

## 911A-TYPE CONNECTOR

### REPLACEMENT OF BROKEN OR DAMAGED TERMINALS

#### 1. GENERAL

1.01 This section provides procedures for replacing broken or damaged terminals of the 911A-type connector.

1.02 These procedures apply to the 911A-type connector. The P-48C740 terminal, which is used in new apparatus and for replacement purposes, is illustrated in Figure 1.

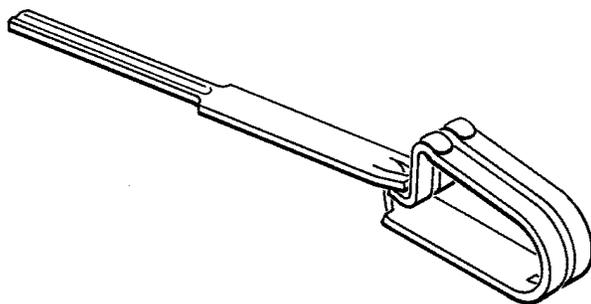


Fig. 1 — Replacement Terminal

1.03 During replacement of terminals, power must be removed and the circuit pack in the damaged connector and the adjacent circuit pack on each side must be removed. If single-side maintenance only is provided, it may be necessary to loosen the connector shelf to provide access to the wire-wrap side of the connector.

1.04 Precautions should be observed to prevent excessive strain on the wiring connecting to the 911A-type connectors. Excessive strain could damage the connectors as described in the caution following 3.03(c).

#### 2. TOOLS AND MATERIALS

CODE OR SPEC NO.	DESCRIPTION
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##### TOOLS:

-	P Long Nose Pliers
KS-6320	Orange Stick

##### MATERIALS:

P-48C740	Terminal
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#### 3. REMOVING AND REPLACING BROKEN TERMINALS

3.01 Instructions for removing wire-wrapped connections are given in Section 069-132-811.

3.02 Remove broken or damaged terminals as follows:

(a) Tag and remove the leads from the terminal(s) to be replaced.

(b) The terminals have a small indentation on the portion of the terminal nearest the connector surface. This portion of the terminal must be removed to allow the contact end of the terminal to be extracted. Using the P long nose pliers, grasp the terminal beyond the wire-wrap portion as closely as possible to the connector. Work the pliers back and forth in the plane perpendicular to the long dimension of the connector until the entire terminal breaks off between the indentation and surface of the connector (Fig. 2).

(c) At the contact side of the connector, insert the P long nose pliers into the section containing the remainder of the terminal so that the contact may be pulled free of the block (Fig. 3).

**Caution:** Care should be taken not to damage the barriers on each side of the terminal being replaced.

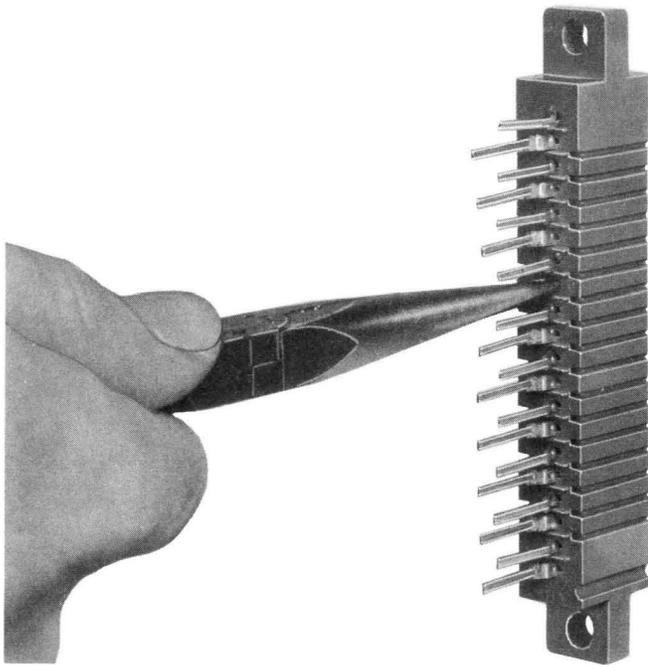


Fig. 2 — Breaking Terminals from Connector

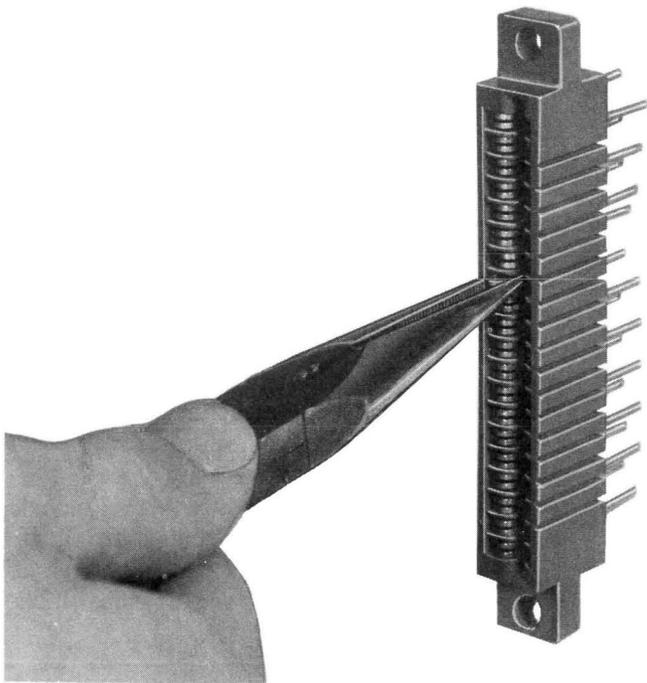


Fig. 3 — Removing Terminal

### 3.03 Replace terminal as follows:

- (a) Insert the new terminal into the connector from the contact side. Observe the positioning of adjacent terminals to determine that the new terminal is correctly positioned.
- (b) Apply light pressure to the terminal until the wire-wrap portion of the terminal protrudes about 1/2 inch from the wiring side of the connector.
- (c) Using the P long nose pliers, grasp the wire-wrap end of the terminal and pull gently to ensure proper seating. The contact should be at the same depth as adjacent terminals.

**Caution:** Do not apply excessive pulling force at the wire-wrap end of the terminal since this could misalign the spring at the opposite end. The spring end of the terminal should seat against the side of the connector. Excessive force will distort the spring, preventing the terminal from seating against the side. This condition prevents insertion of the circuit package into the connector.

- (d) Using an orange stick or small screwdriver, apply pressure to the terminal below the wire-wrap embossing, bending the terminal to a 45-degree angle to the connector. (See Figure 4(A).)

**Note:** Observe that the terminal is always bent in a direction opposite to the offset of the adjacent terminals.

- (e) Using the P long nose pliers, grasp the terminal as shown in Figure 4(B). Apply force as indicated by the arrows, and bend back the end of the terminal so that it is parallel to the adjacent terminals. At the same time, force the 1/16-inch long portion of the terminal flat against the block. The end of the new terminal should not protrude farther than the other terminals.

- (f) Reconnect leads by soldering wire to terminals.

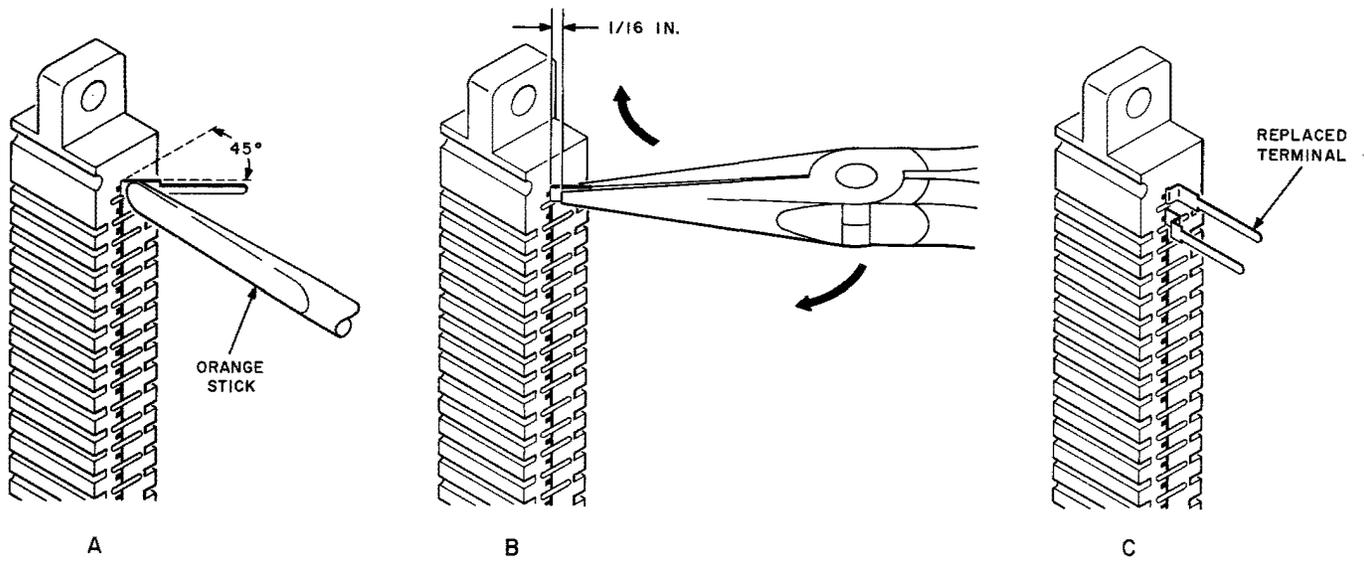


Fig. 4 — Forming Replacement Terminal