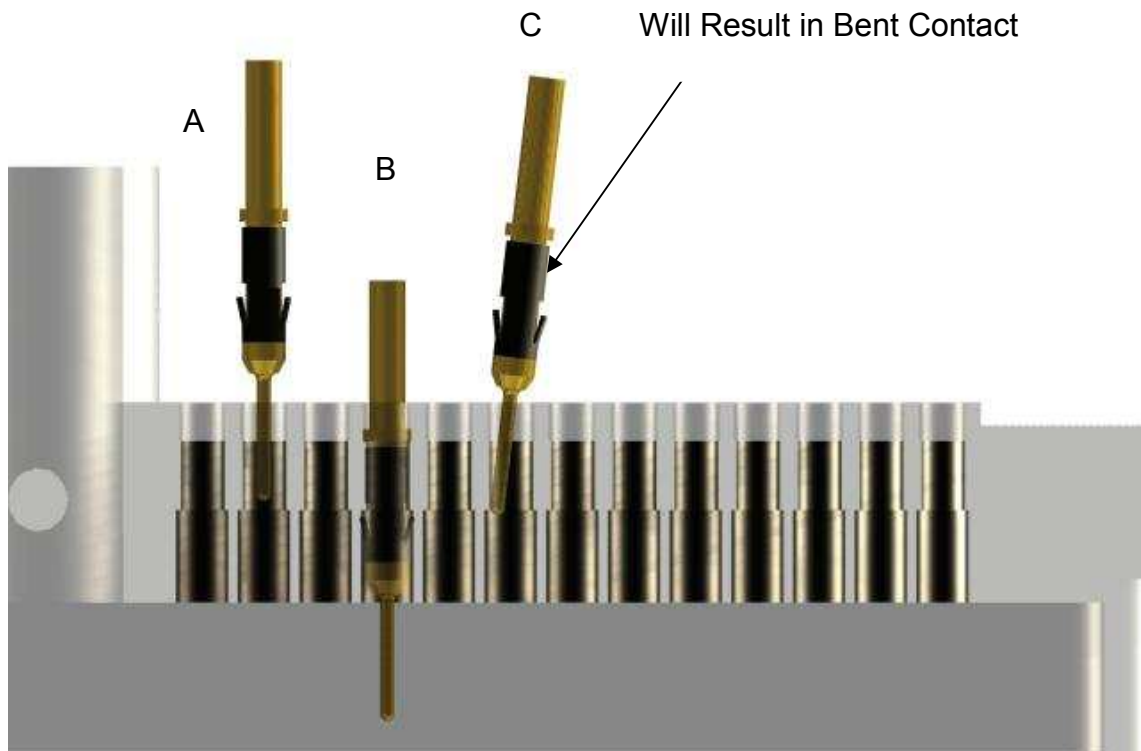




LIF CONNECTOR CONTACT INSERTION PROCEDURE

The MAC Panel LIF Connector is a high precision, low insertion force connector that is designed for reliable operation over an extended period.

Care must be taken when inserting both male and female contacts. The insertion procedure is the same for both:



1. Crimp the wire to the contact. Wire size to be 22 to 26 AWG. For crimp versions use MAC Panel Crimp Frame 452200/M with Die 452299.
2. Align contact with hole, ensuring that flats on contact line up with grooves in LIF body. Position 'A'.
3. Gently insert contact into hole until the clip is correctly positioned as above. Position 'B'.
4. Ensure that the contact enters the LIF body as squarely as possible as the male pin is easily bent resulting in damage to both female and male contacts. Do not insert at an angle (View C).

To confirm that the contacts have been correctly inserted the following procedure should be followed:

1. Listen to the sound of the click as the contact is inserted. This indicates that the clip has sprung out to the correct position. Position B.
2. Visually inspect the inserted side of the contacts to ensure that all the contacts are at the same height.
 - For a male contact the distance from the end of the contact to the plastic should be 5mm. The body of the contact should be level with the plastic.
 - For a female contact the end of the contact should be level with the plastic.

This is a simple inspection and will indicate correct insertion.

If the contact has not been inserted correctly it will float axially within the LIF body. Applying a very light force will confirm this.

If a force of more than 1kg is applied to the contact, either by pushing the contact or pulling the wire, it is possible to damage the contact and/or the housing.

Do not apply a force of more than 1kg.

To ensure trouble free operation of the LIF it is also "good practice" to separate large amounts of wiring around the spindle spool. In-correct cable management can lead to incorrect functioning of the LIF connectors. For further advice contact MAC Panel.

This procedure applies to the following products:

Connectors: LIF-0096-F; LIF-0096-M; LIF-0156-F; LIF-0156-M;
LIF-0260-F; LIF-0260-M

Contacts: HST-806-FC; HST-806-MC; HST-806-FS; HST-806-MS;
HST-806-FW; HST-806-MW

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