

WIRING INSTRUCTIONS FOR REAR SIGNAL CONNECTOR OPTION

The mating connector supplied employs female contacts Amphenol #220-S02. A recommended procedure is given below for making soldered connections to these contacts.

1. Use AWG 24 stranded conductors, preferably Teflon insulated.
2. Wires must be stripped so that 1/16 inch of conductor remains exposed after insertion fully into the contact barrel.
3. Apply heat directly to the wire with the sharp end of a small chisel-tipped soldering iron.
4. Apply thin-gage resin-cored solder only to the exposed wire, allowing solder to wick up into the contact. Do not allow solder to be applied to the exterior cylindrical surface of the contact, as a buildup of solder will prevent its insertion.
5. Use solder sparingly to avoid developing a bead.
6. Insert the wired contact into the appropriate hole in the connector body by hand as far as it will go. Exert seating pressure with a smooth jawed long-nosed plier, gripping the exposed wire perpendicularly just behind the contact. The contact will seat home with a snapping action so that the entire contact is concealed in the connector body.
7. Install heat shrink tubing to cover wires left bare by stripping and soldering operation.
8. Install cable clamp.

A tool is required to remove contacts from the connector. Applicable part numbers are as follows:

1. Handle -- Amphenol #356-200
2. Removal Bit -- Amphenol #356-400-14.

For reference purposes, although not required by the above procedure, other Amphenol tools available are as follows:

1. Crimper for female contacts --
Amphenol #357-104 tool with
#357-304-2 bushing
2. Inserting bit -- #356-400-11, used with the same handle as the removal bit.

Connector Specifications

Temperature Range:	-55°C to +125°C
Current Rating:	3A (wire form contacts) 5A (all other contacts)
Voltage Rating:	1500V AC (RMS) at sea level 375V AC at 70,000 ft.
Dielectric:	Polycarbonate Resin