# 711 CONNECTORIZATION OF THE 4A TOLL IN AND OUT LINK FRAME HORIZONTAL MULTIPLES RECEIVING END

CONTENTS



## 1. GENERAL

### 1.1 Scope of Section

This section describes procedures for joining the 711 Connectors which have been applied to the Horizontal Multiples of Reused 4A Toll In and Out Link Frames.

### 1.2 Associated Information

General information on the 711 Modular Connector System is furnished in Handbook 9, Section 390.

1.22 The sending end connectorization of the 4A Toll In and Out Link Frame Horizontal Multiples is described in Section 390.2 of this handbook.

### 1.3 Tools

1.31 The necessary tools required for operations covered in this section consist of:

R-4774 Connector Joining Tool
R-4775 Single Wire Tool

These shall be ordered from the Regional Stockkeeping Organization as loose items.

## 2. "711" CONNECTOR PREJOINING INSPECTION AND VERIFICATION REQUIREMENTS

2.1 Make sure that the two bays to be joined together are the compatible ones. Check job shipping papers, bay stamping information and/or connector designation markings in order to place the bays in proper line-up position for joining.

2.2 Inspect all wired receptacles to make sure that the mandrels are fully inserted into the housings. If not, press them in by hand. Also make sure that the notched end of the mandrel is at the number one wire position. The notch in the mandrel on the other side shall be diagonally opposite.

2.3 Examine the contact entry windows for the presence of one centrally positioned wire in each window. There should be not more than one wire in any mandrel slot.

2.4 No wire ends should extend more than 1/32 inch outside the mandrel slot nor be recessed more than 1/32 inch from the edge of the mandrel.

2.5 There shall not be any scrap wire pieces trapped between the mandrel and receptacle housing.

2.6 There shall be ample wire slack so that the mating surfaces of the two receptacles may touch.

2.7 The red index bars on the receptacles must be aligned. Also, the wire colors should match in the mating receptacles.

2.8 Examine the assemblies for broken wires outside the receptacles.

## 3. 711 CONNECTOR JOINING AND DRESSING METHODS

3.1 Assemble by hand the two receptacles and the connector module with the red colored bars on ends of components aligned.

3.2 Now open the R-4774 connector joining tool's jaws by swinging the lever away from the tool handle. Slide the connector assembly between the tool jaws.

CAUTION: BE CAREFUL NOT TO TRAP ANY WIRES IN THE PRESSING AREA.



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3.3 Pull the lever towards the handle to close the lower jaw and press the assembly together.

3.4 Push the handle forward and slide the assembly out. The joining of the connector is now complete.

3.5 Repeat the operation for the second connector to complete the connectorization of the horizontal multiple cable.

NOTE: If any corrective action is required, the 711 Connector can be disengaged by inserting a screwdriver in any slot at connector receptacle interface. Twist screwdriver and use gentle prying motion to separate components. To disengage the mandrel, engage edge of coin in mandrel rail slot and apply twisting motion.

3.6 After the two sets of connectors for each shop formed cable have been joined, neatly dress and tie the finished product to the frame uprights.

4. TESTING

4.1 The reused and connectorized 4A Toll Link Frames shall be tested in accordance with the test methods utilizing the "ITE" test equipment furnished for new frames.

4.2 Refer to Handbook 67, Sections 500 and 530, for the incoming and outgoing link frame test information respectively.

Manager, Product Engineering
Control Center