

AMP* "250" FLAG POSITIVE LOCK CONNECTOR

旗型ポジティブ・ロック・コネクタ

Contents

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When only one of above versions is supplied to customers, this top sheet shall be attached.

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カスタマーに英語または日本語版の片方のみを提出する場合は、このトップシートが必ず添付されなければならない。

Revision Record (改訂記録)

Revision Letter (改訂記号)	EC number (改訂記録番号)	Date (日付)
01	FJ00-1348-00	25 AUG 2000

Outline of the latest revision (最新改訂の概要)

Combine two language versions into one document. No change was made on product specification. Change document number to current format..

2ヶ国語の文書を一括管理とした。仕様内容に変更なし。



AMP* "250" FLAG POSITIVE LOCK CONNECTOR

INSTRUCTION SHEET

411-5212 (was IS-212J)	
Released	8-25-82
Revised	25 AUG 00

Rev.01

This instruction sheet covers handling and assembly procedure of AMP* "250" Flag Positive Lock Connector. Read this instruction sheet carefully before you start assembly.

1. NOMENCLATURE OF COMPONENT:

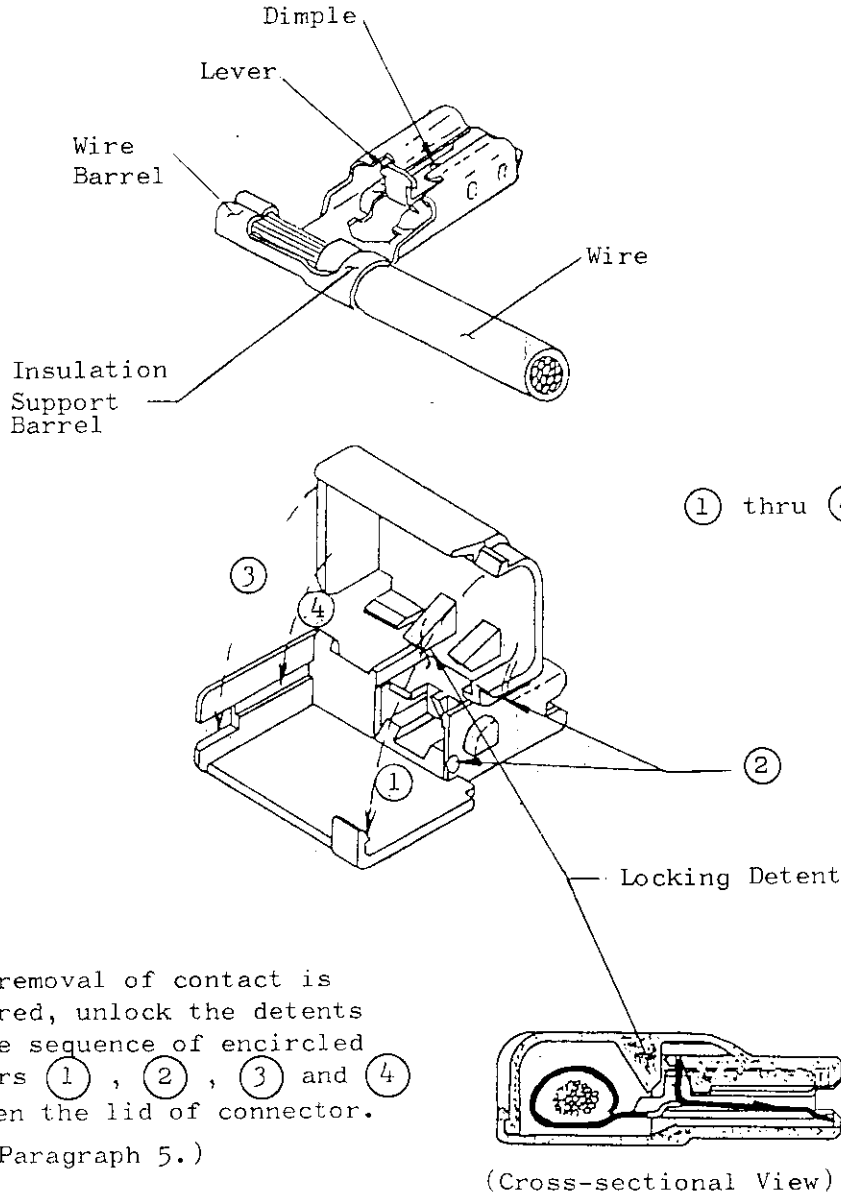
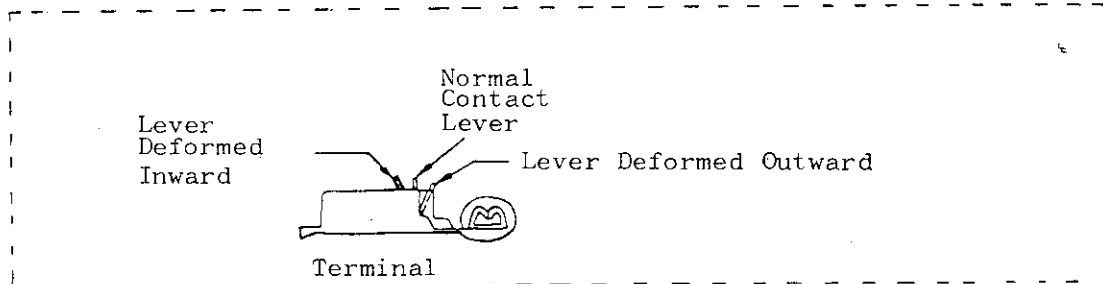


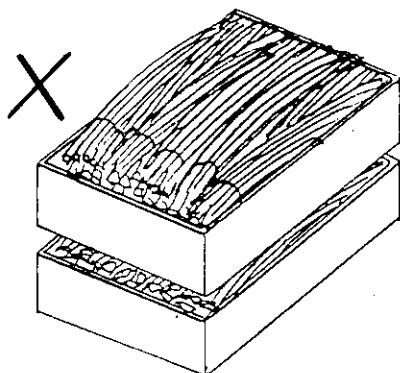
Fig. 1

1. HANDLING DURING CRIMPING OPERATION AND TRANSFER:

To maintain optimum function of contact locking/unlocking mechanism, it is very important to keep the lever intact as supplied. Since this portion of the part is sticking out somewhat outside of the terminal body, it is sensitive to mechanical deformation affected by the undue forcing load during handling. DO KEEP THE LEVER INTACT!



NEVER ATTEMPT STACKING A BULK CONTAINER DIRECTLY!



Carrying in a Bulk Container:

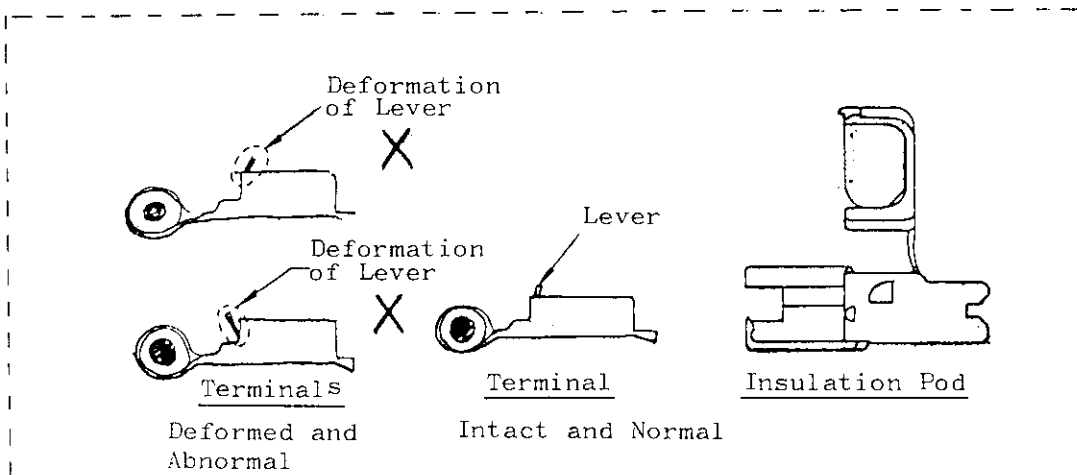
By assembly operation reasons, crimped leads may be often transferred in a bulk container.

In such cases, never handle them roughly, lest it should result deformation of contact lever during transportation.

Avoid stacking a large number of leads in a bulk container without proper protection.

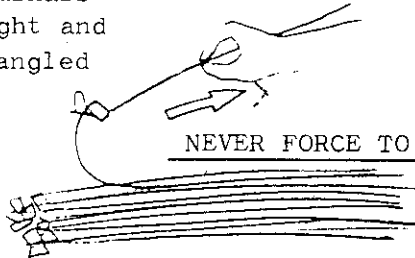
Containers must be dry, clean and sturdy enough, and never to be stacked directly as shown in the sketch (left).

2. INSERTION OF CONTACT LEAD INTO INSULATION POD:



Ravelling Bundles of Terminal Leads:

Terminals
Caught and
Entangled



NEVER FORCE TO SEPARATE!

When ravelling bundles of terminal leads, catching and entanglement of terminals may often occur.

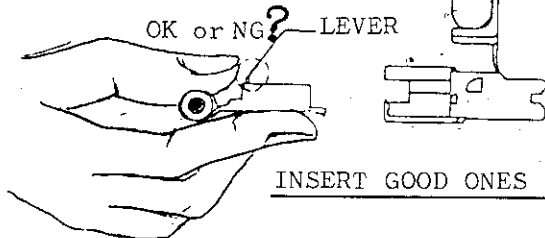
BE PATIENT TO SEPARATE CAUGHT AND ENTANGLED TERMINALS!

SEPARATE THEM CAREFULLY!

Remember, your short-tempered jerk will spoil the parts.

Assembly Insertion into Insulation Pods:

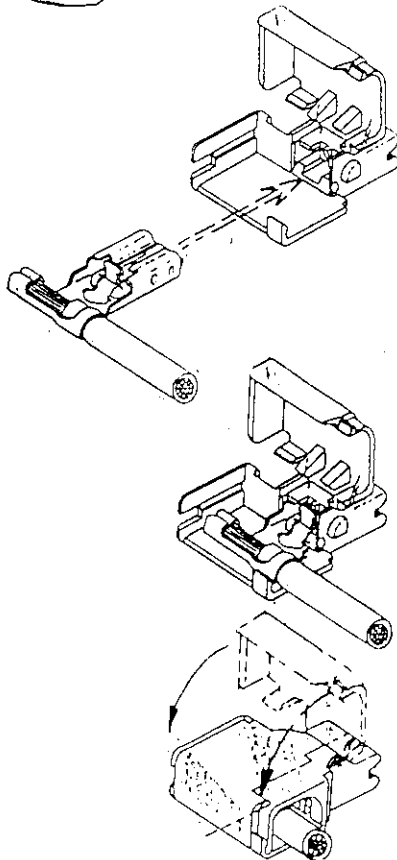
CHECK TO SEE IF THE
LEVER IS ALRIGHT!



INSERT GOOD ONES ONLY!

At the step of inserting crimped terminals into the insulation pods. Be alert to check off the defective terminals having deformation of contact lever.

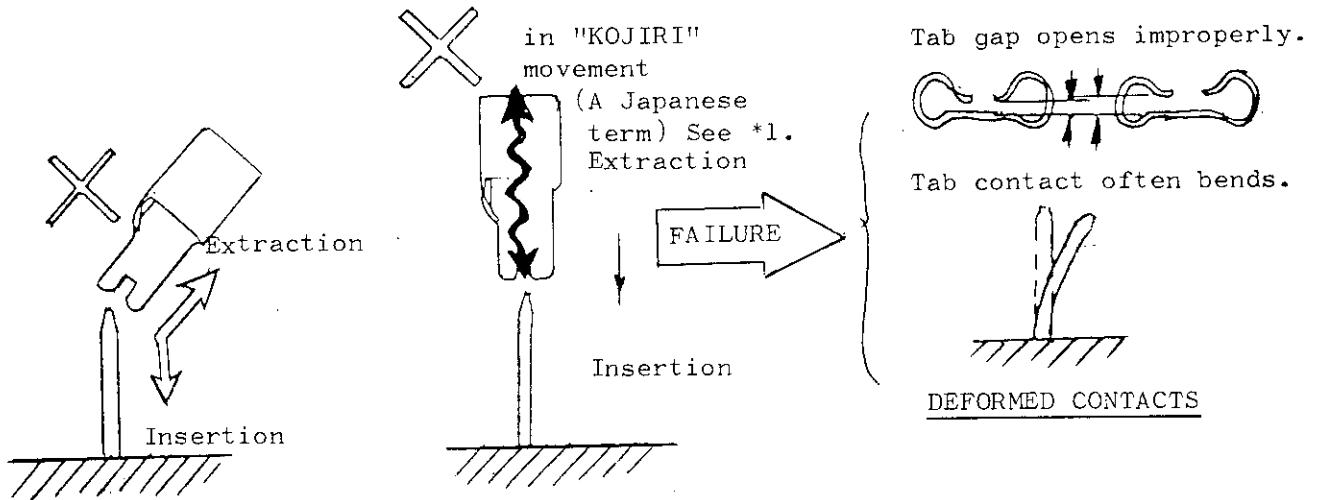
Discarding defective parts is the best policy to maintain the stable reliability!

ASSEMBLY PROCEDURE OF TERMINAL INSERTION INTO INSULATION PODS:

1. Place crimped terminal in a proper position readily facing to the entry of opened insulation pod as shown.
2. Put the crimped terminal on the lower enclosure of the insulation pod, where the flag portion of the contact is seated snug with the tab entry side of the contact and is bottomed in the slit of tab entry side of the pod.
3. Flap the upper enclosure (lid) of the pod over the inserted terminal, and fit on the lower enclosure until it is locked firmly by the proper engagement of locking detents with a small clicking sound.
4. Make sure if the inserted terminal and engagement of the enclosures appear normal and just fitting.

3. MATING AND UNMATING OF TAB CONTACT:

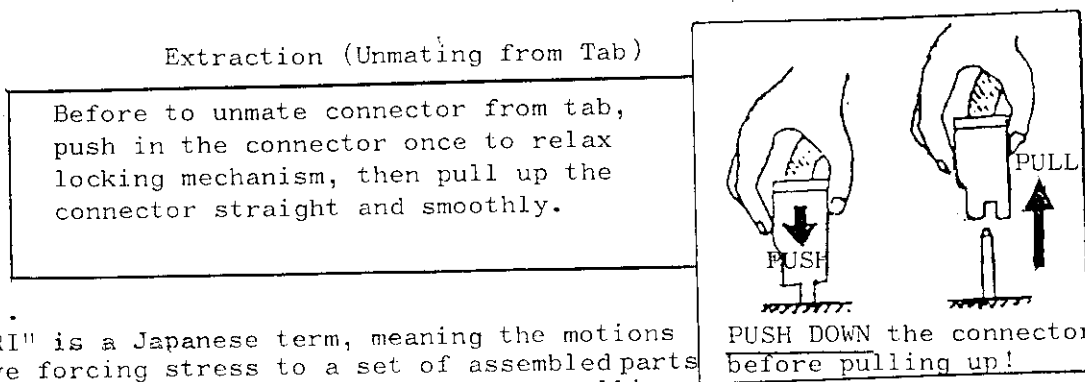
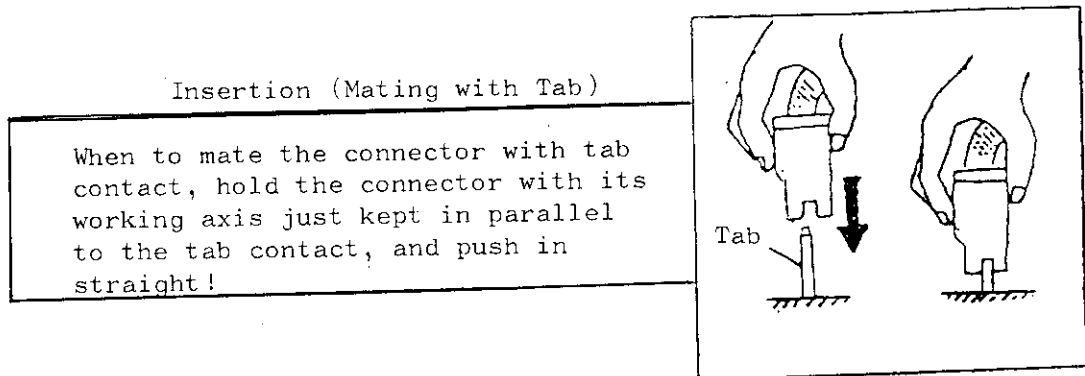
During mating and unmating operation, care must be taken to keep the direction of insertion/extraction movement of contacts just in parallel to the contact working axis. If the movement direction is amiss to the working axis, undue forcing load will cause deformation of contacts, resulting undesirable problems to the connector performance.



Mating/unmating direction is not parallel to the contact working axis. Worked forcibly.

Repeated undue forcing load, applied to the contacts and housing during mating and unmating, will cause ill-affection to the parts.

The ill-affected contacts often fail to deformation. Such bending deformation deteriorates product performance largely.

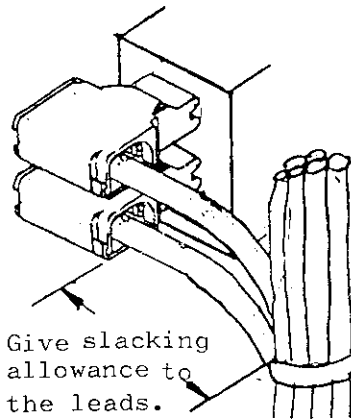


Note 1.
"KOJIRI" is a Japanese term, meaning the motions to give forcing stress to a set of assembled parts in such manners of twisting, bending and rolling applied in the directions amiss to working axis.

(4) ASSEMBLY HANDLING OF CONNECTOR:

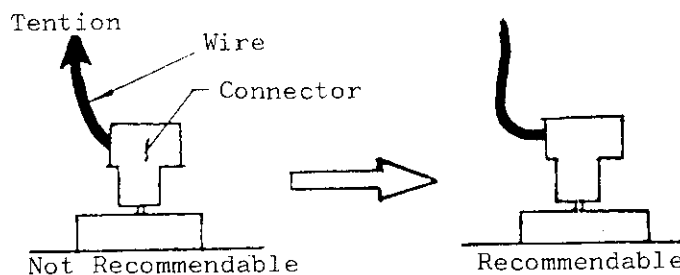
Some important instructions should be observed during assembling operation, in order to prevent from undesirable deteriorating problems to occur especially when terminated on thick and rigid wires.

For easy insertion/extraction movement of connector, give proper slacking allowance to the leads coming out of the connector.

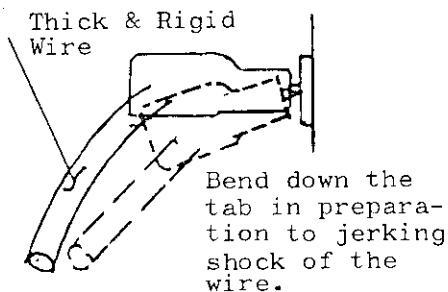


Approximate recommended slacking length is 70mm minimum, from the connector entry.

Avoid keeping connector in the condition where weight and tension is applied to the terminated contact and connector.

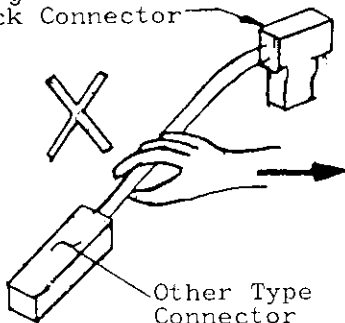


When thick and rigid wire is terminated, round the lead wire to slacken the tention to the contact.



Thick and rigid wire will load its weight on the contact heavily and directly, which may cause bend of contact. To normalize this tention, it is recommended to make a preparatory bend to the contact downward, preventing from failure to occur in the tab contact. It is also effective to make a round of wire at the portion next to connector entry.

Flag Positive Lock Connector



When extracting connector, do not unmate by pulling the WIRES. Be sure to unmate by HOLDING THE CONNECTOR!

Undue careless jerk will spoil the performance of your connector!

(5) REMOVAL OF CONTACT FROM CONNECTOR:

When removal of contact is required, unlock the four locking detent by fingers, and remove the contact. Contact can be taken out without use of tooling.

The unlocking sequence is ①, ②, ③ and ④, the encircled numbers in Fig. 1.

411-5212 (was IS-212J)	
作成年月日	8-25-82
改訂年月日	25 AUG 00

この取扱説明書は、旗型ポジティブ・ロック・コネクタの取扱方法について説明しています。御使用前によくお読み下さい。

部品各部の名称

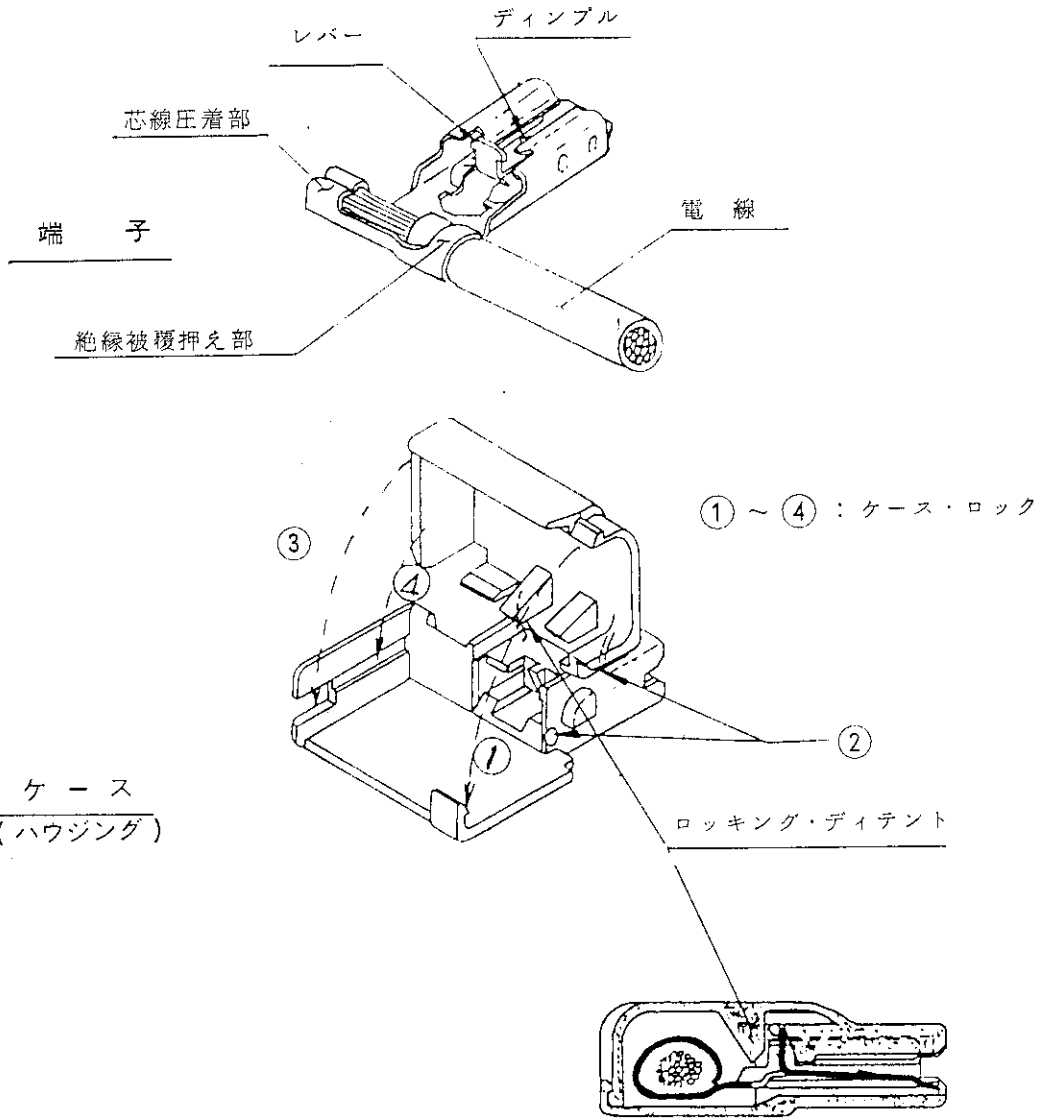
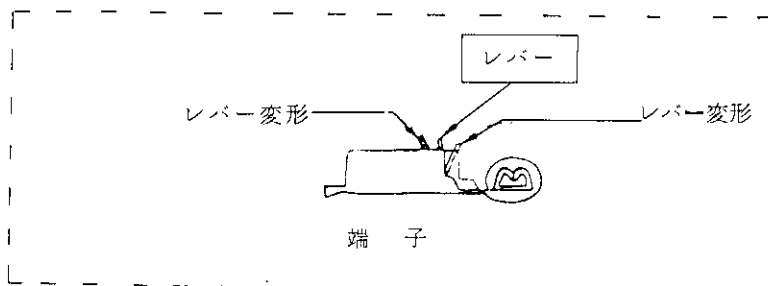


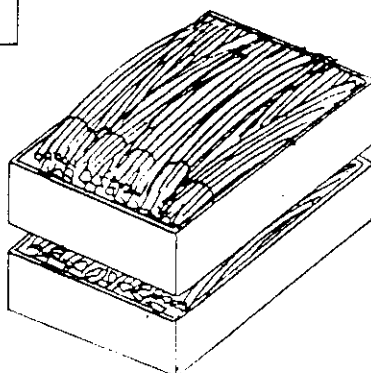
図 - 1

〔1〕 圧着作業

圧着作業時にレバー部の変形に充分注意して下さい。

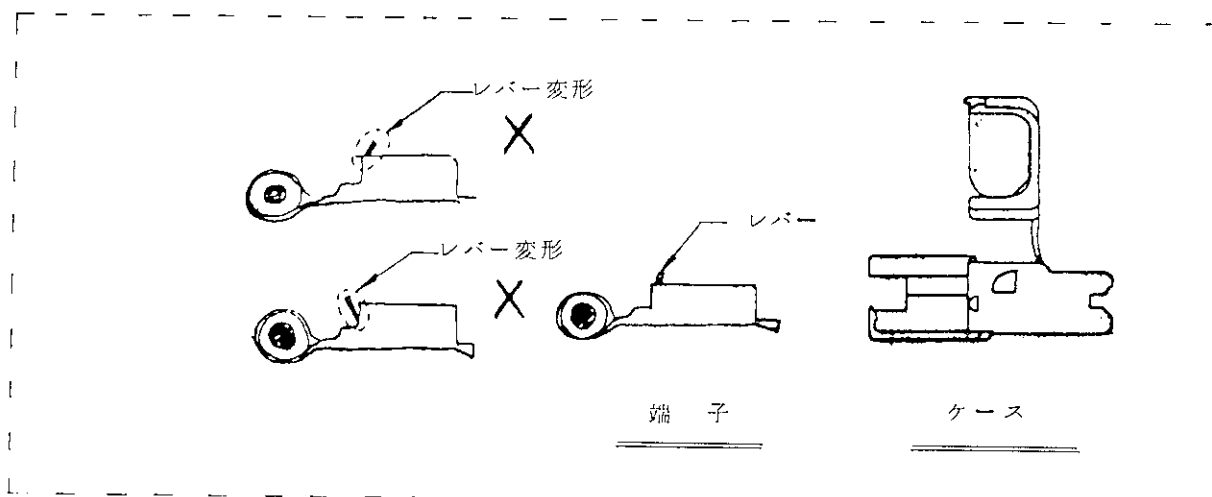


1 箱積み

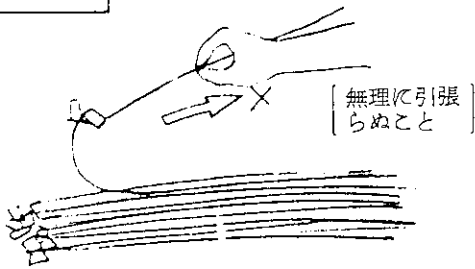


箱入れの際，束にした電線を丁寧に扱って下さい。又箱積みの際，電線を山積みになると端子に過剰な荷重がかゝり，レバー部が変形してしまふことがあります。

〔2〕 ケース入れ作業

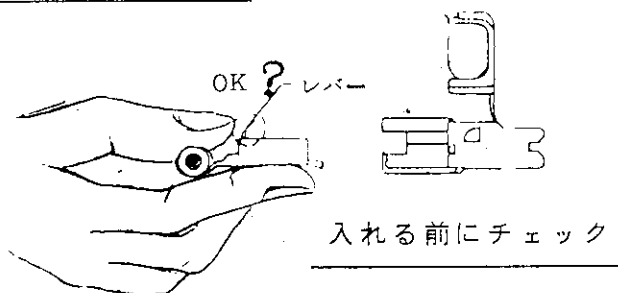


1 束線のほぐし



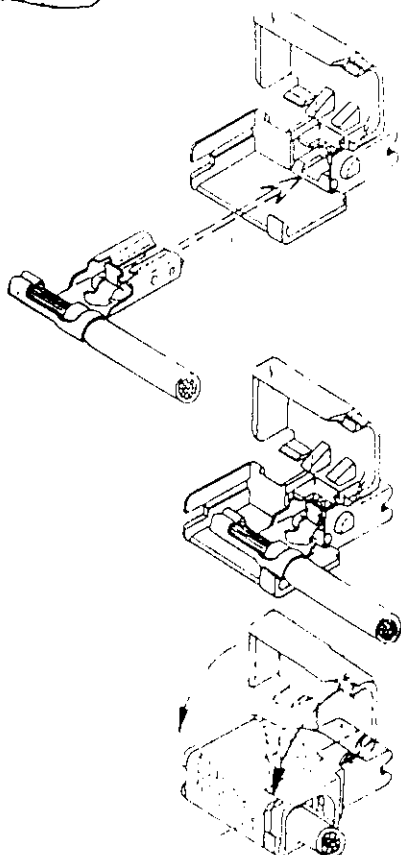
束線をほぐし，束から電線を取り出す時，端子どうしがからんだら無理に引張らないで下さい。

2 ケース入れ



端子をケースに入れる前に端子を見てレバー変形をチェックして下さい。

レバー部が変形している製品は不良品です。“使用しないで下さい”

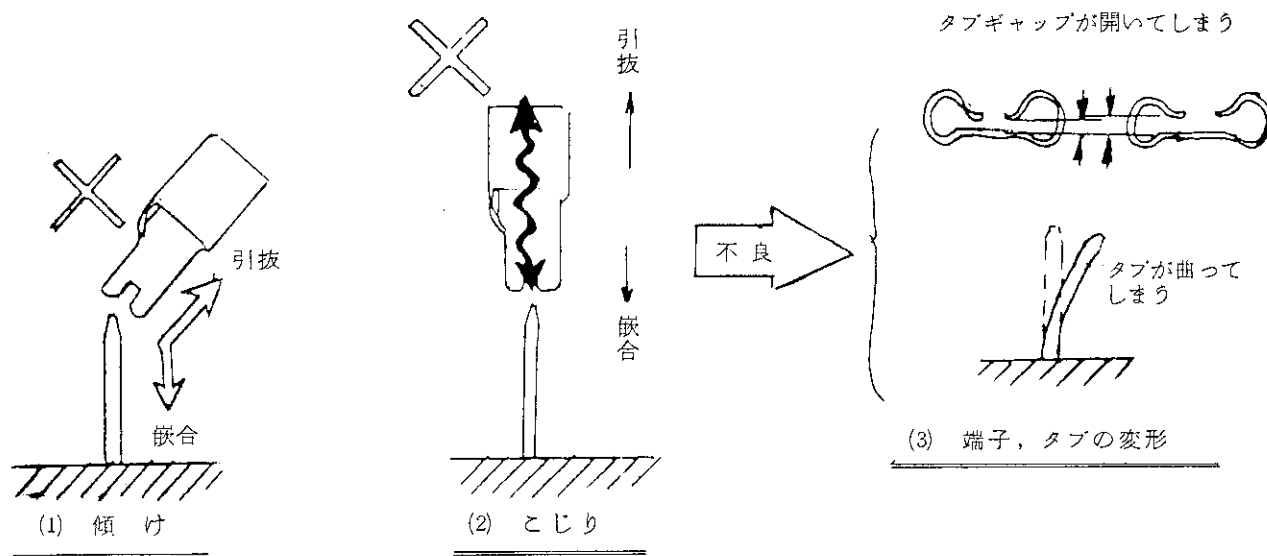


ケース入れ手順

- i) ケースに対し端子を正しい向きに置く。
- ii) ケースに仮挿入する。
- iii) 4ヶ所のケースロックで確実にフタを閉める。

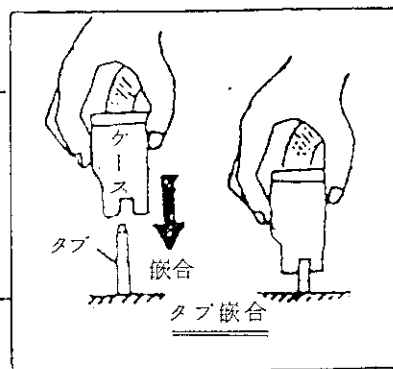
〔 3 〕 タブ 嵌合 ・ 引 抜 作 業

コネクタのタブ嵌合，引抜作業において，コネクタを傾けたり⁽¹⁾，こじりながら⁽²⁾作業すると，端子又はタブを変形させてしまい⁽³⁾，接触不良発生の原因となります。



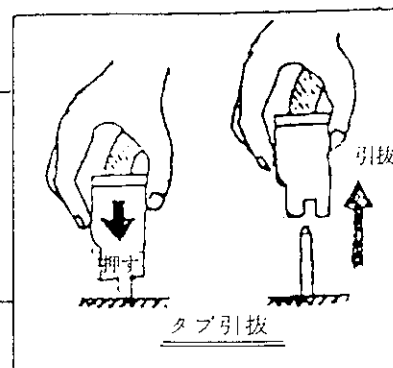
① タブ 嵌 合

コネクタをタブに嵌合させる時は，ケースを持ってタブに対してまっすぐに嵌合させて下さい。



② タブ 引 抜

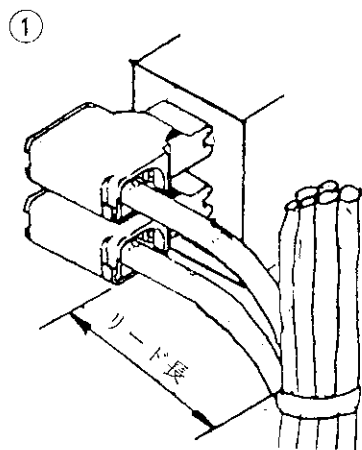
コネクタをタブから引抜く時はケースを持って必ず一度タブ側へ押してからタブに対してまっすぐに引抜いて下さい。



〔4〕 ハーネス実装

ポジティブ・ロック・コネクタのハーネス実装状態において、コネクタにテンションがかゝると接触部及びロック機能に悪影響を及ぼすことがあります。

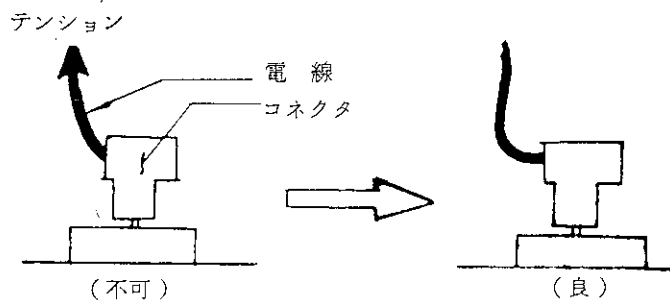
① 電線のリード長



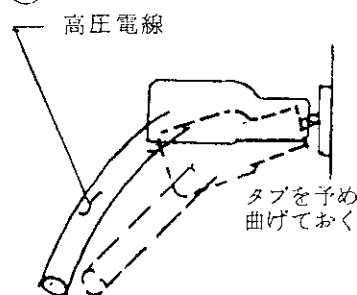
〔リード長は電線の太さによって異なるが、約70mm程度〕

コネクタが容易に抜き差し可能なように、リード長を充分とって下さい。

コネクタに常にテンションがかゝっている状態は避けて下さい。



②

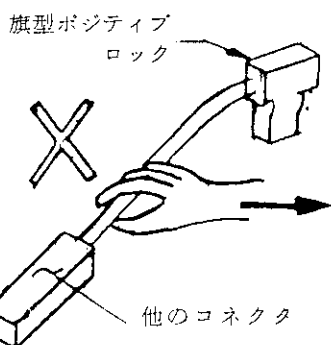


② 太い電線使用時

電線が太いとテンションが大きくなる傾向があるため、その場合は、

- * 電線の曲げRを大きくとるか、
- * タブをあらかじめ曲げて下さい。

③



③ コネクタの抜き差し作業

他のコネクタを抜き差しする際、電線が引張られて、ポジティブ・ロック・コネクタにテンションがかゝる場合があります。

作業時、電線を強く引張らないように注意して下さい。

〔5〕 端子の取り出し

ケースから端子を取り出す場合は、治工具は必要とせず、手指で4ヶ所のケース・ロックを①、②、③及び④の順序で外して下さい(図-1を参照願います)。