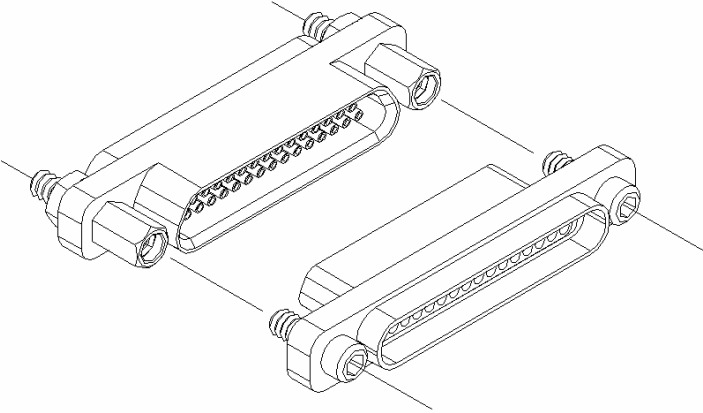
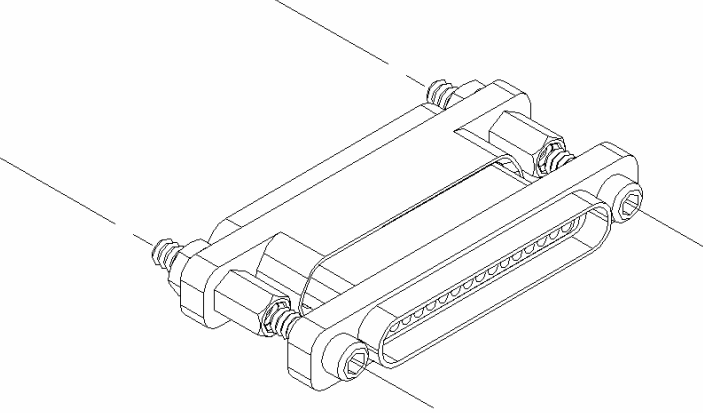


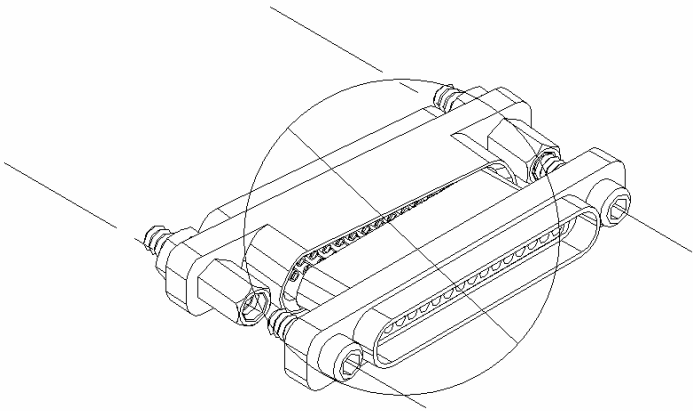
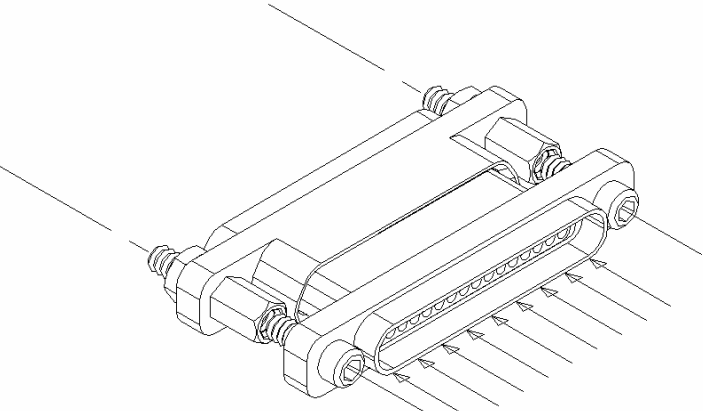
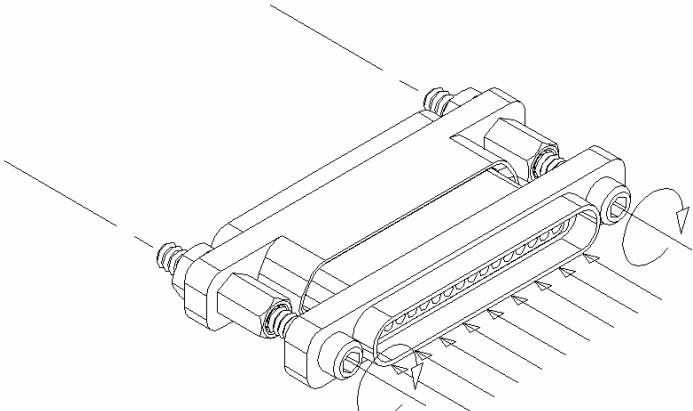
CONNECTOR MATING AND UNMATING PROCEDURE

Purpose: Provides a procedure for mating and unmating of Standard M83513 style connectors.

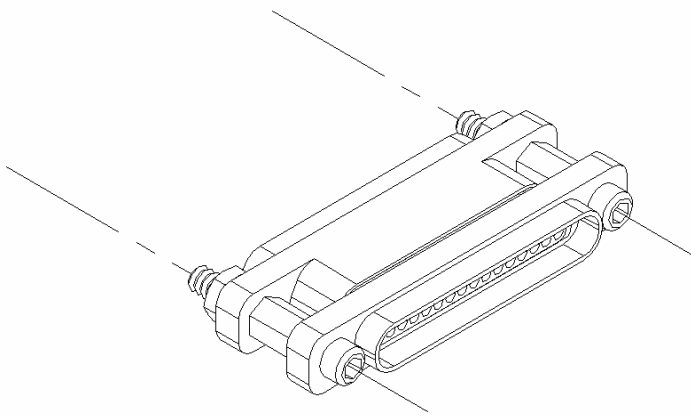
When: During mating and unmating of M83513 connectors, when possible mating should be accomplished using jacking hardware and this procedure to avoid damaging the pin and socket contacts.

Materials: Hex wrench sized for hardware

ACTIONS	NOTES
<p>1.</p> 	<p>a. Align the plug and receptacle in the correct orientation.</p>
<p>2.</p> 	<p>a. Mate the connector halves evenly.</p>

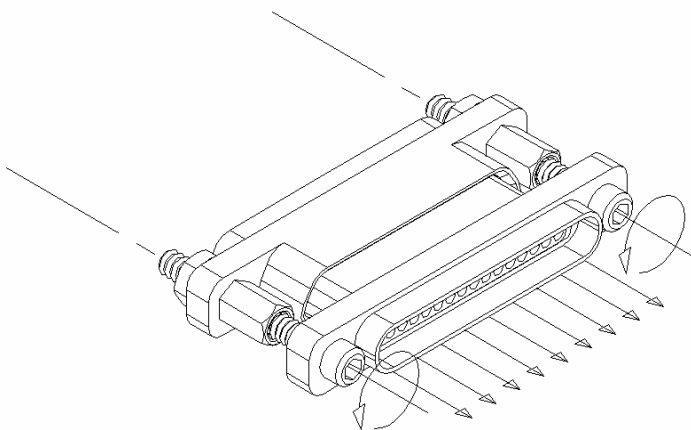
<p>3.</p> 	<p>a. CAUTION! Never mate the connector halves unevenly. Doing so may result in damage to the pin/socket contacts.</p>
<p>4.</p> 	<p>a. Apply an even force to the connector body until the hardware is engaged.</p>
<p>5.</p> 	<p>a. Select the appropriate hardware tool. While applying even pressure on the connector body, alternately tighten each jackscrew 1/2 turn until the connector is fully mated.</p>

6.



a. When the connector is fully mated, a hardware torque may be applied to the following specifications: 2-56 hardware 2.0 to 2.5 inch-pounds, 4-40 hardware 4.0 to 4.5 inch-pounds.

7.



a. Unmating is accomplished in a reverse order of steps 4-6, applying a pulling force to the connector body and loosening the hardware uniformly.