



Instructions for Assembly of Mini D Ribbon (MDR) Non-Shielded Plugs 101XX-8000

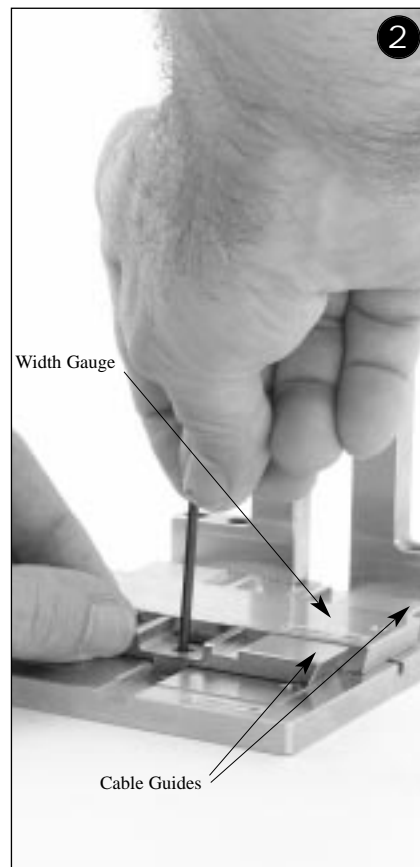
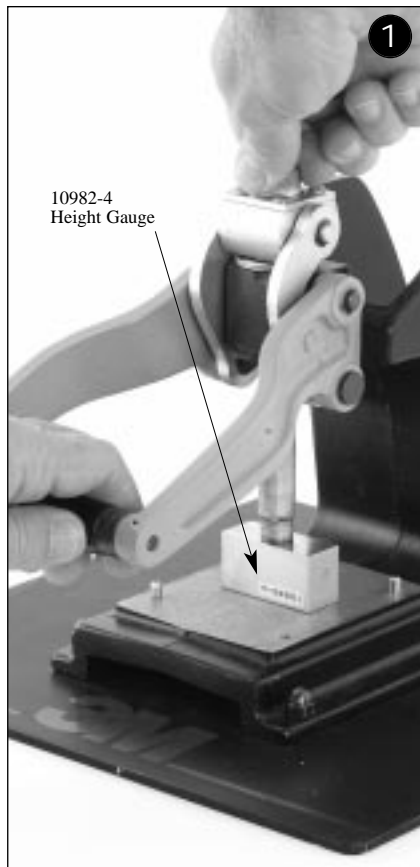
Description

The tools listed are required to assemble the 3M MDR 8000 IDC Wiremount non-shielded plug. These plugs can be installed as terminal end connectors or in daisy chains.

Note: 3M studies have shown a 30 AWG Solid Conductor Cable is the preferred cable to terminate to the MDR 101XX-8000 series plug.

Assembly press	3640 or 10985
Locator plate	10980-3
Platen	10981-5
Height Gauge	10982-4
Width Gauge (XX position)	10983-XX
Cable Stopper (XX position)	10984-XX

Tool Setup

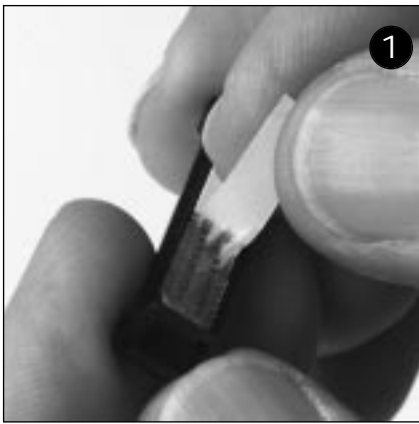


Place the 10982-4 height gauge on the base plate of the press (locator plate removed). Bring the handle down fully and adjust the shaft to touch the gauge. Raise the handle, remove the gauge then turn the adjustment screw one quarter turn (90 degrees) clockwise.

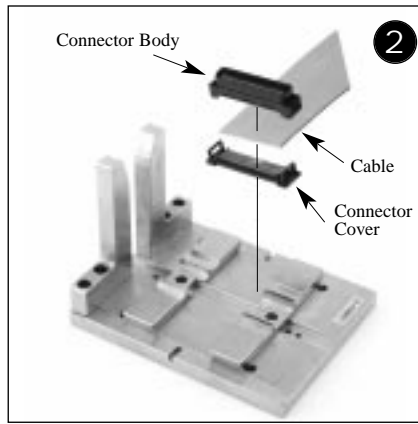
Adjust the width of the cable guides on the 10980-3 locator plate to correspond to the connector. Use width gauge 10983-XX for connectors having XX positions. Remove the width gauge when finished.

Install the 10981-5 platen and the locator plate on the press.

Connector Assembly

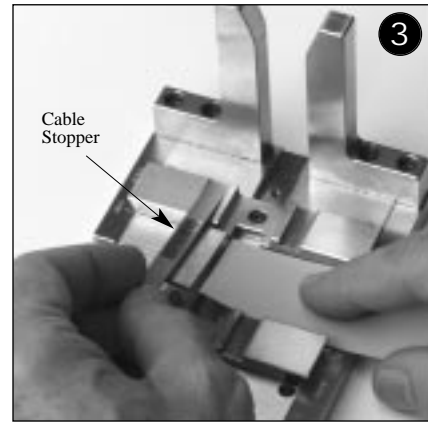


Remove the protective paper lining from the connector cover.



Place the connector cover, then the cable then the connector body on the locator plate.

Note: The locator plate is shown removed from the press for clarity.



When installing a plug on the end of a cable, use the cable stopper to correctly position the cable.

Note: The locator plate is shown removed from the press for clarity.



Lower the press handle to assemble the connector. It is recommended to check the tool setup before starting each production run. Proper seating of the connector cover onto the connector body can be checked by measuring the height of the connector/cover assembly.



The 101XX-8000 plug may be assembled with a strain relief that is installed on the topside of the plug. Bend cable over the top of the connector and snap both inside and outside latches into the body.

For technical, sales or order information, please contact 3M at:
Phone: 1-800-225-5373 Fax: 1-800-325-5329

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