

Figure 1

1. INTRODUCTION

This instruction sheet provides termination and assembly procedures for the Snap-Lug Power Connector. The Snap-Lug socket contact will accept copper conductors only and are compatible with the conductor wire sizes shown in Figure 2. Refer to Figure 2 for crimp tooling details referenced in Figure 4.

The first part of these instructions begins with procedures for the socket contact kit, while the second part of this instruction sheet provides instructions for the post contact kit. See Figure 1.

CONDUCTOR SIZE (AWG)	SOCKET CONTACT KIT	STRIP LENGTH ± 1.27 [.050]	MAX STRANDED CONDUCTOR DIA	PICO CRIMP TOOL	LOCATOR	CRIMP HEAD TOOL PART NUMBER	DIE CLOSURE DIMENSION
4	2226934	21.59 [.850]	7.00 [.275]	500-D-EC	10344	514DA-6934	5.84 [.230] (4 Indenter)
1/0	2226742	24.13 [.950]	12.06 [.475]		10345	514DA-6742	6.60 [.260] (4 Indenter)
2/0			14.6 [.575]			514DA-6743	7.62 [.300] (4 Indenter)
3/0	2828522						



NOTE

- The crimp termination and performance will meet MIL-C-22520 requirements.

Pico is a trademark.

Figure 2

2. INSTALLATION PROCEDURES

Select the conductor size and choose the contact kit according to the application.

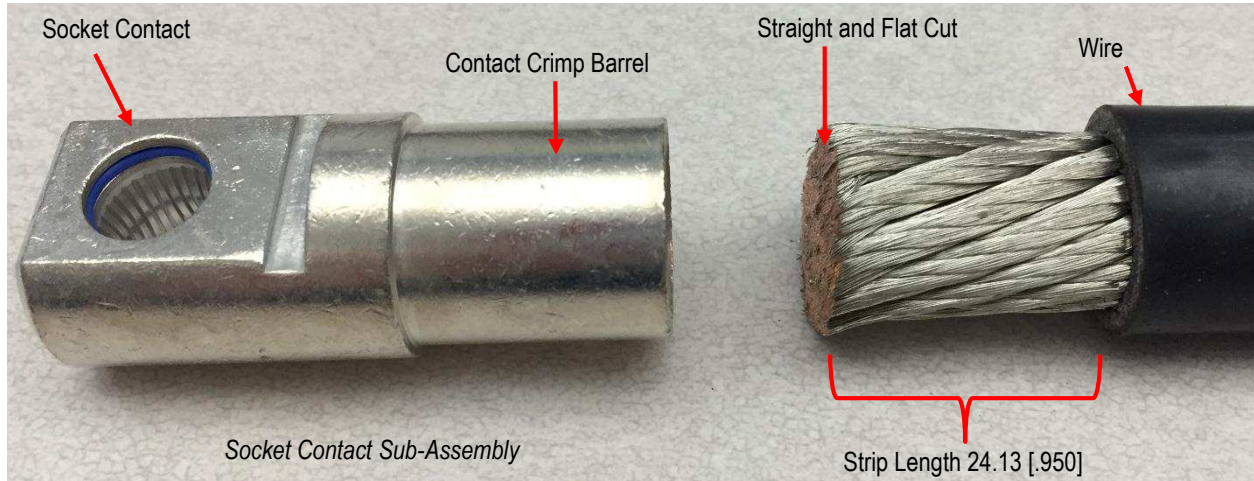
2.1. Cable Preparation

Strip the conductor to the dimension given in the table in Figure 2. Ensure that the wire ends are straight and flat before installing into the crimp barrel of the contact. See Figure 3.



CAUTION

Avoid nicking or cutting the conductors. Laser stripping is recommended to avoid damage to the individual conductors.



NOTE: 3/0 Socket Contact Body Shown

Figure 3

2.2. Contact Crimp Termination

1. Insert the conductor into the contact crimp barrel until it stops against the bottom of the crimp barrel.
2. Choose the crimp die and locator according to the conductor selection in Figure 2.
3. Assemble the locator and crimp die into the Pico crimp tool.
4. Be sure the conductor is fully installed in the crimp barrel
5. Insert the contact body and conductor into the crimp die and locator as show in Figure 4.

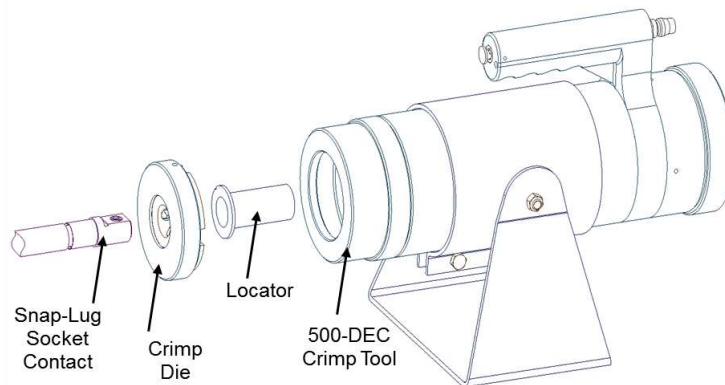


Figure 4

6. Hold firmly and cycle the crimp tool when the contact and conductor is fully bottomed in the locator. Refer to Figure 5 for example after crimp operation.



Figure 5

Pico is a trademark.

2.3. Crimp Inspection

SOCKET CONTACT WIRE SIZE (AWG)	WIRE SIZE (AWG)	TENSILE STRENGTH (lbs) (MIL-C-39029)	CRIMP HEIGHT (in.) (REF ONLY)
4	4	400	.244
1/0-2/0	1/0	700	.296
	2/0	750	.305
3/0	3/0	825	.353

NOTE: Crimp heights can vary depending on the wire selected for the application. Therefore, the above crimp height data should only be used as a reference.

Figure 6

2.4. Housing and Contact Assembly

A. Heat Shrink Tubing

The minimum cut length of shrink tubing is 63.5 mm [2.50 in.].

B. Dual Wall and Single Wall

Dual or single wall heat shrink tubing may be used. If a single wall tubing is used, it is recommended to use adhesive under the heat shrink tubing. The adhesive can be in a paste epoxy form or an adhesive tape. For adhesive selection information see TE Adhesive Installation Guide 2-1773464-2 or contact your local TE Sales Rep. or Field Application Engineer.

C. Procedure

1. Slide the heat shrink tubing over the connector and onto the cable as shown in Figure 7.
2. Insert the socket housing sub-assembly into the socket contact until it latches with an audible and tactile “click”. See Figure 8

NOTE: 3/0 Contact Shown

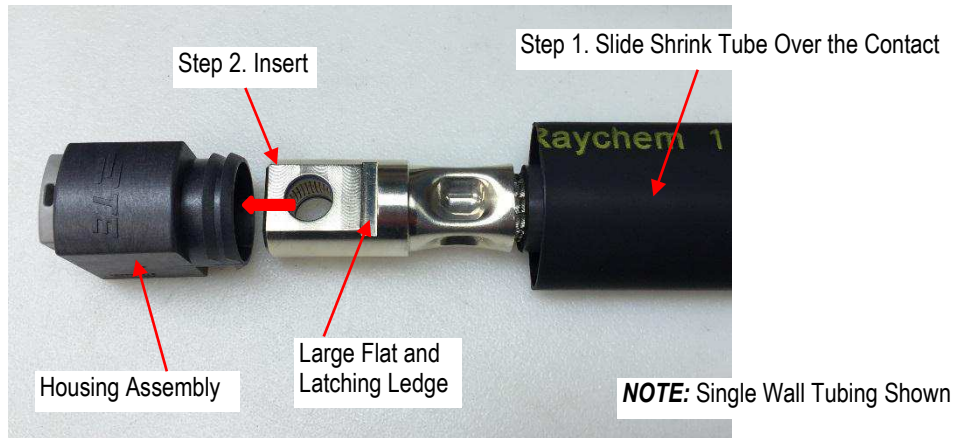


Figure 7

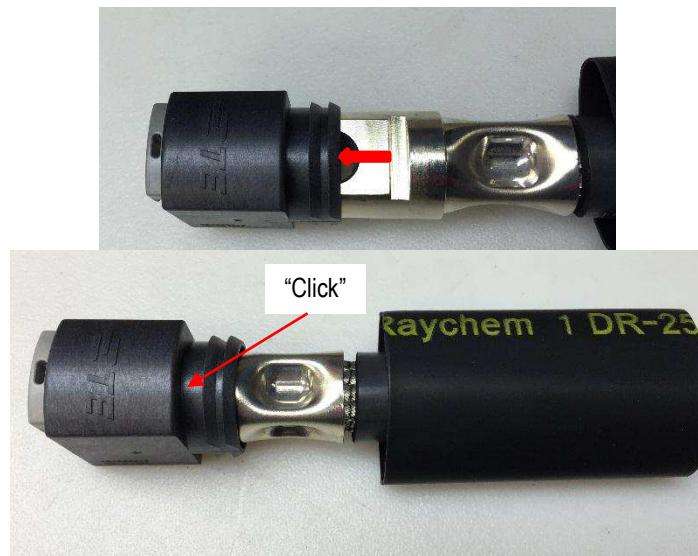


Figure 8

2.5. Heat Shrink Tube Placement and Recover

A. Placement

Slide the heat shrink tubing over the rear of the housing until the tubing is in contact with the housing wall. The housing retaining rings will retain the heat shrink tubing for sealing and strain relief.

B. Recovery Process

Once the heat shrink tubing is properly located, the recovery process may begin. Refer to Figure 9

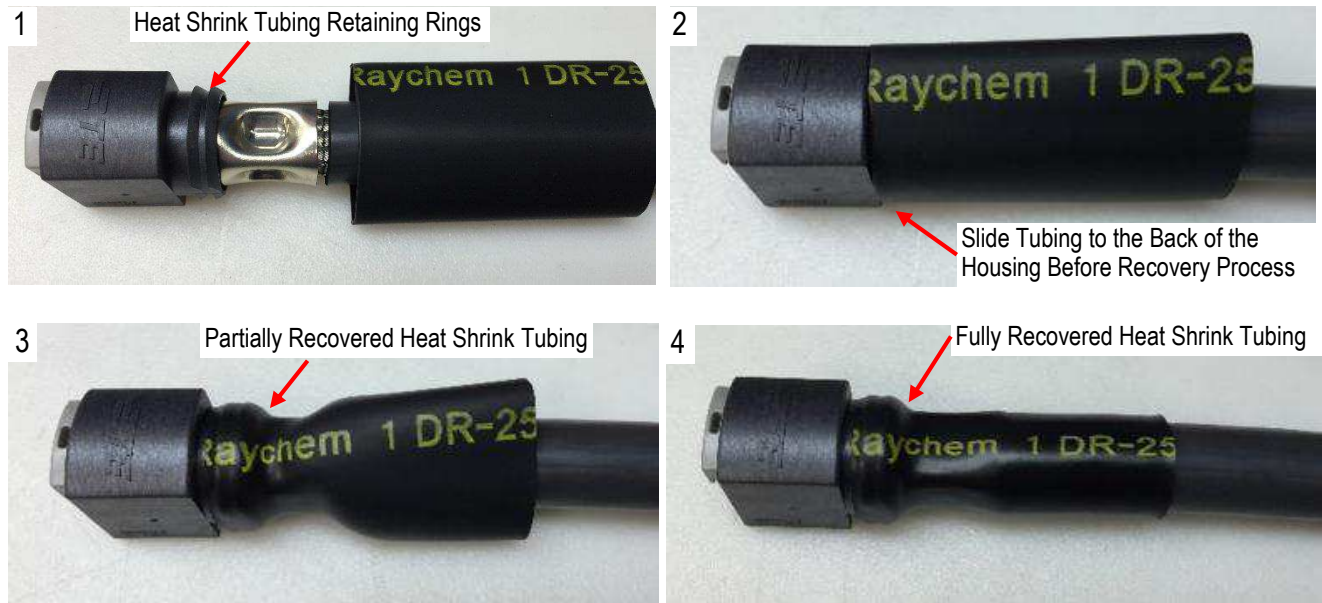


Figure 9

3. POST CONTACT KIT: INSTALLATION AND ASSEMBLY PROCEDURE

1. Thread the post contact on the bus bar and torque to [200 in.-lb.].
2. Install keying ring over the hex-nut area.
3. Push the keying ring firmly over the hex-nut until the audible and tactile “click”. See Figure 10.

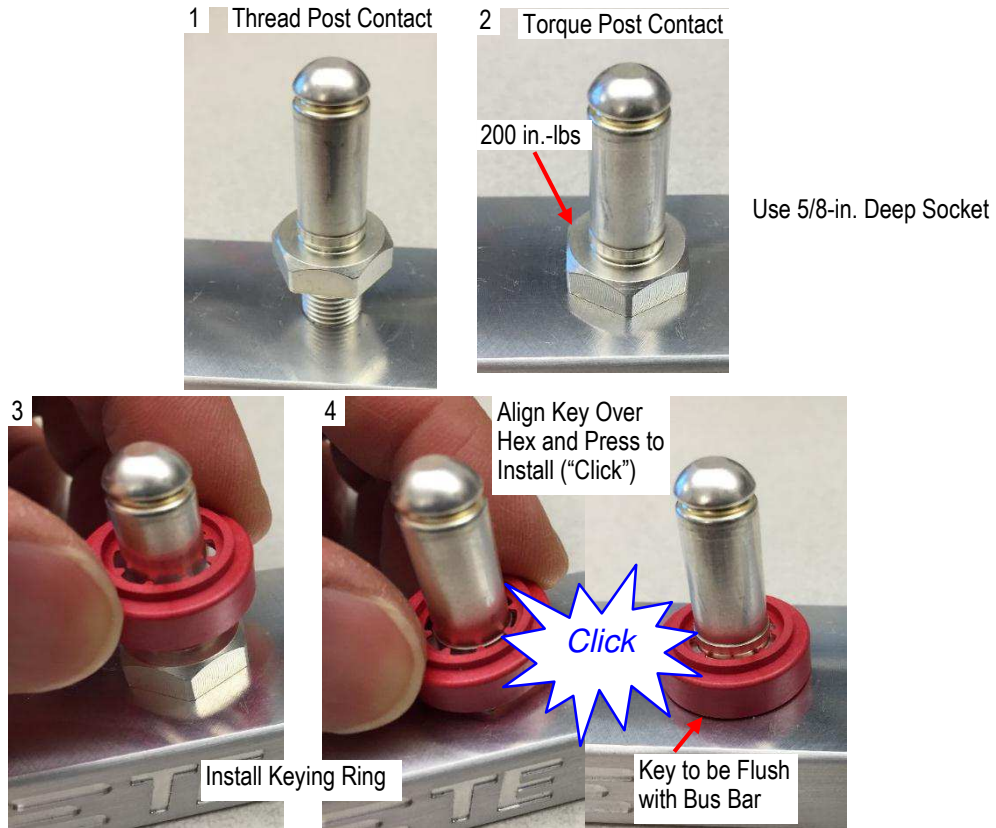


Figure 10

4. REVISION SUMMARY

- Initial release of document