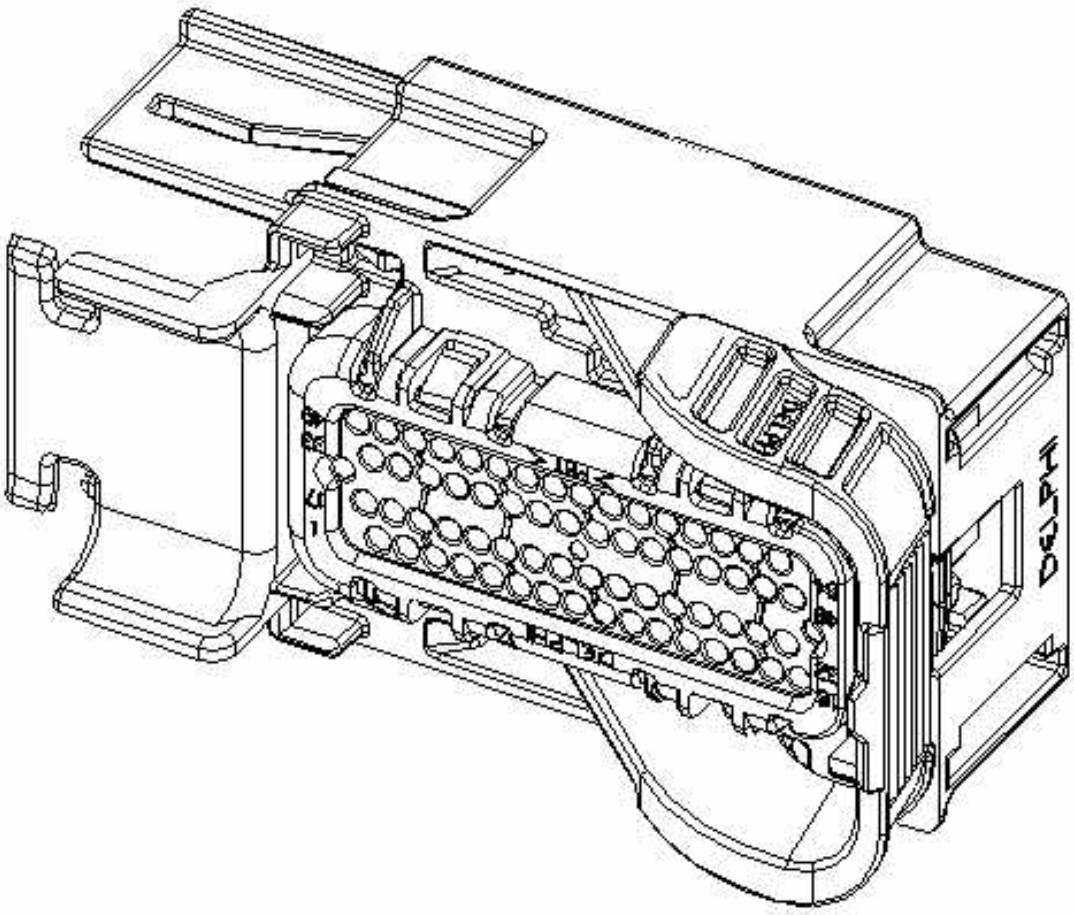
ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY



NOTE: PLEASE CONTACT YOUR DELPHI SALES REPRESENTATIVE WITH ANY QUESTIONS OR COMMENTS CONCERNING THESE ASSEMBLY INSTRUCTIONS. COMPONENT P/N'S AND REPAIR TOOL P/N'S ARE AVAILABLE FROM YOUR DELPHI SALES ENGINEER.

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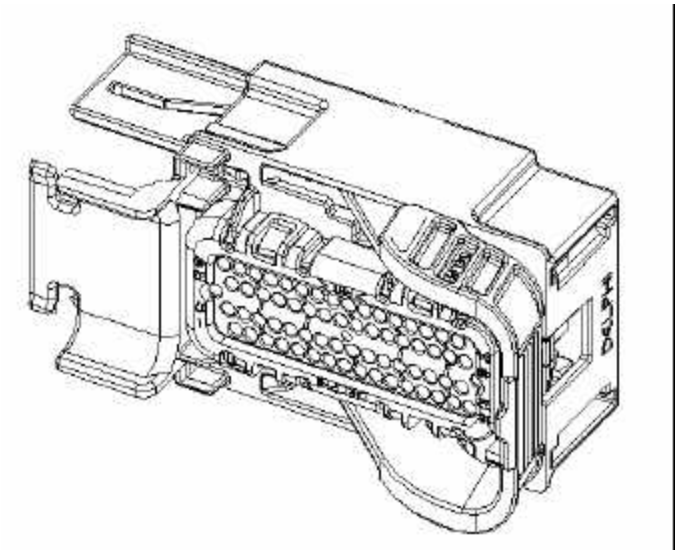
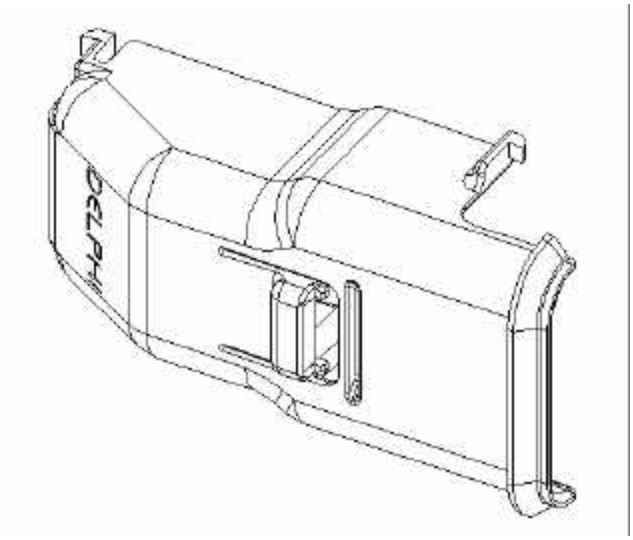
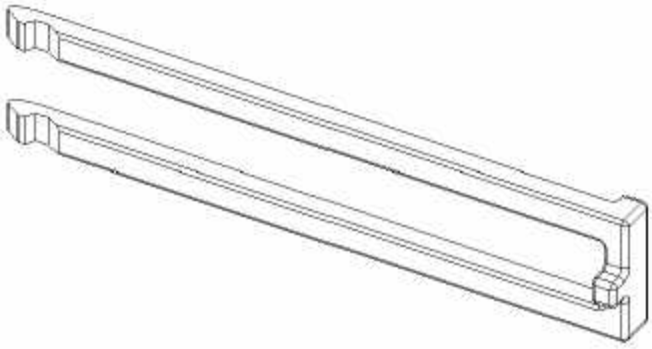
ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY



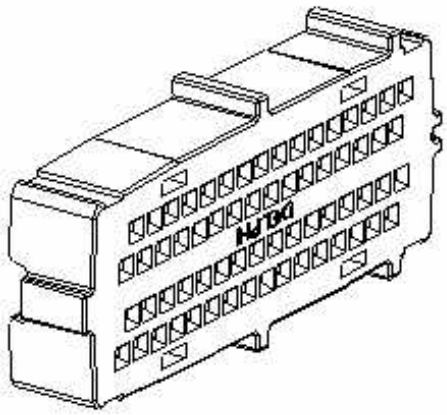
CONNECTOR ASSEMBLY



COVER



SECONDARY LOCK



NOSE-PIECE

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ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY

STEP 1: BUILD CONNECTOR ASSEMBLY TO CONNECTOR HOLDER.

STEP 2: PLUG LEADS TO CONNECTOR ASSEMBLY PER PRINT.

WIRE LENGTHS: WHEN ESTABLISHING WIRE LENGTHS, THERE **MUST** BE NO TIGHT WIRES. WIRE LENGTHS **MUST** BE ESTABLISHED ACCORDING TO THE HARNESS BUILD SEQUENCE.

PLUGGING SEQUENCE: WHEN PLANNING HARNESS BUILD, MICRO 64 TERMINALS MUST BE THE FIRST END PLUGGED OF EACH LEAD. ADHERENCE TO PROPER CONNECTOR FILL SEQUENCE IS REQUIRED TO AVOID UNDER-PLUGS WHICH MAY CAUSE DAMAGE, UNSEATED TERMINALS AND MISPLUGGED LEADS.

CAUTION: ASSEMBLY OPERATORS **MUST NOT** DEVIATE FROM THE ESTABLISHED PLUGGING ORDER.

PLUGGING TECHNIQUE: TO AVOID BENDING THE TERMINAL, GRIP THE LEAD NEAR THE BACK OF THE TERMINAL. IT MAY BE NECESSARY TO RE-GRIP THE LEAD A FEW TIMES DURING THE PLUGGING PROCESS TO AVOID ANY TERMINAL DAMAGE. OPERATOR **MUST** USE SIGNIFICANT CARE TO ENSURE THAT THE TERMINAL IS PUSHED STRAIGHT INTO THE CAVITY.

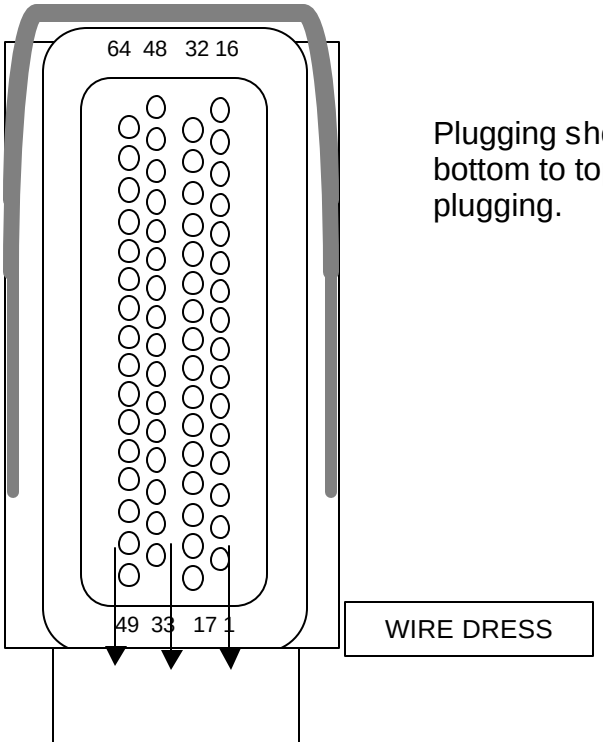
CAUTION: IF A TERMINAL BENDS DURING PLUGGING, OPERATORS **MUST NOT** STRAIGHTEN, RESHAPE OR RE-PLUG THE TERMINAL.

THE OPERATOR MUST PUSH THE TERMINAL TO THE BOTTOM OF THE TERMINAL CAVITY, THEN TUG LIGHTLY ON THE LEAD TO VERIFY THAT THE TERMINAL IS SEATED.

CAUTION: IF THE LEAD DOES NOT SEAT PROPERLY OR IS PLUGGED INTO THE WRONG CAVITY, REMOVE IT AND/OR REPLACE THE LEAD AND/OR CONNECTOR.

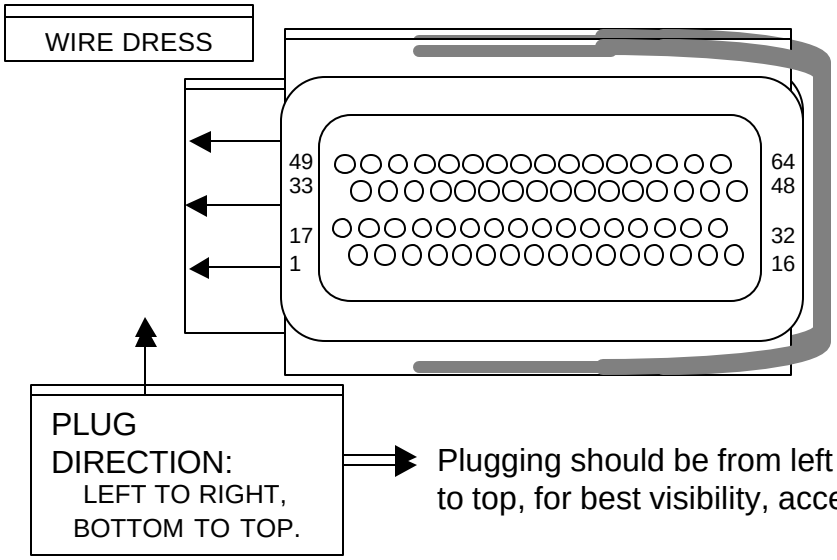
RECOMMENDED PLUGGING SEQUENCE

Connector Holder Vertical



Plugging should be from right to left and from bottom to top, for best visibility, access in plugging.

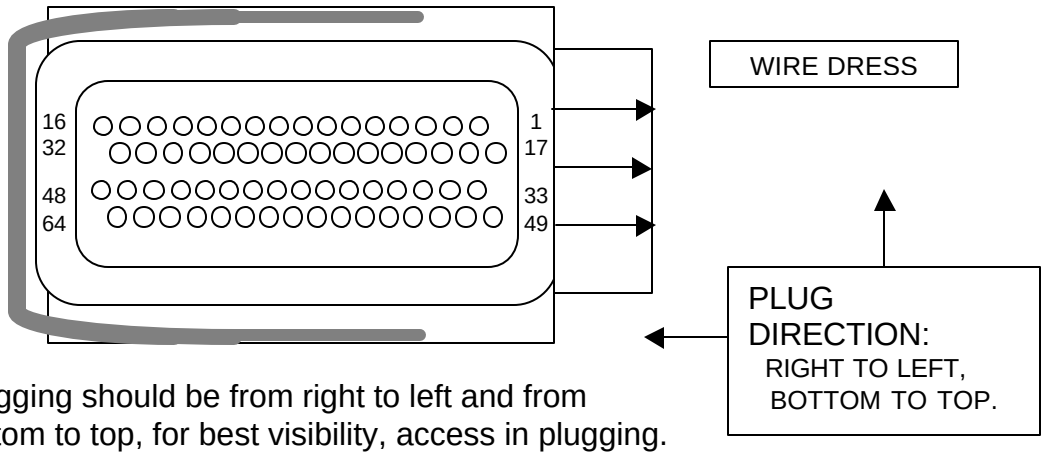
Connector Holder Horizontal



Plugging should be from left to right and from bottom to top, for best visibility, access in plugging.

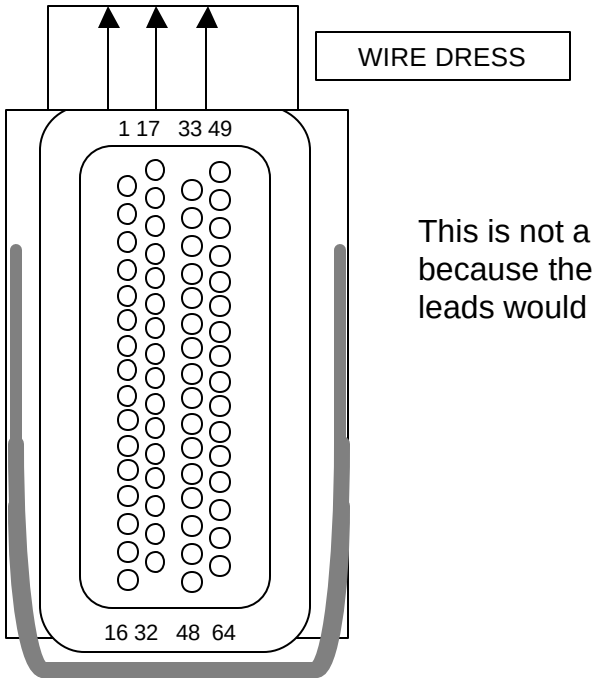
RECOMMENDED PLUGGING SEQUENCE

Horizontal Holder



Plugging should be from right to left and from bottom to top, for best visibility, access in plugging.

Vertical Holder



This is not a recommended holder position, because the wire dress would be upward, and the leads would be very difficult to route.

ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY

STEP 3: **ROUTING OF LEADS:** PROPER ROUTING OF LEADS ON THE BUILD FIXTURE IS CRITICAL. WHILE ROUTING LEADS AFTER PLUGGING MICRO 64 TERMINALS, ASSEMBLY OPERATORS SHOULD APPLY ONLY LIGHT FORCE BECAUSE LEADS COULD BE PULLED OUT OF THEIR CAVITIES.

STEP 4: **APPLY SECONDARY LOCK:** AFTER PLUGGING ALL THE LEADS INTO THE CONNECTOR BODY, START SECONDARY LOCK INTO CONNECTOR AND PUSH TO INSERT. ORIENTATION IS REQUIRED.
USE TOOL # 12152222 TO FULLY SEAT THE SECONDARY LOCK TO A HARD STOP POSITION.
CAUTION: THE SECONDARY LOCK **MUST BE FULLY SEATED,** BEFORE REMOVING THE CONNECTOR BODY FROM ITS HOLDER OR APPLYING ANY COVERINGS.

STEP 5: APPLY HARNESS COVERINGS PER PRODUCT PRINT.

STEP 6: BUILD (1) ONE COVER TO CONNECTOR ASSEMBLY.

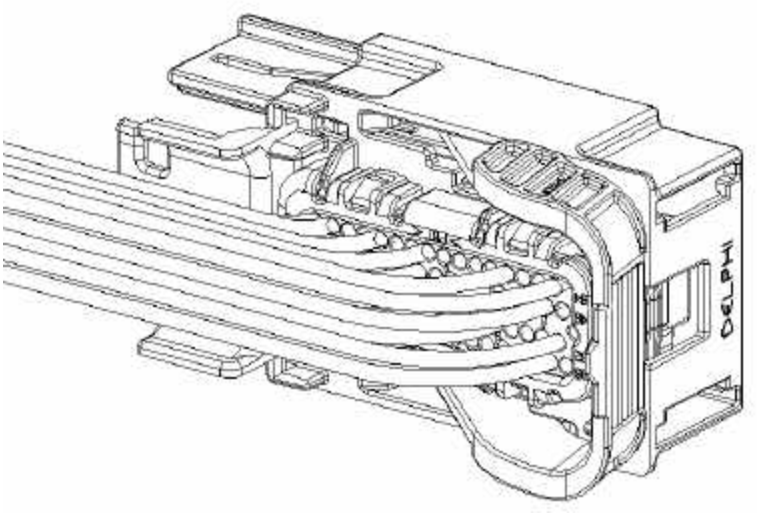
A. APPLY WIRE DRESS COVER TO CONNECTOR BY INSERTING FLEX LEGS INTO LOCK SLOTS AT LEVER END.

B. INSERT STATIONARY TABS OF WIRE DRESS COVER INTO SLOTS IN CONNECTOR NEAR WIRE EXIT.

STEP 7: APPLY NOSE-PIECE TO CONNECTOR ASSEMBLY.

ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY

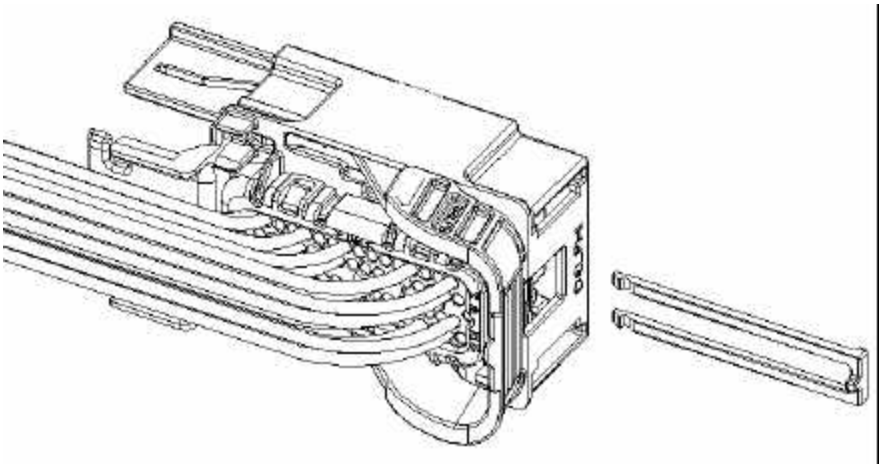
STEP 1: BUILD CONNECTOR ASSEMBLY TO ASSEMBLY TOOLING HOLDER.



STEP 2: PLUG LEADS TO CONNECTOR ASSEMBLY PER PRINT.

STEP 3: **ROUTING OF LEADS:** PROPER ROUTING OF LEADS ON THE BUILD FIXTURE IS CRITICAL.

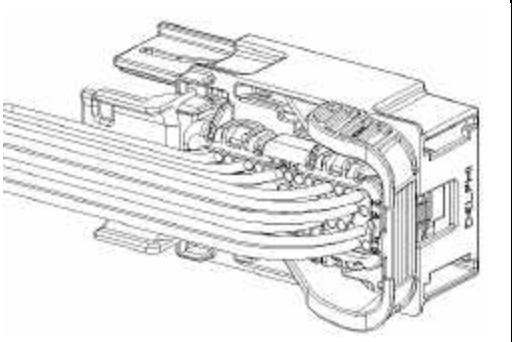
ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY



STEP 4: **APPLY SECONDARY LOCK:** AFTER PLUGGING ALL THE LEADS INTO THE CONNECTOR BODY, START SECONDARY LOCK INTO CONNECTOR AND PUSH TO INSERT. ORIENTATION IS REQUIRED.

USE TOOL # 12152222 TO FULLY SEAT THE SECONDARY LOCK TO A HARD STOP POSITION.

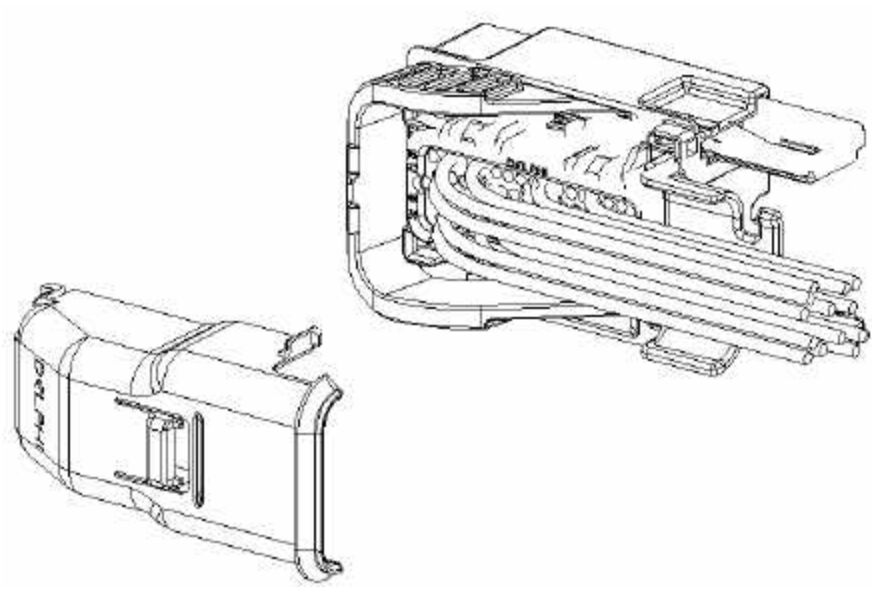
CAUTION: THE SECONDARY LOCK **MUST BE FULLY SEATED,** BEFORE REMOVING THE CONNECTOR BODY FROM ITS HOLDER OR APPLYING ANY COVERINGS.



COMPLETED STEP 4

STEP 5: APPLY HARNESS COVERINGS PER PRODUCT PRINT.

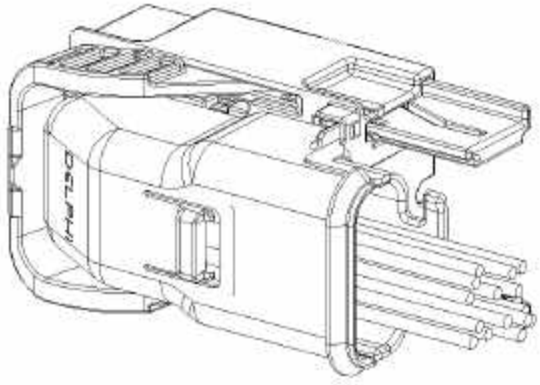
ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY



STEP 6: BUILD (1) ONE COVER TO CONNECTOR ASSEMBLY.

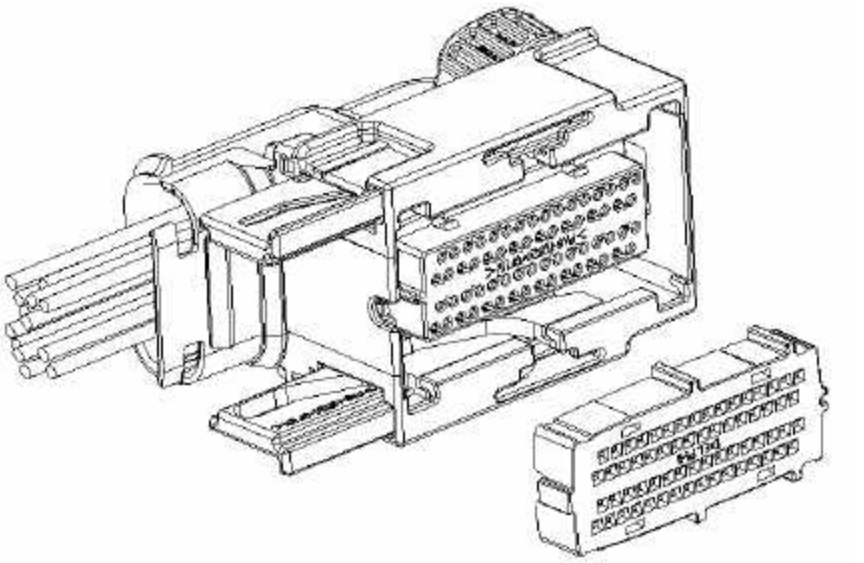
A. APPLY WIRE DRESS COVER TO CONNECTOR BY INSERTING FLEX LEGS INTO LOCK SLOTS AT LEVER END.

B. INSERT STATIONARY TABS OF WIRE DRESS COVER INTO SLOTS IN CONNECTOR NEAR WIRE EXIT.

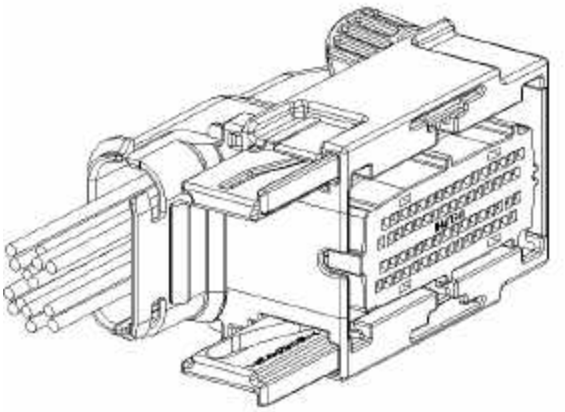


COMPLETED STEP 6

ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY

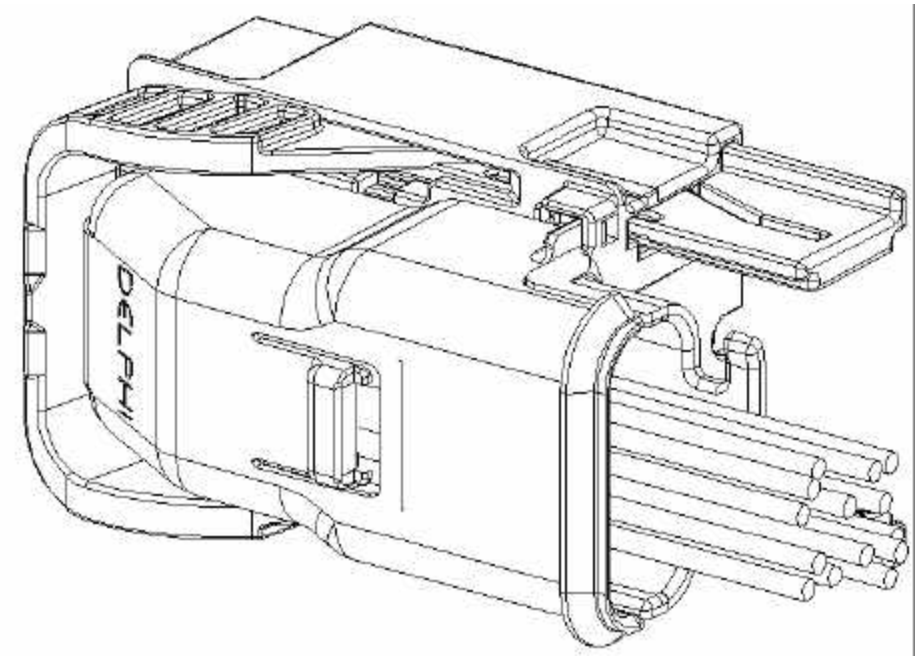


STEP 7: APPLY NOSE PIECE TO CONNECTOR ASSEMBLY.



COMPLETED STEP 7

ASSEMBLY INSTRUCTIONS
MICRO 64 CONNECTOR ASSEMBLY



COMPLETED ASSEMBLY

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