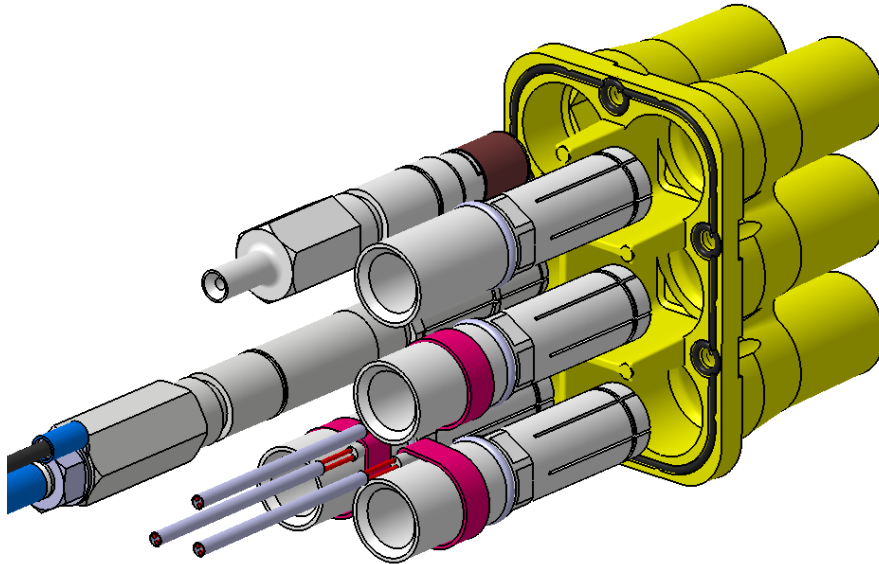


Assembly Instructions



PDS400 Aircraft Connector Temperature Sensor & Sleeve Fitting Instructions

LPA Connection Systems

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Contents

1. Assembly tools and Auxiliary Materials	3
1.1 Power Tube	3
1.2 Standard Tools	3
1.3 Auxiliary Materials	4
2. Assembly Instructions	5
2.1 Fitting Elastic Sleeve into Contact	5
2.2 Fitting Temperature Sensor	6
2.3 Heat-Shrink over the temperature sensor	8
2.4 Inserting power contact into inner block moulding	8

1. Assembly tools and Auxiliary Materials

1.1 Power Tube

Position	Image	Description	Manufacture/Supplier Details
1		Power Tube Rear Half	LPA ref: 54307

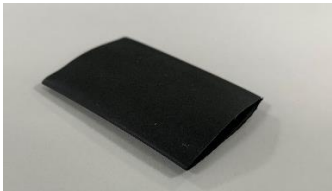

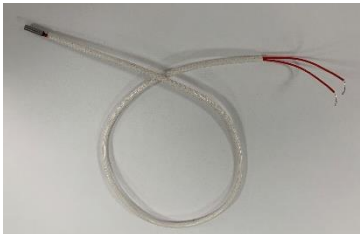
1.2 Standard Tools

Position	Image	Description	Manufacture/Supplier Details
1		Hellerman Sleeve Expander	Non-specific
2		Heat Gun	Non-specific
3		Small Screw Driver	Non-Specific

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1.3 Auxiliary Materials

Position	Image	Item number	Description
1		LPA ref: 28187	3 x Heat-shrink 50mm long
3		LPA ref: 54463	3 x Elastic Sleeve
4		LPA ref: 51710, 50082 and 50081	3 x Temperature Sensor (51710 – PTC 100 Sensor Kit, 50082 – PT 100 Sensor Kit and 50081 – PTC 120 Sensor Kit)

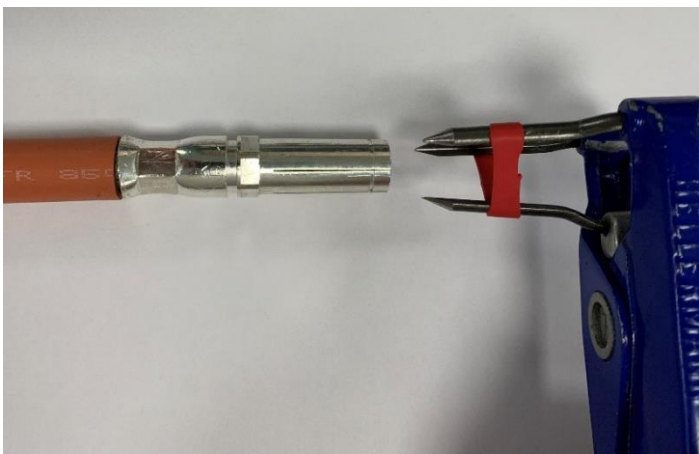
2. Assembly Instructions

2.1 Fitting Elastic Sleeve into Contact

1. Slide the elastic sleeve onto the prongs and push the plier handle to expand the sleeve.



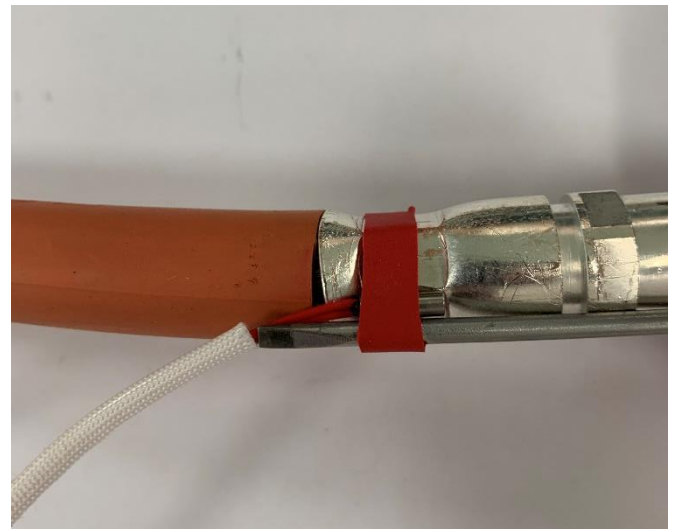
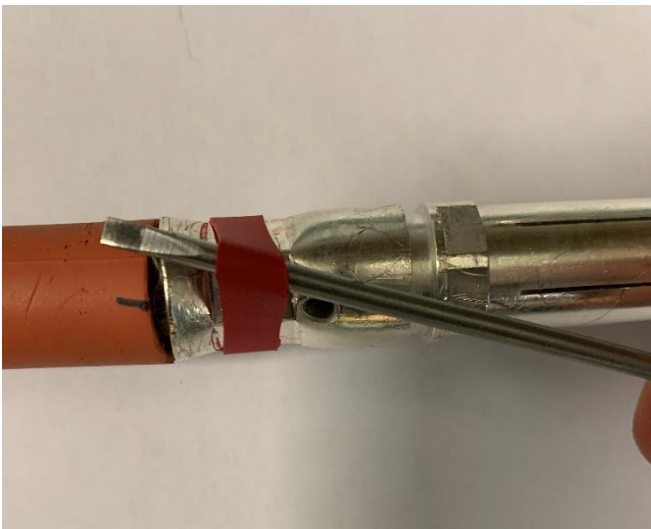
2. Slide the elastic sleeve over the power tube real half and close the pliers while firmly pulling the handle to get the elastic sleeve to slide on to contact as the prongs retract. Ensure that elastic sleeve sits over the crimped portion of the power contact.





2.2 Fitting Temperature Sensor

1. Using a small screwdriver, lift the elastic sleeve and slide the temperature sensor so it sits evenly under the sleeve.



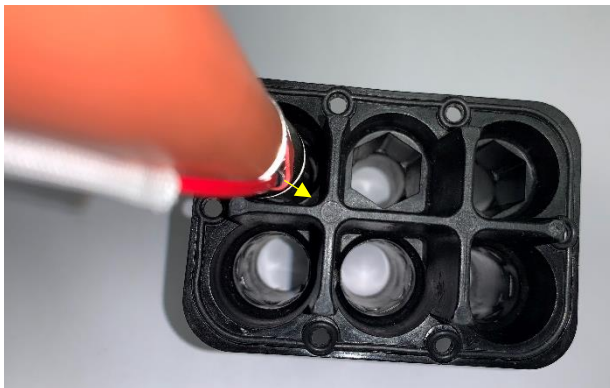
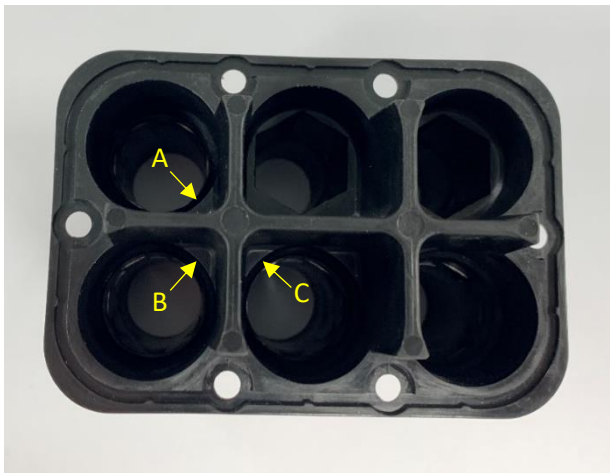
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2. Pull the screwdriver out and ensure the temperature sensor is held in position by the elastic sleeve.

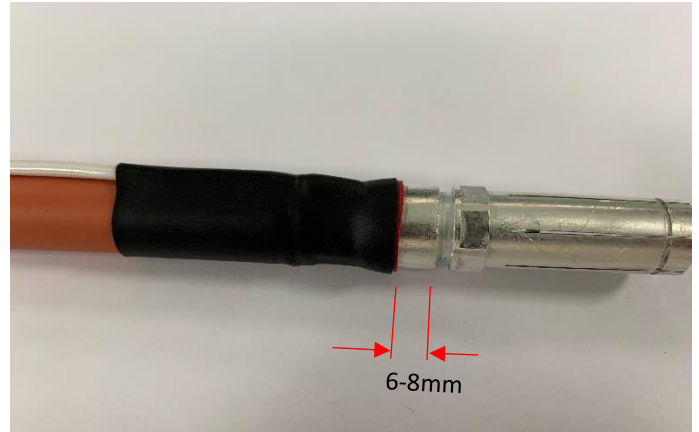


3. Fit tube to moulding, adjust position of sensor so it sits in the pocket of inner block. Remove and fit heat shrink.



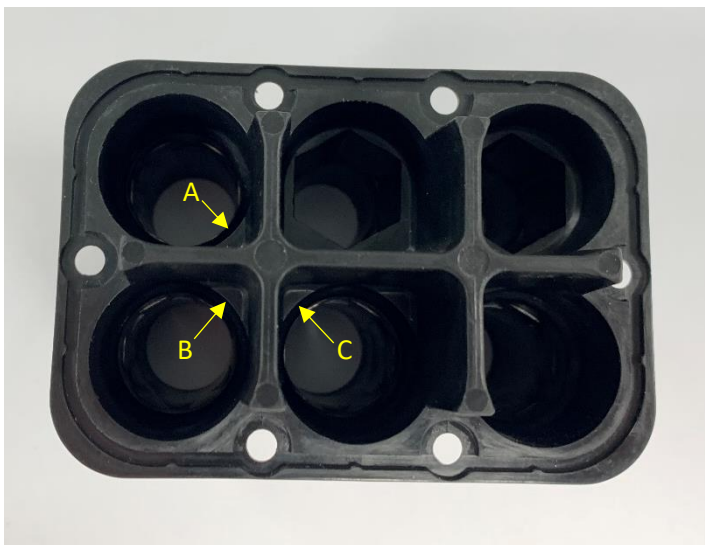
2.3 Heat-Shrink over the temperature sensor

1. Cover the cable and rear half of the power contact at the crimp joint using supplied heat-shrink by using hot air gun.



2.4 Inserting power contact into inner block moulding

1. Insert the power tube rears fully into position A, B, C and N of the inner block moulding. Ensure that power tubes with temperature sensor incorporated are positioned correctly. Adjust the contact in order to have temperature sensor sitting in a pocket of the inner block moulding.



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2. Ensure that power tubes are inserted fully to make grooves visible for large circlips to be placed.

