

302-TYPE CONNECTORS REPLACEMENT OF TERMINALS

1. GENERAL

1.01 This section provides procedures for replacing broken or damaged terminals on 302-type connectors.

1.02 A broken terminal is usually discovered by continuity checks or when a protector unit is removed, followed by the broken terminal.

1.03 The procedures apply to the three types of terminals used on 302-type connectors as shown in Fig. 1.

1.04 Precaution should be taken to prevent interference to working circuits on adjacent terminals during replacement of broken terminals.

2. TOOLS AND MATERIALS

CODE OR SPEC. NO.	DESCRIPTION
TOOLS	
—	P Long-Nose Pliers
KS-6320	Orange Stick
MATERIALS	
P-46D861	Terminal
P-46D862	Terminal
P-46D871	Terminal

3. REMOVING AND REPLACING BROKEN OR DAMAGED TERMINALS

3.01 Instructions for making and removing wrapped connections are given in Section 069-132-811. Instructions for soldered connections are given in Section 069-140-811.

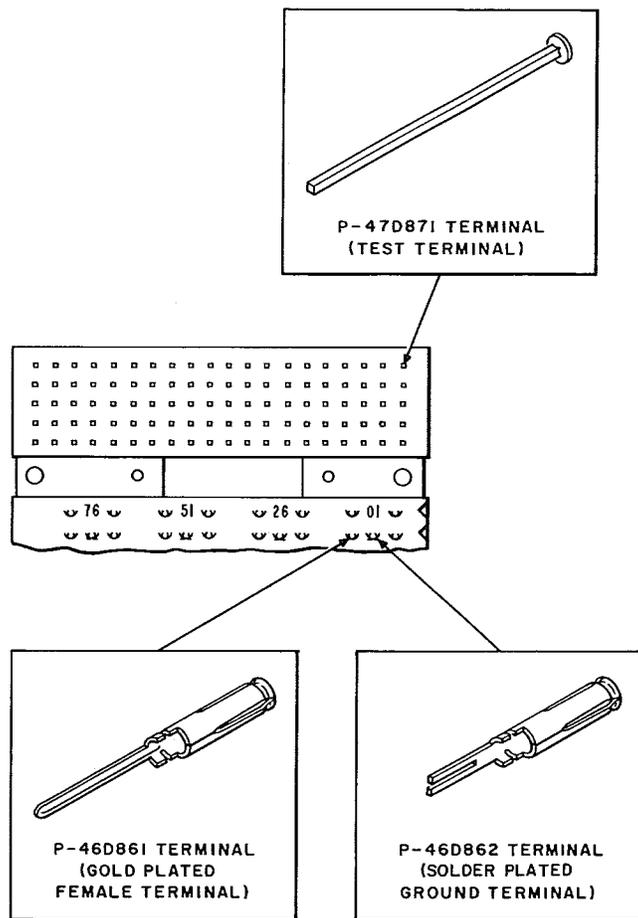


Fig. 1—302-Type Connector—Wiring Side

REMOVING TERMINALS

3.02 P-46D861 Terminal

(a) From the wiring side of the connector, tag and remove the leads from the broken terminal to be replaced.

3.03 P-46D862 Terminal

(a) From the wiring side of the connector, using a soldering copper, remove all the solder

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from the terminal to be replaced and using the P long-nose pliers, grasp the broken terminal and remove it.

3.04 P-46D871 Terminal

- (a) From the wiring side of the connector, tag and remove the leads from the terminal to be replaced.
- (b) Using a new terminal or a sharp instrument such as a test probe, push the broken terminal through the connector about 1/8 inch.
- (c) From the protector unit side of the connector, grasp the terminal head with the P long-nose pliers and pull the terminal from the block.

REPLACING TERMINALS

3.05 The portion of a wire previously used for a solderless-wrapped connection shall not be reused for subsequent solderless-wrapped connections, nor shall it be soldered. This portion must be cut off and the wire reconnected by solderless wrapping. Except in cross-connection fields, it will be necessary to splice the wire if there is not sufficient slack to provide the number of turns required for a solderless-wrapped connection. In cross-connection fields, the wire shall be rerun to provide sufficient length for a solderless-wrapped connection.

3.06 P-46D861 and P-46D862 Terminals.

- (a) From the protector unit side of the connector, insert the new terminal into the same slot from which the old terminal was removed. Using the fingers, push the terminal into the slot as far as possible.
- (b) Replace the protector unit to hold the terminal in place.
- (c) From the wiring side of the connector, using the P long-nose pliers, pull the terminal forward into its proper position. Determine that the terminal is in the correct position by observing the position of the adjacent terminals.
- (d) Using the P long-nose pliers, apply a steady pressure and crimp open the tangs of the terminal.
- (e) Reconnect all leads to the P-46D861 terminal. Reconnect the P-46D862 terminal to the ground bar using a soldering copper.

3.05 P-46D871 Terminal

- (a) From the protector unit side of the connector, insert the new terminal into the same slot from which the old terminal was removed. Using the fingers, push the terminal into the slot as far as possible.
- (b) Using an orange stick, push the terminal into its proper position on the connector.
- (c) From the wiring side of the connector, reconnect all leads.