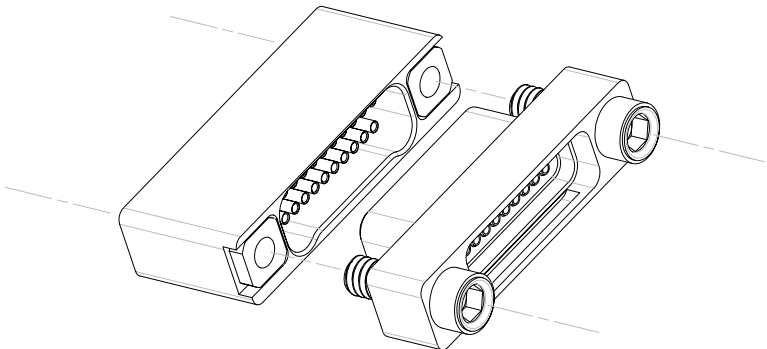
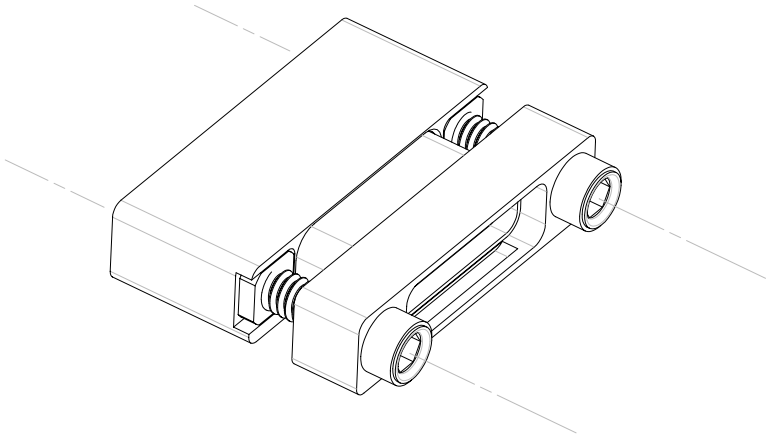


NANO CONNECTOR MATING AND UNMATING PROCEDURE

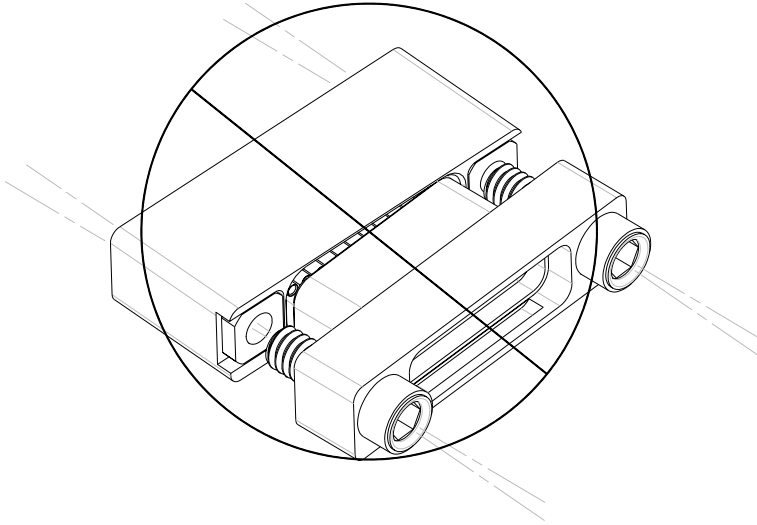
Purpose: Provides a procedure for mating and unmating of NANO style connectors.

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

Materials: .050" hex key wrench sized for #0-80 hardware.
1/16" hex key wrench sized for #2-56 hardware.
Ball end wrench is not recommended.
Hex wrench key/bit conforming to the requirements of ASME / ANSI-B-18.3 is recommended.

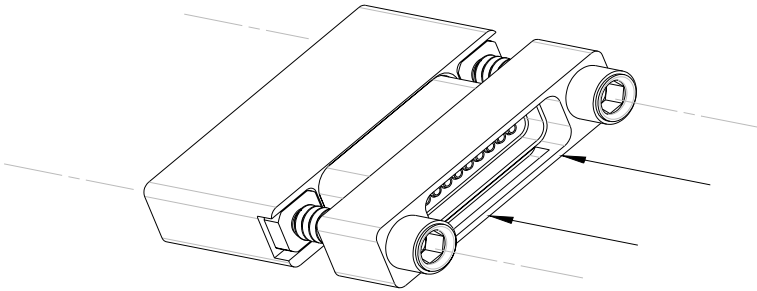
ACTIONS	NOTES
<p>1.</p> 	<p>a. Align the plug and receptacle in the correct orientation.</p>
<p>2.</p> 	<p>a. Mate the connector halves evenly.</p>

3.



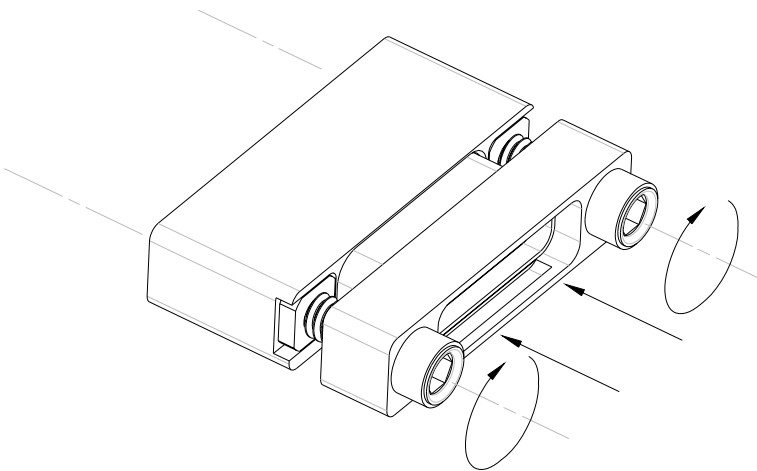
a. **CAUTION! Never mate the connector halves unevenly. Doing so may result in damage to the pin/socket contacts.**

4.



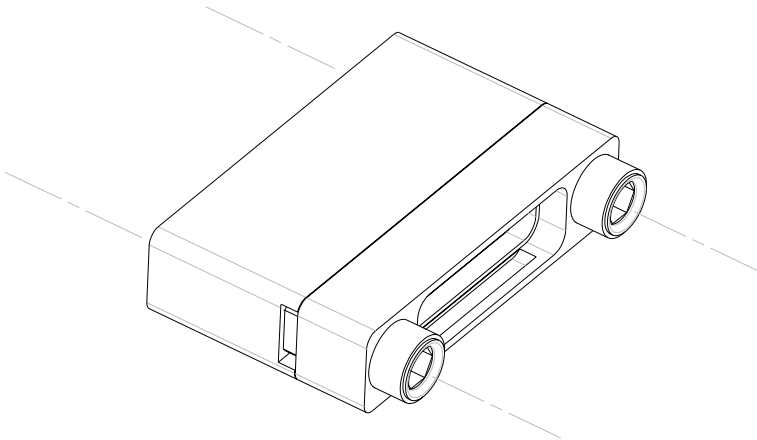
a. **Apply an even force to the connector body until the hardware is engaged.**

5.



a. **Select the appropriate hardware tool. While applying even pressure on the connector body, tighten one jackscrew 1/4 turn, then tighten the other jackscrew 1/2 turn. Thereafter alternately tighten each jackscrew 1/2 turn, starting with the first jackscrew, until the connector is fully mated.**

6.

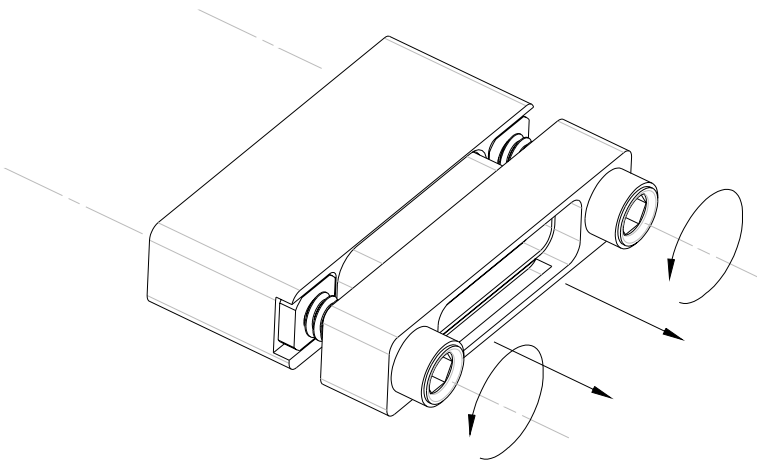


a. When the connector is fully mated, a hardware torque may be applied to the following specifications:

#0-80 hardware
1.0 inch-lbs. Max.

#2-56 hardware
2.0 inch-lbs. Max

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.