

**KS-14528, KS-14555, KS-14672, AND KS-16323 CONNECTORS**  
**KS-14095, KS-14173, AND KS-16080 JACKS,**  
**KS-13875, KS-14460, AND KS-14482 PLUGS,**  
**AND KS-14453 SOCKET**  
**PIECE-PART DATA AND REPLACEMENT PROCEDURES**

1. GENERAL

1.01 This section covers the information necessary for ordering parts to be used in the maintenance of KS-13875, KS-14460, and KS-14482 plugs, KS-14095, KS-14173, and KS-16080 jacks, KS-14453 sockets, and KS-14528, KS-14555, KS-14672, and KS-16323 connectors. It also covers the approved procedures for replacing these parts.

1.02 This section is reissued to include additional apparatus and to provide an optional method for replacing terminals. Detailed reasons for reissue will be found at the end of the section.

1.03 Part 2 of this section covers ordering information for those parts which it is practicable to replace in the field in the maintenance of the above apparatus. No attempt should be made to replace parts not designated. Part 2 also contains an explanatory figure showing the different parts. This information is called Piece-part Data.

1.04 Part 3 of this section covers the approved procedures for the replacement of the parts covered in Part 2. This information is called Replacement Procedures.

2. PIECE-PART DATA

2.01 The figure included in this part shows the replaceable parts in their proper relation to other parts of the apparatus, together with their corresponding names.

2.02 When ordering parts for replacement purposes, give the number and the name of the part and also the KS number and name of the apparatus. For example: B-118194-2 Terminal for the KS-14173 Jack. Do not refer to the BSP number.

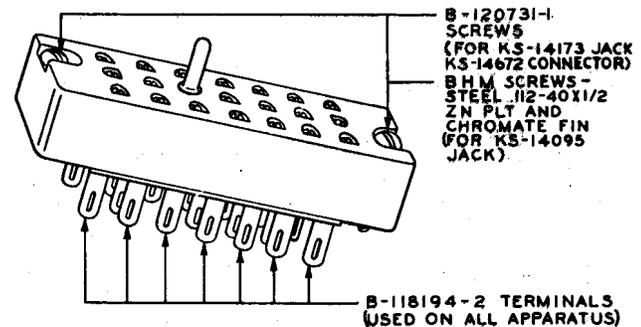


Fig. 1 - Typical Jack (KS-14173 Jack Shown)

3. REPLACEMENT PROCEDURES

3.01 List of Tools and Materials

<u>Code or Spec No.</u>	<u>Description</u>
<u>Tools</u>	
R-2291	Short-nose Skinning Pliers
EXP-9015	Pliers (Cinch Mfg. Corp.)

See Table A for Mating Component

Materials

KS-14666	Cloth
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3.02 Before making any replacement of terminals, remove the associated circuit from service in accordance with the approved procedures. Also, remove all fuses associated with the defective apparatus.

3.03 Where necessary, remove the screws that mount the apparatus and move it so that

the wiring side is accessible. Where a cable clamp, cover, or handle arrangement is used, loosen the cable clamp screws and remove the screws holding the cover so as to permit sliding the cover back along the cable to expose the wiring end of the terminals. Exercise care not to break any of the wires when performing these operations.

3.04 No replacement procedures are specified for screws or other parts where the replacement consists of a simple operation.

#### Removal of Terminal

3.05 Disconnect the wiring from the defective terminal by unsoldering. While the solder on the terminal is still melted, wipe the terminal clean of solder with a KS-14666 cloth.

3.06 With the short-nose pliers, flatten the embossed dimple on the terminal.

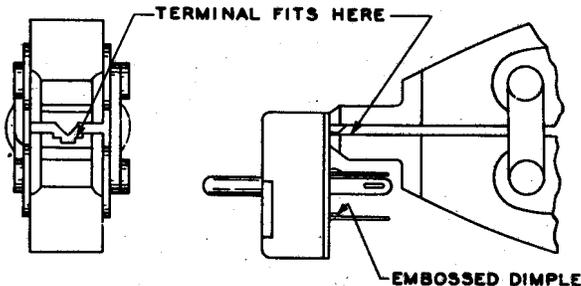


Fig. 2 - View of the EXP-9015 Pliers and Method of Placing Over the Terminal

This dimple appears on the flat terminal near the phenolic block. Push the terminal through the rectangular slot in the block from the wiring side with the short-nose pliers. Remove the damaged terminal from the front side. If the terminal to be removed is a twisted one, flatten the twist, using the short-nose pliers, and push the terminal back enough so as to remove it from the front. In case of broken terminals the burred edge on the wiring side should first be flattened.

#### Replacement of Terminal (Dimple Method)

3.07 Insert a new terminal into the block from the front side. Then insert the mating component, as listed in Table A, fully to hold the new terminal in place. Place the EXP-9015 pliers over the new terminal, as shown in Fig. 2, and press a

dimple in the terminal to hold it in place. In this operation, the nose of the pliers should be held tightly against the block.

TABLE A

<u>Apparatus</u>	<u>Mating Component</u>
KS-13875 Plug)	KS-13876 Connector
KS-14095 Jack)	
KS-14460 Plug)	
KS-14482 Plug)	
KS-14173 Jack	KS-14160 Plug
KS-14453 Socket	KS-14452 Plug
KS-14528 Connector	KS-14527 Connector
KS-14555 Connector	KS-14554 Connector
KS-14672 Connector	KS-14671 Connector
KS-16080 Jack	KS-16081 Plug
KS-16323 Connector	KS-16322 Connector

3.08 Remove the mating component and solder the wire, which was unsoldered from the old terminal, to the new terminal. At the same time, retain as much of the original slack in the wire as possible. Check to see that there is no solder shorting any terminals and then reassemble by reversing the procedure followed to gain access to the wiring side. Restore the circuit to service.

#### Replacement of Terminal (Twist Method)

3.09 Insert a new terminal into the block from the front side as far as it will go. Grip the flat portion of the terminal with the short nose pliers so that with the terminal fully inserted in the block there is approximately 1/32 inch between the nose of the pliers and the face of the block. Push the terminal back in the block so that the nose of the pliers is against the face of the block. This gives a slight play of terminal to permit it to float in its hole. Twist the terminal 90 degrees. After twisting, the terminal shall float freely in its hole in all directions and the edge of the terminal shall be approximately 1/64 inch below the face of the block. Care should be taken in twisting, not to tear or rupture the terminal. All terminals which are replaced shall be twisted in the same direction.

Note: If terminals in a block are held in place by a dimple, it is desirable to replace terminals by using the dimple method in 3.07 so as to present a uniform appearance and spacing. However, if the tool for this method is not available, the twist method may be used.

3.10 Resolder the wire removed observing the precautions in 3.08 and reassemble cover and cable clamp, if used. Restore the circuit to service.

REASONS FOR REISSUE

1. To add KS-13875, KS-14095, KS-14453, KS-14460, KS-14482, KS-14528, KS-14555, KS-14672, KS-16080, and KS-16323.
2. To revise Fig. 1.
3. To revise the list of tools and materials (3.01).
4. To amplify 3.03 and 3.06.
5. To add 3.04.
6. To add Table A (3.07).
7. To add the twist method (3.09 and 3.10).