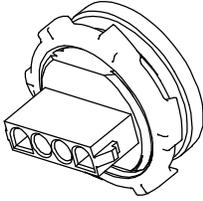
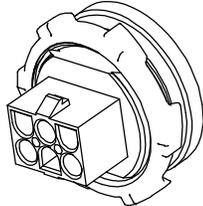


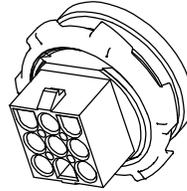
*4-Position Bulkhead
Connector*
1604256-1



*6-Position Bulkhead
Connector*
1604210-1



*9-Position Bulkhead
Connector*
1604254-1



*12-Position Bulkhead
Connector*
1604941-1

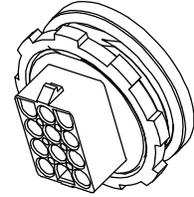


Figure 1

1. INTRODUCTION

This instruction sheet provides assembly procedures for the Universal MATE-N-LOK bulkhead connectors shown in Figure 1.

NOTE



Dimensions on this instruction sheet are in metric units [with U.S. customary units in brackets].

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION

Each bulkhead connector consists of a housing, O-ring, and locknut. The bulkhead accepts a specified number of crimp-type pin and/or socket contacts and mates with an appropriate plug (a typical 4-position plug part number is 350779-1).

Both the plug and bulkhead have individually numbered cavity identification on the back (wire end), and in addition, the plug has an identification rib on the side of the housing indicating the number one cavity.

Mating connectors are fully polarized for proper engagement and employ a positive locking feature to prevent accidental disengagement.

NOTE



For a completely sealed interface, the mating connector must be provided with an interfacial seal and a wire seal. For example, 12-position Interfacial Seal 794279-1 and Wire Seal 794280-1 are available. Seals are available for the other sizes.

3. ASSEMBLY

3.1. Panel Cutout

Each bulkhead is designed to fit into a specific panel cutout. Prepare the cutout according to the Customer Drawing of the part number given in Figure 1.

3.2. Installing Bulkhead into Panel (Refer to Figure 2)

1. Remove the locknut from the bulkhead.
2. Place the bulkhead into the panel cutout. Orient the bulkhead so that the mating face is protruding through the correct side of the panel and the O-ring is against the panel. Make sure that cavity number "1" is properly oriented (typically on the left when viewing the bulkhead from the flanged side).
3. Thread the locknut onto the threaded portion of the bulkhead. Finger-tighten the locknut, then turn the locknut one-quarter more turn.

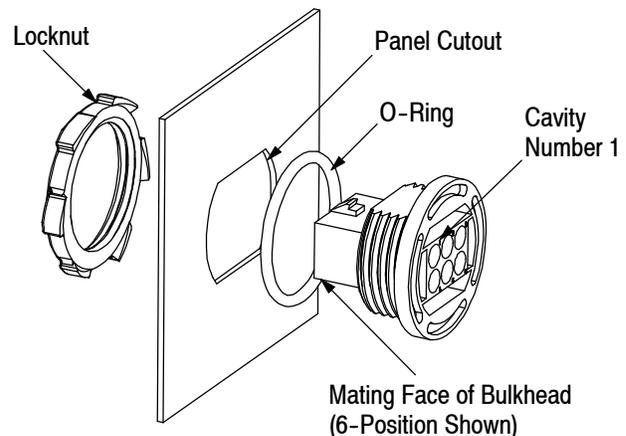


Figure 2

3.3. Inserting Contacts into Bulkhead

1. Crimp the contacts according to the requirements given in Application Specification 114-1010.
2. Insert the terminated contacts in the appropriate cavities of the bulkhead. An insertion tool is generally NOT required for inserting contacts; however, Insertion Tool 455830-1 is available for inserting contacts crimped to small wire sizes. Refer to Instruction Sheet 408-7984 for insertion procedure.

NOTE *Pin and socket contacts may be inserted in either the bulkhead or plug or they may be intermixed in each connector to provide additional keying combinations.*

3.4. Extracting Contacts

Extraction Tool 318851-1 is available for removing pin and socket contacts from plug and bulkheads. Refer to 408-4371 for extraction procedure.

4. HARDWARE REPLACEMENT

Customer-replaceable parts are listed in Figure 3. A complete inventory should be stocked and

controlled to prevent lost time when replacement of parts is necessary. Parts other than those listed should be replaced by Tyco Electronics to ensure quality and reliability. Order replacement parts through your representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
 TYCO ELECTRONICS CORPORATION
 PO BOX 3608
 HARRISBURG PA 17105-3608

DESCRIPTION	CONNECTOR	
	4, 6, AND 9 POSITIONS	12 POSITIONS
O-Ring	1604260-2	1604260-1
Locknut	1604261-2	1604261-1

Figure 3

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements