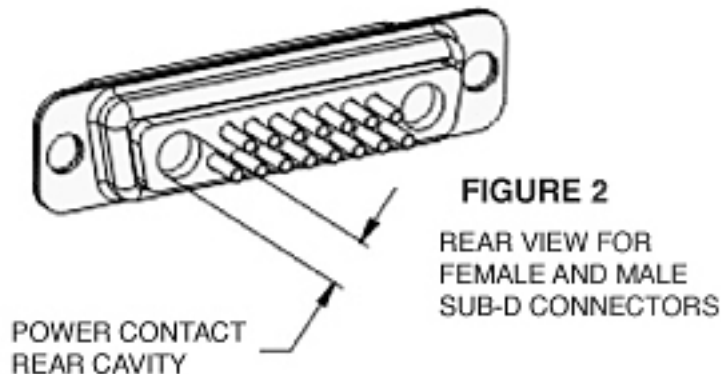




STEP ONE:

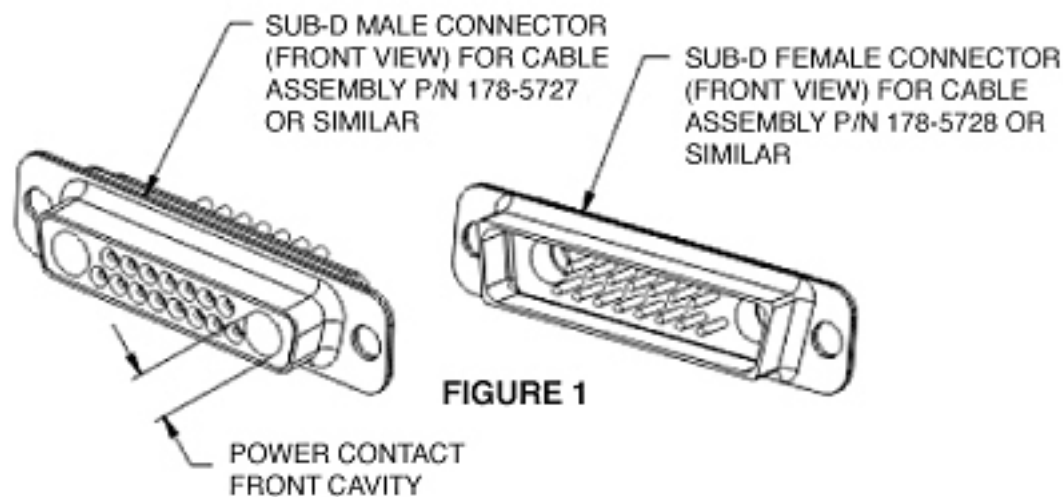


Select the power contact cavity where the HiMate lead assembly is to be installed.
See figures 1 and 2.

CAUTION: Using connectors other than the Positronic brand may result in an improper installation and mating of the HiMate lead assemblies.

The following insertion/removal instructions are for single or multiple high voltage HiMate lead assemblies. These instructions are for use with Positronic Sub-D connectors. Removal of other hardware from the Sub-D connector may be required to insert and/or remove the HiMate lead assembly. Set the removed hardware aside for future use.

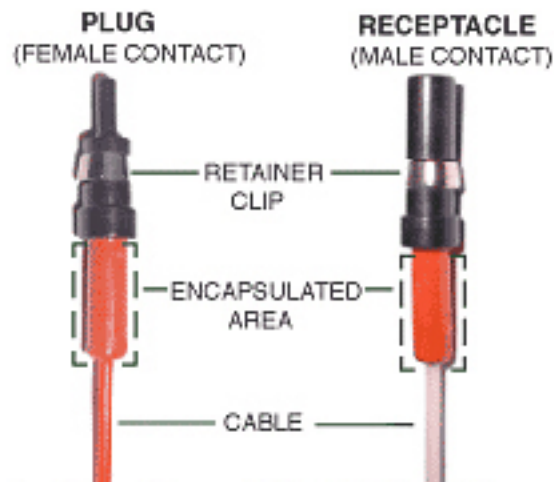
Note: Make sure that the Sub-D connector gender is for the appropriate HiMate lead assembly as shown in figure 1.



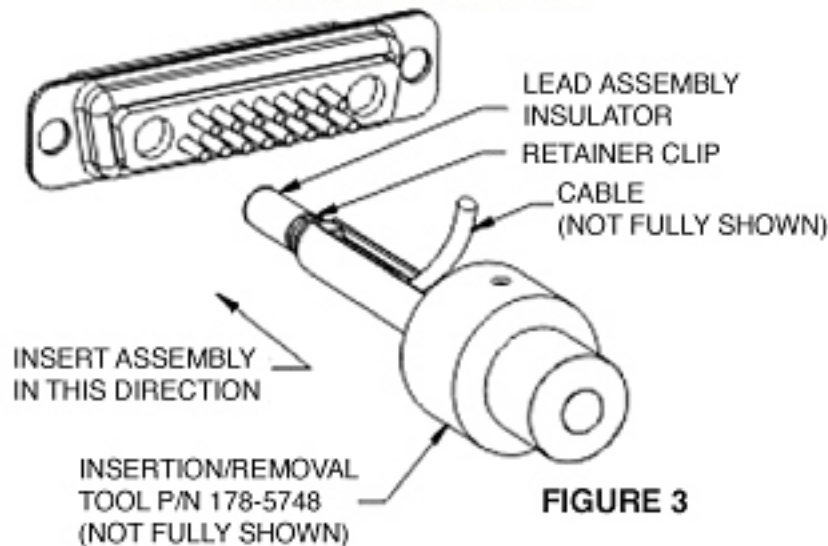


STEP TWO:

TYPICAL HIMATE SUB-D
LEAD ASSEMBLIES.

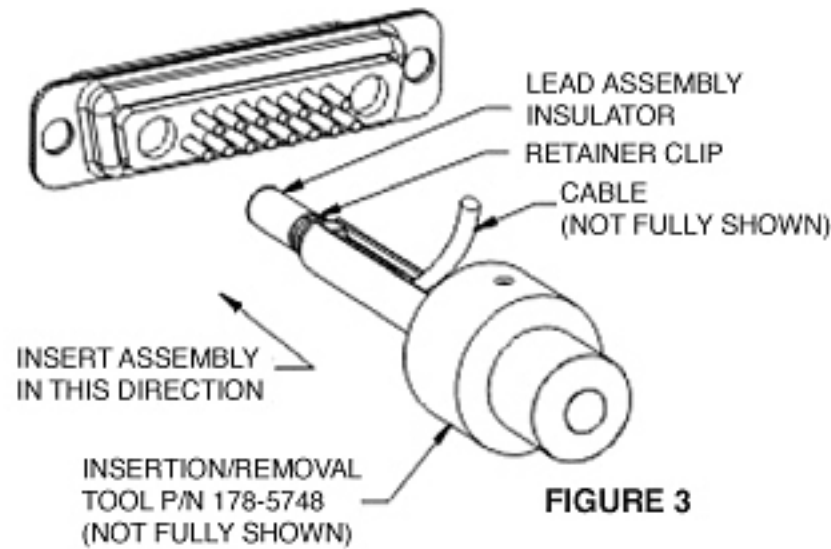


Place the HiMate lead assembly into the insertion tool P/N 178-5748, as shown in figure 3. A slot on the tool is provided to cradle the cable. Bend the cable to one side as shown in figure 3. Make sure the insulator of the lead assembly bottoms out onto the tool prior to installation. Insert the HiMate lead assemblies from the rear of the Sub-D connector.





STEP THREE:



Align the lead assembly connector insulator with the required cavity hole of the Sub-D connector. Using the tool, push the lead assembly insulator forward until the retainer clip locks in place. Some slight wiggling may be required when collapsing the retainer clip into the Sub-D connector. **CAUTION:** Always use the tool to insert the lead assembly insulator into the connector cavity. Never attempt to install the insulator by holding on to the rubber encapsulated area or the lead wire itself.



PHOTO 3A

This photo applies to steps 2 and 3 of the HiMate insertion procedure on page 2. Shown is a HiMate plug lead assembly placed into the insertion tool. While a HiMate plug lead assembly is shown, the tool and the procedures of steps 2 and 3 can also be used to install a HiMate receptacle lead assembly.

TOOL - P/N 178-5748





STEP FOUR:

After installing the HiMate lead assembly, remove the insertion tool carefully. To ensure proper seating of the insulator make sure the retainer clip has snapped into place by gently pulling on the cable from the HiMate encapsulation. (See figure 4). CAUTION: Excessive pulling or jerking of the cable will result in severe damage to the lead assembly

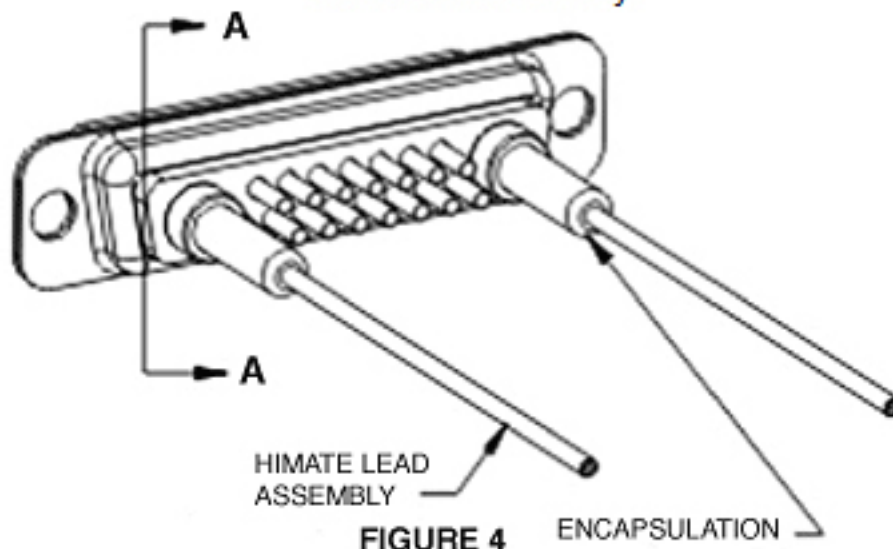


FIGURE 4

ENCAPSULATION





STEP FIVE:

When assembled properly the HiMate insulator should have the approximate control dimension shown in figure 5. The HiMate should move freely and/or spin. If the HiMate assembly is not able to move or spin, remove the lead assembly and re-install per steps 3 and 4. After the HiMate lead assembly is installed, some additional assembly may be required. Re-install all required hardware onto the Sub-D connector if needed.

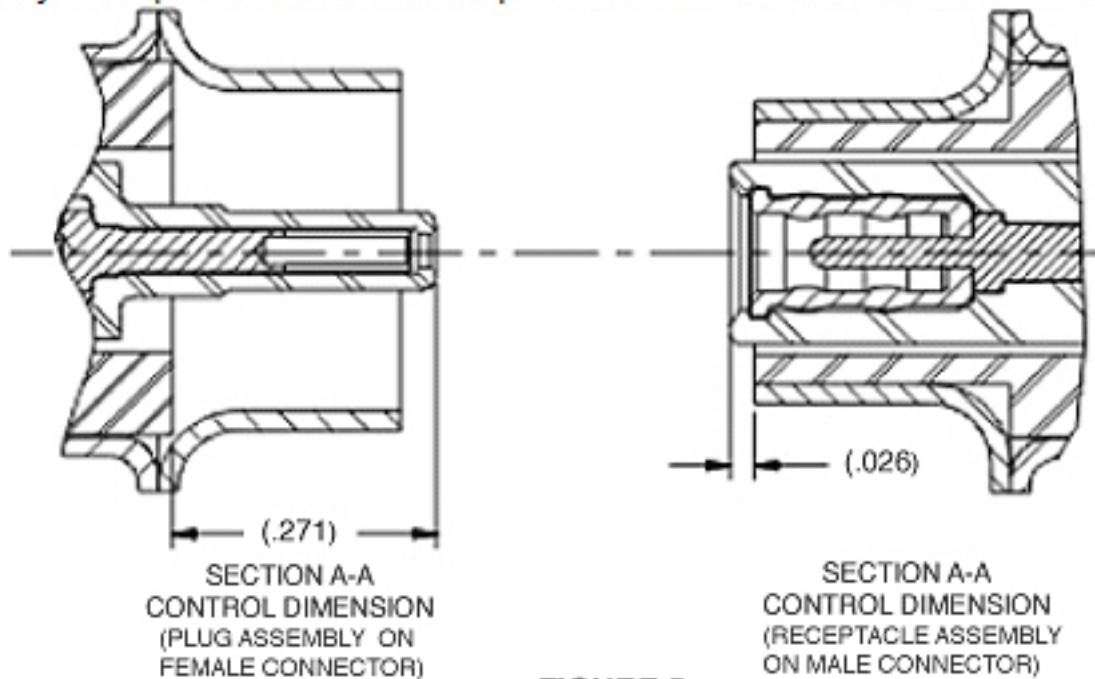


FIGURE 5





STEP SIX:

Select the HiMate lead assembly to be removed. Removal of all HiMate lead assemblies is from the front of the Sub-D connector. Use the removal side of the tool P/N 178-5748. Slide the tool over the nose of the HiMate insulator to collapse and release the retainer clip. See figure 6. Push the removal tool plunger (at the end of the tool) and the nose of the insulator until the lead assembly is fully withdrawn from the Sub-D connector.

To re-install the lead assembly follow steps 2,3,4 and 5

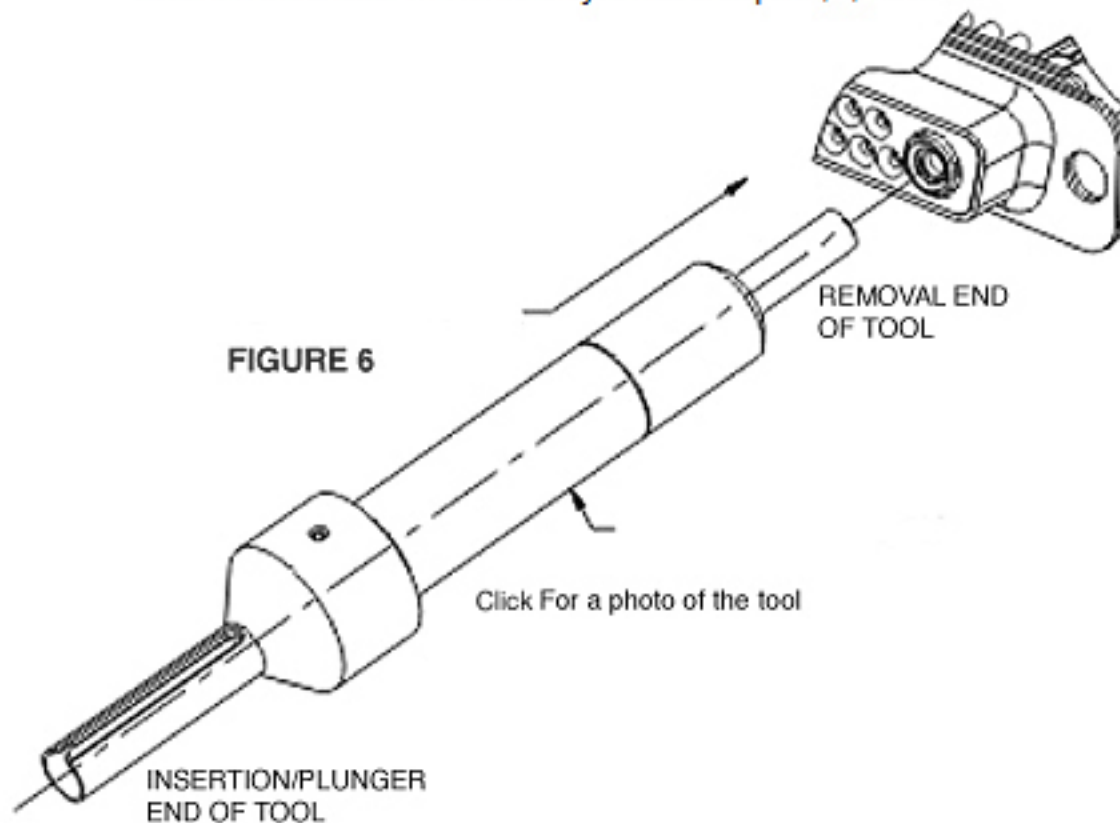


PHOTO 6A

This photo applies to step 6 of the HiMate removal procedure on page 4. Shown is the removal end of the tool, P/N 178-5748, ready to be placed over a HiMate plug insulator for removal. The same tool and procedure is also used to remove a HiMate receptacle insulator.

TOOL - P/N 178-5748

