The 3M Locator Plate 3443-107N is designed to aid in the assembly of the preassembled socket connector family for all positions. End-to-end as well as daisy chain length (min daisy chain length  $\pm 45$  mm). Set-up and assembly instructions are based on termination procedures with 3M manual and pneumatic presses.

Locator plate includes:

- Instruction sheet
- 3 mounting screws
- 1 M571x26 Hex Key
- 1 SW 2.5 56x18 Hex Key

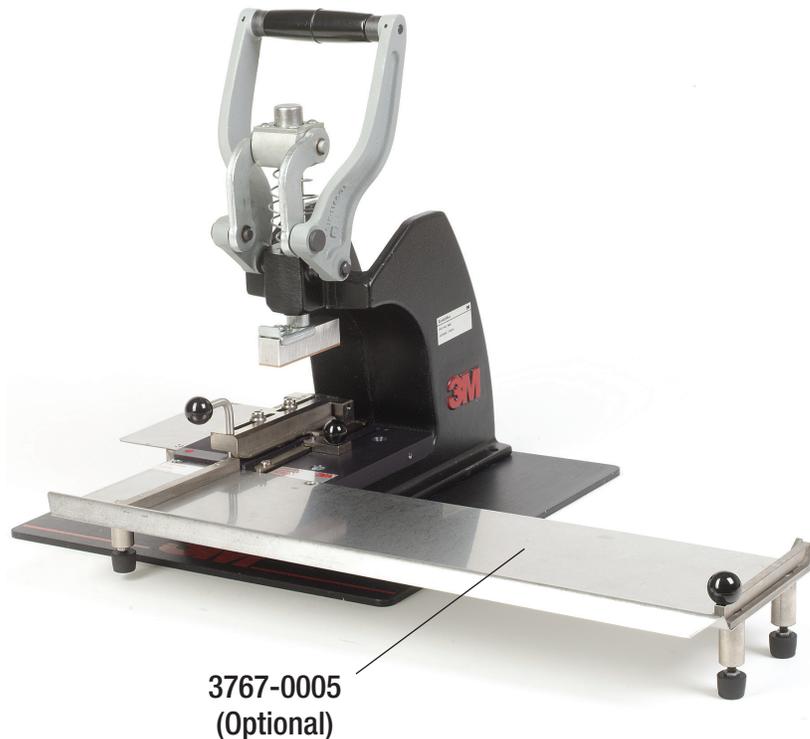


Figure 1

## 2.0 Tool Preparation

- 2.1 Mount lever ① on the guiding wing ② and secure by locking screw ③. Make sure that the plastic ball is facing towards the operator (see Figure 2).
- 2.2 Remove the platen from the assembly press. Adjust shut height to 17 for the 3M™ Assembly Press 3640, or to 17½ for presses the 3M™ Assembly Presses 3335 and 3316 using shut height gauge 3436-1B. The the 3M™ Assembly Press 3830 shut height is self-adjusting.
- 2.3 Place the locator plate on the press and fasten it with the two locking screws, that are included.

**Note:** *If the optional 3M™ Staging Platform (part number 3767-0005) is used, please refer to its own instruction sheet for mounting.*

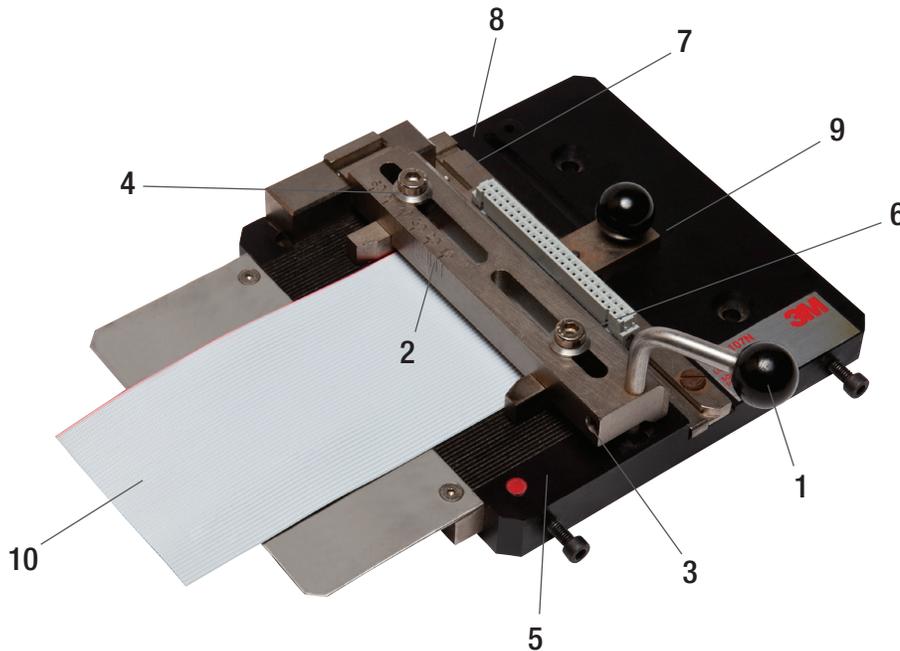


Figure 2

## 3.0 Assembly Procedure

- 3.1 Cut cable to the required length.
- 3.2 Loosen the left cable guide screw ④. Lift the guiding wing ② and slide the left cable guide ④ into the required position depending on the connector size to be used. Connector pole sizes are indicated on the guiding wing ②. Lower the guiding wing ② and make sure that the serrations of the base plate ⑤ and cable guide ④ are fully aligned. Tighten the cable guide locking screw.
- 3.3 Insert the appropriate cable ⑩ under guiding wing ② and adjust the right cable guide ⑥. Make sure that the base plate ⑤ and cable guide ⑥ serrations are aligned and that the right cable guide ⑥ is as close as possible to the cable ⑩.
- 3.4 Adjust the cable stop as required (see Figure 1). For daisy chain assemblies: left position ⑧. For end-to-end assemblies: right position ⑨.
- 3.5 Install the proper platen (3442-9) onto the press.
- 3.6 Remove the connector from the packing strip cover down, IDCs facing down towards the plate.

- 3.7 Slide the connector into the guiding groove against the connector locator stop ⑦.
- 3.8 Place the cable ⑩ into the base plate serrations. For end-to-end assemblies, smoothly slide the cable between cable guides ④ ⑥, under the guiding wing ② against cable stop ⑨. For daisy chain assemblies, until the required length is obtained. The cable will fit between the cover and the contacts of the connector.

***Note: If the cable is not entering into the connector smoothly, check the flatness of the cable used.***

- 3.9 Complete the assembly by closing the press handle.

***Note: Never operate a pneumatic press without ensuring that there is a connector in the locator plate.***

- 3.10 Raise the press handle and remove the finished assembly by lifting the guiding wing ② with the lever ①.
- 3.11 Visually inspect to ensure that:
  - a) The cover is fully locked. If not, check the shut height gauge.
  - b) The cable is correctly aligned in the cover. If not, check the cable guide adjustment.

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