ASSEMBLY HEADS 3624-41 AND 3624-42

Instructions for the assembly of CHG .100" WIREMOUNT SOCKET CONNECTOR to discrete wire

- CHG One Row (.100" Centers) Wiremount Socket
- CHG Two Row (.100" X .100" Centers) Wiremount Socket
- CHG Two Row (.100" X .100" Centers) Military & DIN Polarized Sockets

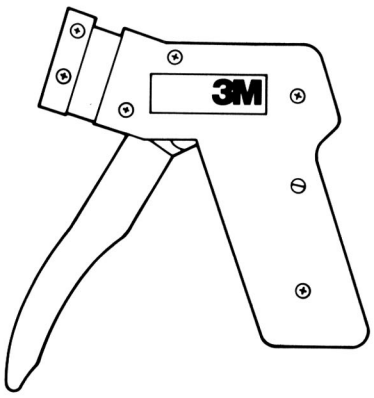
CHG Connector Style	Wire Gauge Size	Assembly Heads	Use with Pistol Grip
1 & 2 Row Stackable 1 & 2 Row Centerbump	26 and 28 AWG	Prod. No. 3624-41	 3586-12 Pistol Grip
1 & 2 Row Stackable 1 & 2 Row Centerbump	24 and 22 AWG		
2 Row Military & DIN	26 and 28 AWG	Prod. No. 3624-42	
2 Row Military & DIN	24 and 22 AWG		

Table 1

General:.
These instructions point out the assembly equipment required to assemble CHG socket connectors to discrete wire. Assembly procedures and assembly quality guidelines for termination are explained.

ASSEMBLY EQUIPMENT

Refer to Table 1 to determine the appropriate Assembly Head to be used with a specific CHG connector.

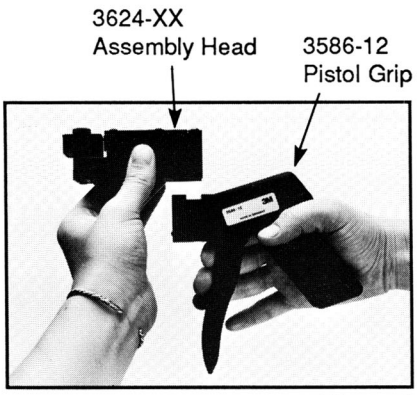


Figure 1

1. Assemble a 3624-XX Assembly Head on to the 3586-12 Pistol Grip. See Figure 1.

2. The 3624-41 Assembly Head is used for the 1 and 2 row non MIL-DIN polarized CHG connector. The **connector backstop** must be set correctly to accommodate a specific connector style. To setup the connector backstop: remove the cap screw, rotate the **connector backstop** to the appropriate side and replace the cap screw. See Figures 2 and 3.

3. The 3624-42 Assembly Head is used for the MIL and DIN polarized CHG connector. The Assembly Head is preset at the factory and no backstop adjustment is required. Refer to Page 4 for seating information.

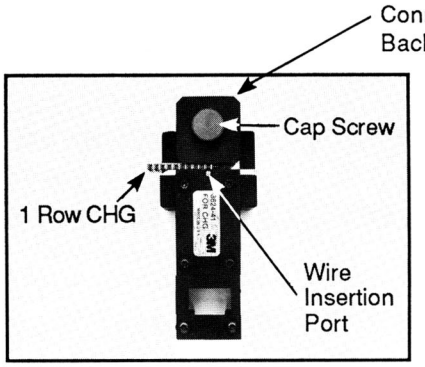


Figure 2

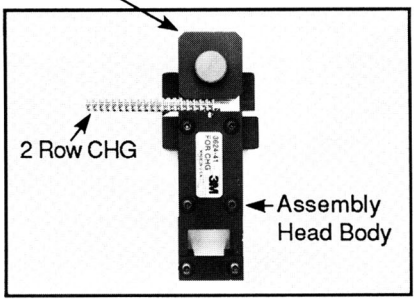


Figure 3

4. Because CHG connectors can accommodate a wide range of wire styles and gauges as shown in Table 2, Page 4, the wire insertion depth must be controlled to maintain termination quality. To assure the correct wire insertion depth, a depth **adjustment** may be necessary. To adjust the wire insertion depth, a set screw in the base of the Assembly Head (See Figure 4) is adjusted. Use the 1/16" allen wrench (provided) to rotate the adjustment set screw. Clockwise will seat the wire deeper and counter clockwise will seat the wire higher.

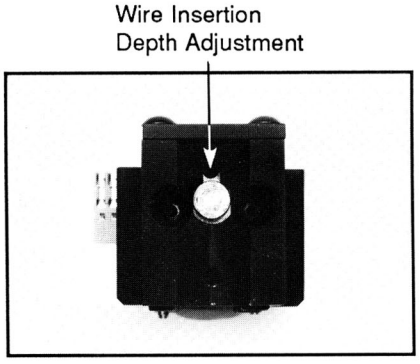


Figure 4

5. The **release screw** on the side of the pistol grip handle can be turned counter clockwise with a screw driver to release any jam. This will release the internal indexing mechanism and reset the pistol grip and head. See Figure 5.

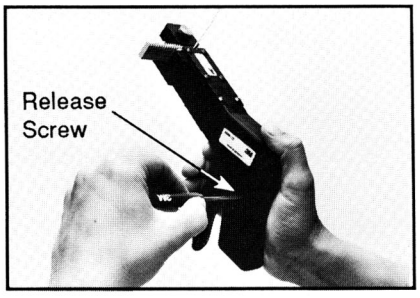


Figure 5

WIRE TERMINATION PROCEDURE

1. To insert a connector body into the Assembly Head from the left as shown, actuate the pistol grip trigger handle and hold it in the closed position. Insert the connector body until it **stops** against the wire termination driver inside the Assembly Head. Release the trigger handle slowly and connector body will index into position automatically. This technique will be especially helpful on short (six conductor and under) connectors.

   This procedure is used for all body styles. See Figure 6.

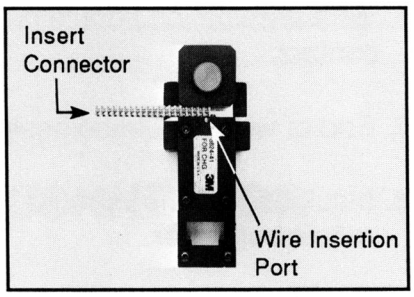


Figure 6

2. To insert a wire, place a straight wire in the **wire insertion port.** The wire should be inserted until it stops on the bottom stop. The wire to be inserted should be grasped about 1" from the termination end of the wire. Special care should be given to hold small 28 AWG wires.

CAUTION: Bending wires, forcing wires into the wire insertion port, or entering the port at an angle can cause poor wire termination quality.

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3. To terminate the wire, close the pistol grip trigger and then release the trigger to the ready position. This action will also index the connector body to the next contact assembly position. See Figure 7.

CAUTION: Do not allow the trigger to "snap back" as this violent action may cause connector body indexing mis-alignment.

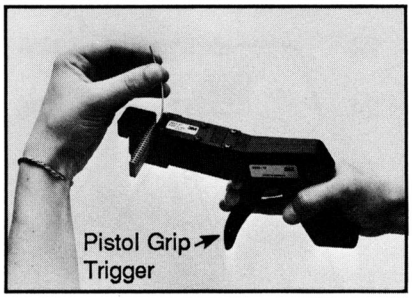


Figure 7

4. To remove the connector from the assembly head, grasp the connector body and move it to the right.

TERMINATION QUALITY

All terminations should be inspected for the following:

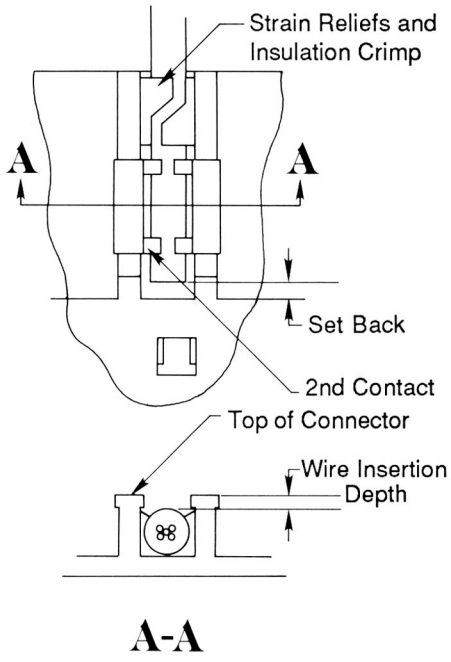
1. Wire termination should be seated in the second contact.

2. End of wire should be set back.

3. Insulation crimp should be complete with both strain reliefs bent over.

4. Wire insertion depth should be measured at Section **A-A**.

5. Check for connector body damage.
   If the depth is not within the tolerance given in the reference chart Table 2, a depth adjustment must be made. Refer to Assembly Equipment #4 on Page 2 for instructions.



A-A

TABLE 2

WIRE INSERTION DEPTH (CHG) 1 ROW AND 2 ROW STACKABLE				WIRE INSERTION DEPTH (CHG) MILITARY DIN POLARIZED			
AWG	UL STD 1061 STRANDED	SOLID	UL STD 1007 STRANDED	AWG	UL STD 1061 STRANDED	SOLID	UL STD 1007 STRANDED
22	.025"	N/A	N/A	22	.042"	N/A	N/A
24	.031"	.035"	N/A	24	.048"	.052"	N/A
26	.036"	.039"	.024"	26	.053"	.056"	.041"
28	.040"	.042"	.028"	28	.057"	.059"	.045"

NOTE: All dimensions are ±.002"

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