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Instructions for installation of 3445 Discrete Wire Block

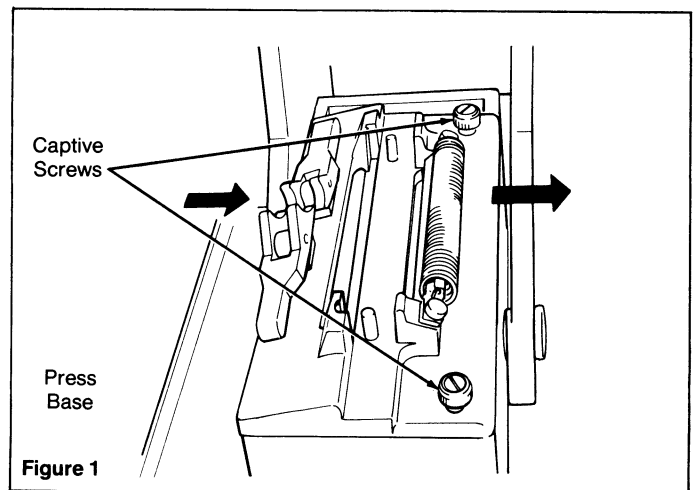
General:

The 3445 Discrete Wire Block is designed to be mounted directly onto the 3316 Universal Press base for use during discrete wire or controlled pitch flat cable operations. With

proper accessories, it provides a means of holding wire/cable in proper alignment for mass termination to Scotchflex insulation displacement connectors.

Installation:

The Discrete Wire Block can be positioned for either left-to-right (Figure 1) or right-to-left assembly, whichever position is more convenient for the operator. The Discrete Wire Block is placed on the press base, and its two slotted, captive screws are turned down tightly with a screwdriver.

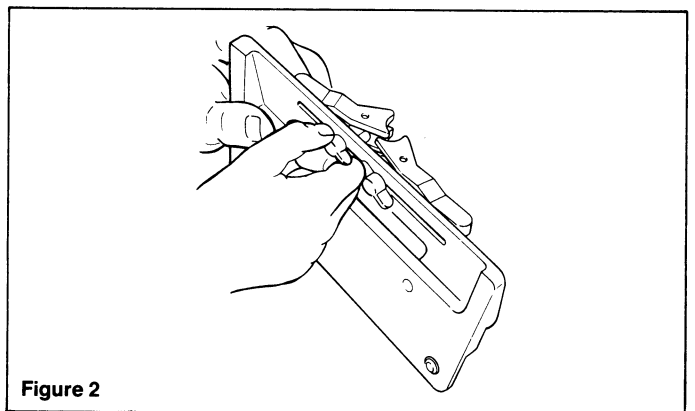


Adjustment:

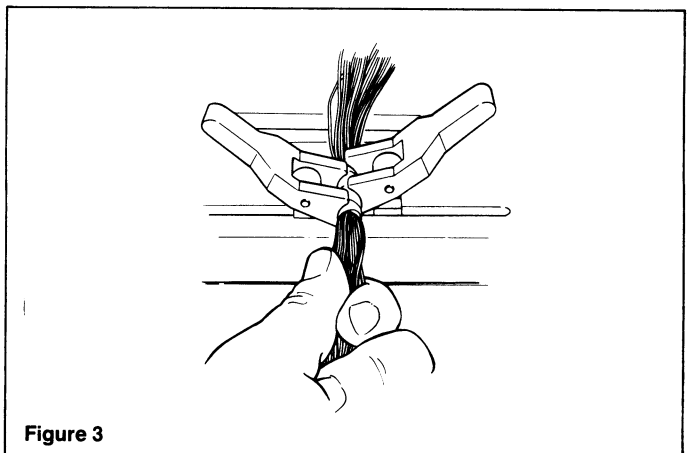
In order to align components properly for the particular type of wire/cable and connectors being used, the following adjustments should be made:

1. Cable Clamps for Round-Jacketed Cable or Discrete Wire Bundle

The cable clamps should be positioned on the Discrete Wire Block so that they grasp the wire bundle or cable securely, in proper alignment with the connector (and junction shell, if one is being used). This is done by loosening the two T-knobs under the block and moving the pair of clamps right or left to the desired position. (Figure 2)

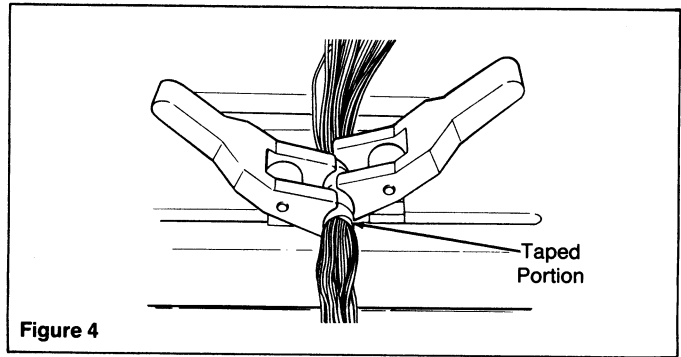


Insert the wire bundle or jacketed cable between the clamps and adjust the opening so that when the clamp wings are raised, the clamp fingers will grasp the bundle firmly enough to resist a considerable pull. (Figure 3)



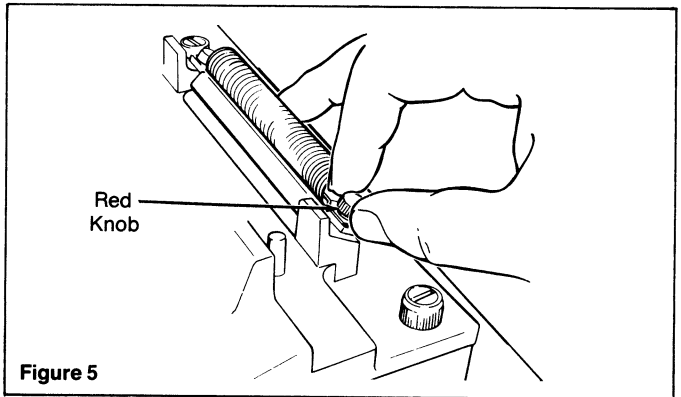
NOTE: When using bundles of individual discrete wires, be sure that the portion being grasped by the clamps is taped to protect the insulation and aid in retaining the wires. (Figure 4)

When the clamps are aligned satisfactorily, retighten the T-knobs.



2. Wire Retainer Assembly

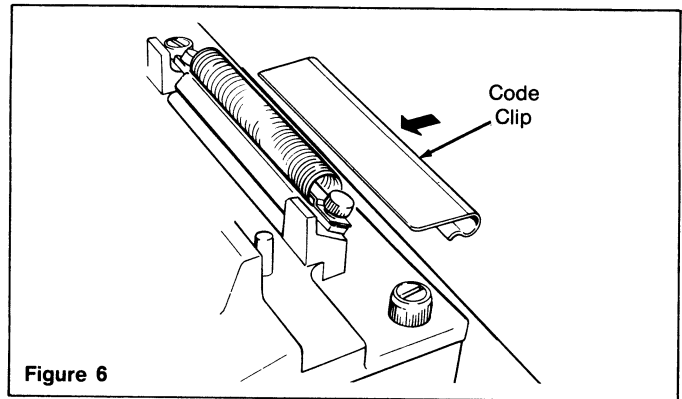
The wire retainer assembly should be positioned with the desired wire gauge in the UP position (black for 26 & 28 gauge, brown for 24 gauge). Note that arrows point to the appropriate color for each gauge. To remove the assembly for this adjustment, loosen the red knobs at each end (Figure 5). Be sure to retighten them after choosing your wire gauge.



3. Code Clip (3M Part No. 3445-1000)

The code clip is a supplementary aid in wiring your connector. Specific codes can be written on this replaceable clip to provide the operator with a wire placement guide. Any code — numbers, colors, etc. — can be used to indicate proper wire positions. Insert as shown on Figure 6.

Two commonly used wire codes, NEMA and Telecommunications, are shown below:



Telecommunications (3459-1 Pair Splitter)

NEMA (3459-2 Pair Splitter)

Primary Colors (Pair Splitter)

| | | | | |
|-------|-----|--------|--------|--------|
| white | red | black | yellow | violet |
| | | blue | | |
| | | orange | | |
| | | green | | |
| | | brown | | |
| | | slate | | |

Secondary Colors (Code Clip)

Chart 1

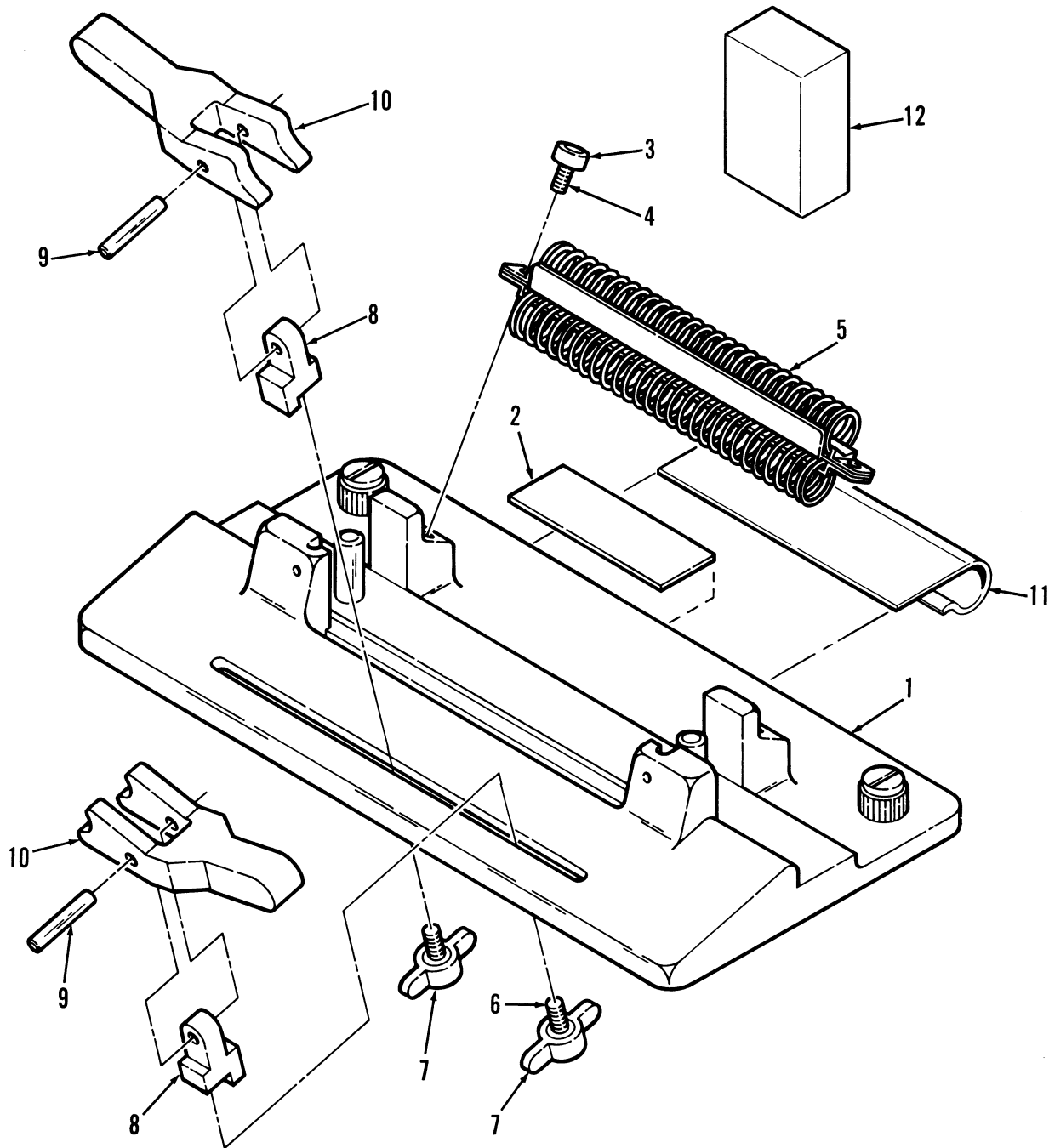
Secondary Colors (Code Clip)

| | | | | | | | | |
|-------|-----|--------|--------|-------|------|--------|------|-------|
| Brown | Red | Orange | Yellow | Green | Blue | Violet | Gray | White |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Primary Colors (Pair Splitter)

Chart 2

The Discrete Wire Block is now ready for installation of the Connector Nest and Pair Splitter. Refer to Instruction Sheets for the particular connector nest and connector being assembled.



| Item No. | Part Number | Description |
|----------|----------------|----------------------------------|
| 1 | 78-8041-2602-3 | CONNECTOR NEST ASSY. |
| 2 | 78-8041-4379-6 | #3445 LABEL |
| 3 | 26-1004-1297-7 | KNOB |
| 4 | 18-3172-2515-1 | SCREW, 6-32 x 5/16 Lg., S.H.C. |
| 5 | 78-8041-4071-9 | WIRE RETAINER ASSY. |
| 6 | 78-7023-3280-3 | SCREW, 10-32 x 3/8 Lg., S.H.C. |
| 7 | 26-1004-1296-9 | T-KNOB |
| 8 | 78-8041-2606-4 | PIVOT SLIDE |
| 9 | 26-1000-3281-7 | DOWEL, 1/8 Dia. x 3/4 Lg. |
| 10 | 78-8041-2605-6 | CLAMP |
| 11 | 78-8044-2072-3 | CODE CLIP |
| 12 | 78-8044-2043-4 | GAUGE BLOCK, 1.750 Lg. x 1.400 W |

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