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## Instructions and Installation Procedures for Scotchflex® 64-Positions Socket/Plug Flat Cable Connector System compatible with mating DIN 41612 Connectors

### General:

Scotchflex manual and pneumatic Assembly Presses and Accessory Tooling are recommended for the assembly of DIN 41612 type Scotchflex Socket and Plug Connectors. Scotchflex Tooling is offered to reduce set-up time, to provide easier and faster assembly and minimize assembly errors.

**Table 1  
System Components:**

Connector Type and 3M Part No.	Contacts Quantity	Strain Relief Part No.	Pull Tab Part No.	Optional Coding Accessories
Socket Connector 6964-0000 -0001	64 Contacts (Three row body-contacts in rows a and c)	3448-6964	3490-6	3435-1 (Keying Plug)
Plug Connector 3695-0000		3448-3695		3708 (Coding Notcher)*

\*Contact your Scotchflex representative for availability details.

**Table 2  
Tooling and Adjustment Settings:**

Connector Type and 3M Part No.	Locator Plate Part No.	Platen Part No.	Adj. Setting Presses 3440-A, 3640	Adj. Setting Presses 3335 series, 3339 series, 3316
Socket Connector 6964-0000 -0001	3443-87	3442-9	4 1/2	5
Plug Connector 3695-0000	3443-91		3	3 1/2

## Assembly:

1. Refer to table 2 to determine the appropriate locatorplate and the correct adjustment setting of the Scotchflex Assembly Press.

For more details on press set-ups, see our Instruction Sheets on the adjustment of each individual Scotchflex press.

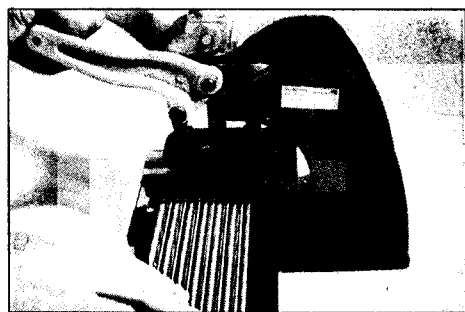


figure 1

2. Cut suitable cable length using Scotchflex Flat Cable Cutter 3382 or Scotchflex Cable Shear 3320. (fig. 1 and 2)

Note: To prevent shorting of conductors, do not cut cable with a scissors-type device, knife or trim the cable after connector assembly.



figure 2

3. Rub thumb along length of paper liner on connector cover to ensure maximum adhesive transfer.

**Plug Connector 3695-0000:** Remove paper liner from the cover. (fig. 3)

**Socket Connector 6964-000x:** Remove cover from the paper liner by snapping the cover down against the adjacent cover, then pulling away laterally. (fig. 4)



figure 3

4. Firmly press ribbed side of the cable into alignment grooves on the cover. The adhesive will help it to stay in place.

Check visually to ensure that:

- Cable is properly aligned and oriented in cover grooves.
- Cable end is flush with cover for end terminations, or perpendicular to cover for midspan terminations.

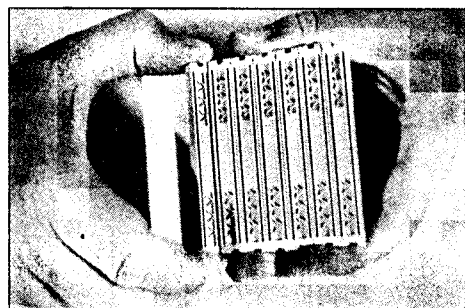


figure 4

5. Position and orient the connector body over the cable-cover subassembly. Engage the cover retainer guides with body ports. (fig. 5 and 6)



figure 5

## Assembly: (contd.)

6. a) **Plug Connector 3695-0000:** Place connector/ cable subassembly in the locatorplate guide with connector body side down. (fig. 7)
- b) **Socket Connector 6964-000x:** Place connector/ cable subassembly in the locatorplate guide with cover side down. (fig. 8)



figure 6

7. Lower the assembly press handle fully to complete the connection.

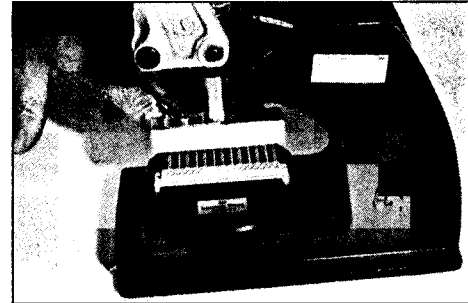


figure 7

8. Raise the press handle and remove the completed assembly. Visually inspect to ensure that:

- a) Cover is fully seated and parallel to body.
- b) Cable is correctly oriented and aligned with cover grooves.
- c) Cover retainers are fully engaged with the connector body. (fig. 9)

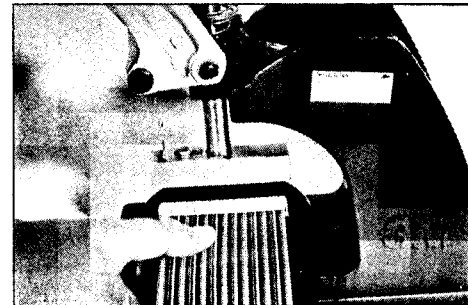


figure 8

## Strain Relief Attachment:

1. Place the metal strain relief clip into plastic strain relief channel.

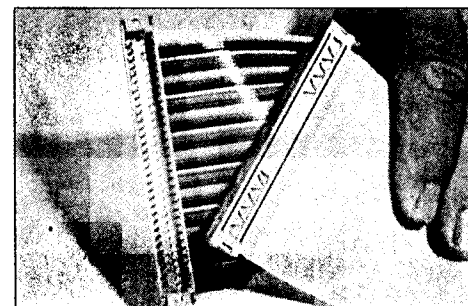


figure 9

2. Fold the cable back over the cover.

3. Hook one end of the strain relief clip onto one end of the connector. Engage the other end of the clip onto opposite end of the connector and snap it into position with finger pressure. (fig. 10)

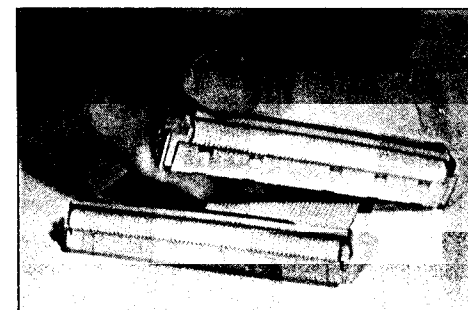


figure 10



## Keying Plug Installation:

6964 Socket Connector and 3695 Plug Connector combination permits keying without loss of contact.

1. Insert the wedge shaped 3435-1 Keying Plug into one of the keying positions on side of the 6964 Socket Connector. Break off the tab. (fig. 11)
2. Remove the corresponding plastic material from the 3695 Plug Connector using the 3708 Coding Notcher Tool. (fig. 12)

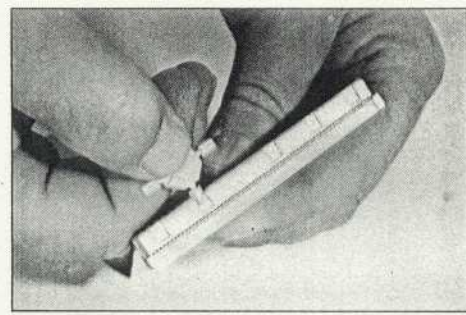


figure 11

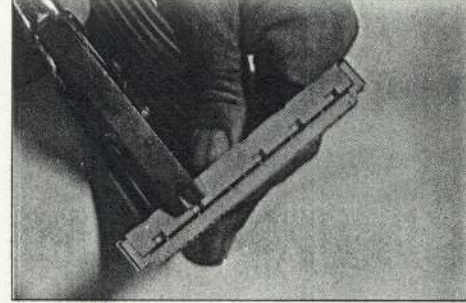


figure 12

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