

## 0.64III Plug Housing

### 1. PART NAME AND PART NUMBER

#### 1.1. Housing

Part Number	Part Description
2237147	0.64III 8P 1Row Plug Housing
2237049	0.64III 16P Plug Housing
2237152	0.64III 16P Plug Housing, Short Body

Fig. 1

**NOTE** Part number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted.

#### 1.2. Contacts

Applicable female contacts are listed below (See Fig.2)

Part No	Part Name	Wire Type (O: Applicable, -: Not Applicable)					
		Type	0.13	0.22	0.3	0.35	0.5
1674311	0.64III Receptacle (Female Contact)	AVSS/CAVS/CAVUS/ AVSSH-f	-	-	O	-	O
		CIVUS/CHFUS/ CHFSS/HFSS-f	-	-	O	-	O
1674936		CIVUS/CHFUS/ CHFSS	-	O	-	-	-
1827483		CIVUS/CHFUS	O	-	-	-	-

Fig. 2

**NOTE** Applicable wire is this manual may be subject to change on the results of additional testing and evaluation.

### 2. CUSTOMER RECEIVING INSPECTION

We conduct inspections according to our quality control regulations to maintain an overall lot control. In addition, customers should conduct receiving inspections based on the specific customer drawing.

### 3. STORAGE AND CARRYING

- (1) Avoid storing the housing in a moist or dusty place. Stock the housing in a comparatively dry and clean place (5~35°C, 45~85%RH) away from direct sunlight.
- (2) Avoid leaving or carrying the housing in an open area without packaging
- (3) Do not drop or shock the housing when carrying it.

## 4. HARNESS MAKING

### 4.1. Procedure for Female Contact Insertion into Housing

- (1) Confirm the retainer is in pre-assembled condition. When the retainer is in final lock condition, it must be unlocked to pre-assembled condition. (See para 4.3) The contact cannot be inserted in final lock conditions.

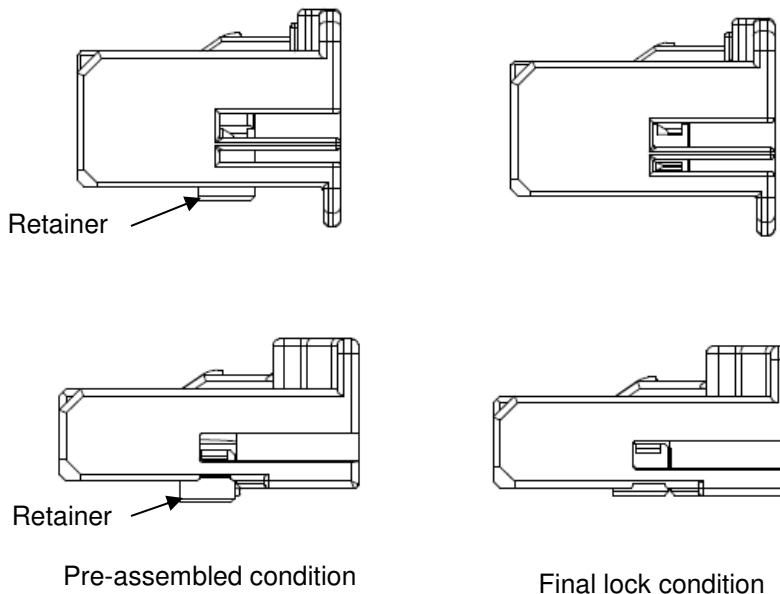


Fig. 3

- (2) Confirm type of plating on the contact. It must be the same type of plating on the female contact and the male contact. The type of plating can be seen on the customer drawing.

**NOTE** Connection between different types of plating should never be allowed.

- (3) Insert the contacts into the housing with same direction as shown in Fig. 4. The insertion is finished when the lance is locked and the contact cannot be inserted.

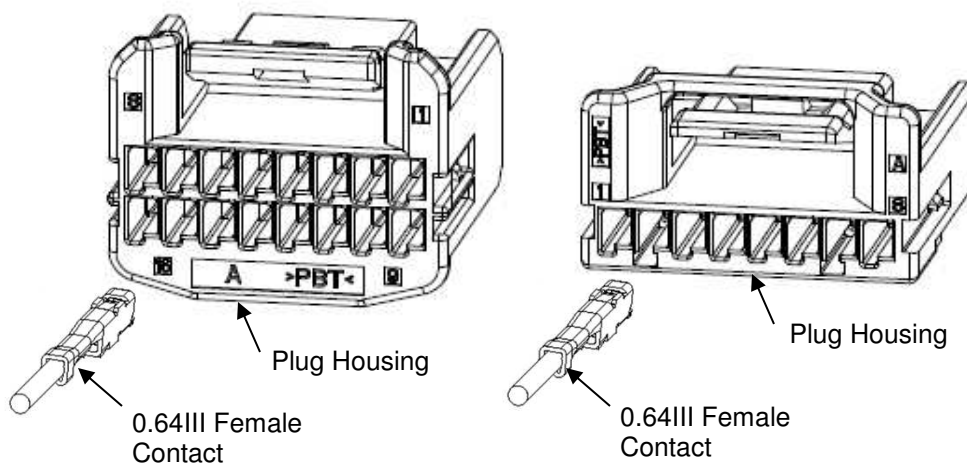


Fig. 4

- (4) By pulling the contact by 20N Max, check to make sure that the contact cannot be withdrawn.

#### 4.2. Double Lock (Secondary Lock) Operation

- (1) After insertion all the contacts, press the retainer for final lock condition. The double lock operation is finished by confirmation that the retainer is kept in the final condition by the 2 projections.

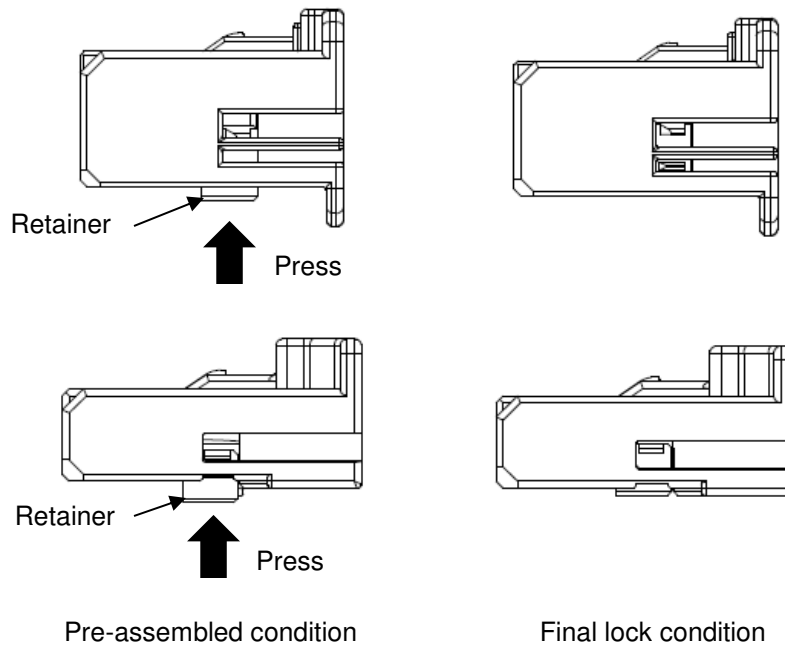


Fig. 5

- (2) The double lock operation cannot be completed if there are any half-inserted contacts. When the retainer cannot be pressed to the final condition, do not press by force, find the half-inserted contact and insert it to proper position. (See para 4.1)

#### 4.3. How to Unlock Retainer from Final Lock Condition

When the female contact requires insertion or extraction, the retainer must be in the pre-assembled condition. The insertion or extraction cannot be done in final lock condition.

- (1) Insert the jig, 1mm blade screw driver, into the window of the retainer pointed by the tear drop mark. (See Fig 6)
- (2) Draw out the retainer to pre-assembled condition.

**NOTE** Do not extract the retainer more than appropriate length. Otherwise the retainer may be damaged.

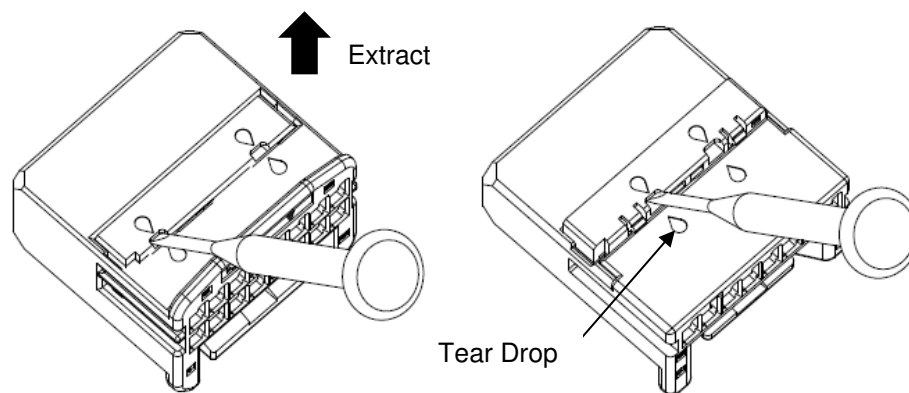


Fig. 6

#### 4.4. How to Extract Female Contact

- (1) Confirm the retainer is in pre-assembled condition. When the retainer is in final lock condition, it must be changed to pre-assembled condition. (See para 4.3) The female contact cannot be extracted in final assembled condition.
- (2) To extract the female terminals, using the extraction tool PN: 1729375-1 is recommended. Follow the instruction sheet No. 411-78139 to use the extraction tool. If the extraction tool cannot be prepared, insert a precision screw driver which is 1.4mm ~ 1.8mm width into the proper hole to the end, remove the loaded contact from housing while pulling the crimped wire. (See Fig.7)

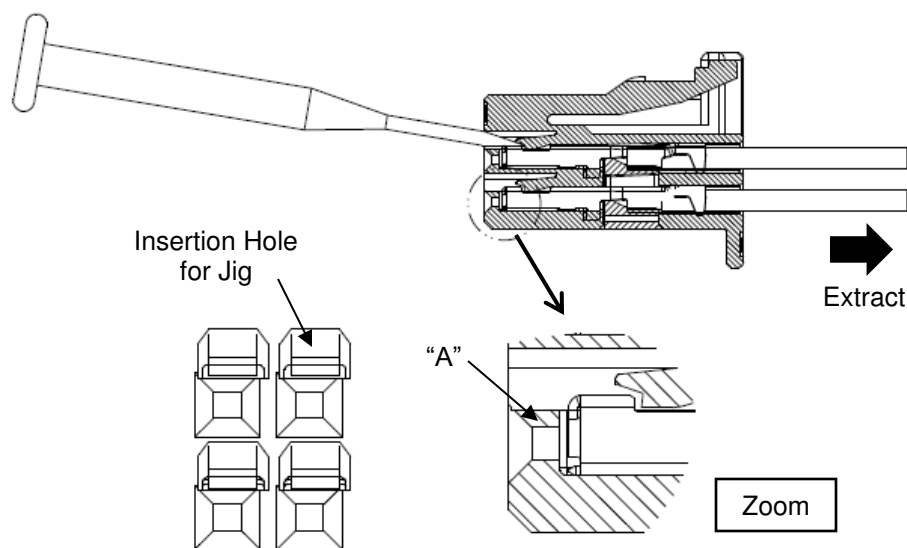


Fig. 7

**NOTE** Please do not apply unnecessary force to the wall "A". It becomes the cause of breakage.

**NOTE** If only insert the jig, the primary terminal latch will be released. Take care not to apply unnecessary force, otherwise the deformation of the jig occurs or it is cause for falling of retention force by the deformation of the housing lance. And do not repeat extract more than 10 times, otherwise the retention force will fail.

- (3) When the female contact cannot be extracted, do not pull the wire by force but ensure the housing lance is unlocked.

**NOTE** Take care not to insert the screwdriver or the extractive jig into the female contact. If those should be inserted, the female contact must be replaced. Re-using is never allowed.

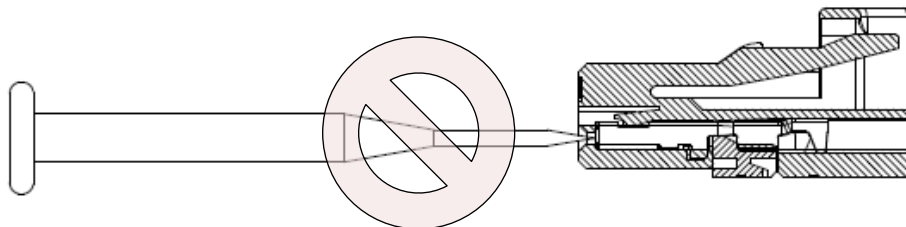


Fig. 8

#### 4.5. Harness control

##### (1) Handling

Take care not to apply unnecessary force or shock to the connector or the wire

##### (2) Taping up wires

The wires must not be taped up to 30mm from the end of the housing to avoid applying unnecessary force to the wires.

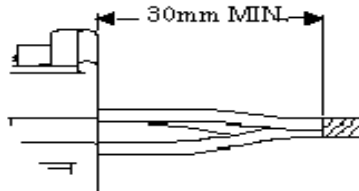


Fig. 9

##### (3) Electric circuit check

1. For making a check on electric circuit, the applicable mating connector or equivalent product should be used.
2. When servicing the connector, never insert an individual probe pin for the inspection into the female contact. The pin must be probed from the wire side.

**NOTE** If the probe pin should be inserted, the female contact must be replaced.

3. Please report to our company the treatment device for energizing inspection use.

##### (4) Storage

Avoid storing the connector in moist or dusty place. Stock the connector away from sunlight.

##### (5) Shipping and carrying

The connector should be used with the proper packaging to prevent ingress of dust, moisture, etc.

## 5. MATING AND EXTRACTION OF CONNECTOR

### 5.1. Mating of Connector

- (1) Check to make sure that the contacts are inserted into the housing in proper condition, the wires are taped up from proper position and the retainer is in final lock condition. If the retainer is in pre-assembled condition, it must be changed to final lock condition. (See para 4.2)
- (2) Check the contact and housing to make sure there are defects, deformation, discoloration, damage, rust, crack, deficit, etc.

**NOTE** The connector must be renewed if any defects are found.

- (3) Insert the proper female housing into the male connector straight. The operation is finished when you hear the click sound and cannot insert further. When you cannot insert the housing, do not insert by force, check the items in (1) and (2).

**NOTE** At the insertion operation, take care not to apply force except in the insertion direction.

- (4) By pulling the female housing lightly, check to make sure that the connector cannot be withdrawn.

## 5.2. Extraction of Connector

Grip the female housing and then draw straight out while pressing down the locking lever. When the housing cannot be drawn out, do not pull it by force but check to make sure if the locking mechanism is released.

**NOTE** At the extraction operation, take care not to apply force except in the extraction direction

**NOTE** Do not pull the wire only.

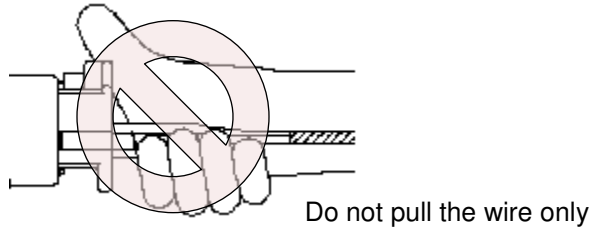


Fig. 10

## 5.3. General Attention Matters

- (1) Do not mate and extract the connector unnecessarily.
- (2) Do not insert any objects except the proper connector.
- (3) At mating/extraction operation, or after mating operation, take care not to apply unnecessary force or shock to the wire and the connector