

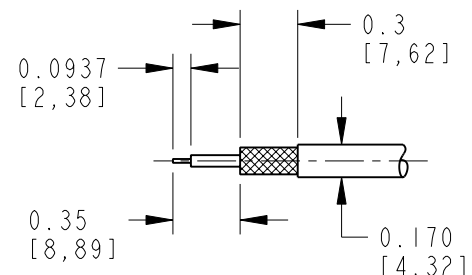
MOUNTING AND ASSEMBLY
INSTRUCTIONS FOR SWITCHCRAFT®
TINI Q-G®
CORD PLUGS AND RECEPTACLES

CORD PLUGS - Series TA(*)F, TA(*)FL,
TA(*)M & TA(*)ML

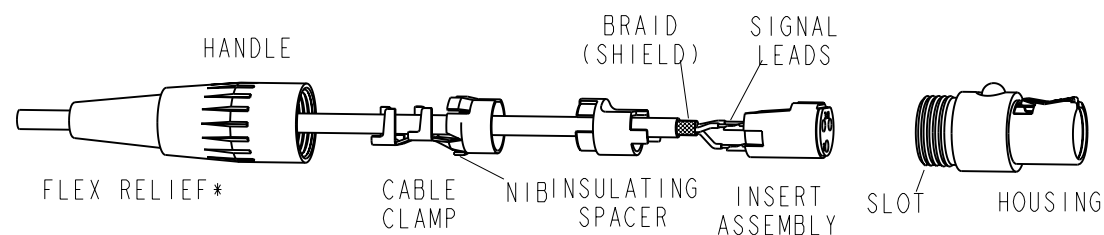
To assemble a cord plug, proceed as follows:

1. Strip cable as shown in illustration.
2. Assemble cord plug parts and cable as shown in exploded view of male or female plug. If cable is larger than 0.115 inch (2.92mm) outside diameter Series TA(*)FL or TA(*)ML (without bushing) should be used.
3. Solder leads (22 AWG maximum) to terminals on insert.
4. Slide insulating spacer forward to interlock into insert. If necessary, rotate spacer to assure interlocking fit.

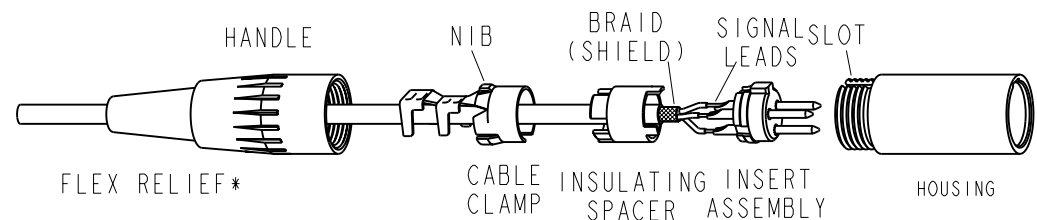
CABLE STRIPPING



EXPLODED VIEW, FEMALE CORD PLUG



EXPLODED VIEW, MALE CORD PLUG

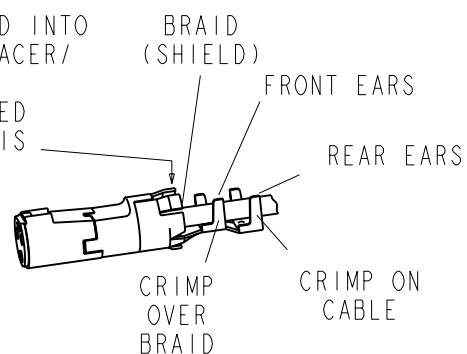


* NOT USED ON SERIES TA(*)ML AND TA(*)FL

5. Slide cable clamp forward over spacer. Rotate, if necessary, to assure interlocking fit.
NOTE: Make sure insert, spacer and clamp are properly interlocked and fit tightly together before proceeding. See crimping illustration.
6. Press forward slightly on cable and crimp rear set of ears on clamp. Make sure insert, spacer and clamp stay interlocked and press tightly together as crimping is done. See illustration.
7. Carefully crimp front ears around cable braid. (Crimp rear ears around cable).
8. Push completed assembly into rear of housing. If necessary, rotate assembly to assure nib on clamp fits into slot on housing. See crimping illustration to identify full insertion point of assembly into housing.
9. Slide end cap forward and thread it onto housing for secure, completed plug.

DETAILS OF CRIMPING

NOTE: WHEN INSERTED INTO HOUSING, INSERT/SPACER/CLAMP SHOULD BE COMPLETELY ASSEMBLED INTO HOUSING TO THIS POINT.



MALE RECEPTACLES - Series TB(*)M

Receptacles mount through panel/chassis hole of 0.445 inch (11.3 mm) diameter. Where non-turn feature is desired, housing is flatted for "D" hole mounting (See illustration in the Switchcraft Engineering Design Guide)

Minimum mounting centers are 0.470 inch (11.9 mm). Panel thickness is 0.25 inch (6.35 mm) maximum. Terminals accept up to #22 AWG wire.

As an alternate, receptacles may be P.C. board terminated. See "Recommended P.C. Board Layout" in the Switchcraft Engineering Design Guide.

FEMALE RECEPTACLES - Series TY(*)F and TY(*)FPC

Mounting may be from front or rear of panel (with or without accessory escutcheons).
NOTE: Escutcheons are not normally used with front mount receptacles.

Minimum centers are 0.75 inch (19.05 mm). Counter sunk holes in flange accept two #3 machine screws or 0.1 inch (2.54 mm) maximum diameter rivets. Maximum panel thickness: TY(*)F front mount-0.375 inch (9.5 mm) maximum; rear mount-0.093 inch (2.3 mm) maximum. TY(*)FPC front mount-0.312 inch (7.9 mm) maximum; rear mount 0.093 inch (2.3 mm) maximum.

Series TY(*)F receptacles have solder terminals, including separate ground terminals.

Series TY(*)FPC receptacles may also be terminated to P.C. board, as well as panel/chassis. See "Combined P.C./Panel Mounting" illustration and Recommended P.C. Board Layout" illustration in the Switchcraft Engineering Design Guide. Receptacles have standoffs to provide clearance between P.C. board and rear of housing.

THIS IS AN INSTRUCTION SHEET FOR THE PRODUCT SHOWN.

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