

Assembly Instructions for AC Saf-D-Grid® Ultra Short Receptacle
2016G1-LPBK / 2016G2-LPBK Receptacle Contact, Solder Type
2300GX Series Receptacle Housing

Soldering Method #1, 2300GX Series Saf-D-Grid Receptacle with contacts

 (See Video Link on Page 2)

A 1/8" wide screwdriver tip and Ø.032" lead-free solder is recommended for use. Solder of 99.2 Sn/0.3 Ag/0.5 Cu composition works well.

Prior to soldering, strip back the wire insulation 0.35" ± 0.01" (8.9 mm ± 0.3 mm). 2016G1-LPBK contacts should be used with 18 AWG wires only. 2016G2-LPBK contacts should be used with 12 and 10 AWG wires. The conductors should be looped through the hole in the contact prior to soldering (Figure 1)

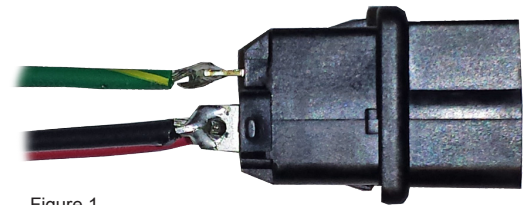


Figure 1

During soldering, only the wires should be heated rather than the terminal to avoid excessive heating of the plastic housing (Figure 2). As the solder wicks in, it will heat up and properly wet the terminal. Total solder time shall be 4-6 seconds to avoid excessive heating of the housing. Example solder joints are shown in (Figure 3).

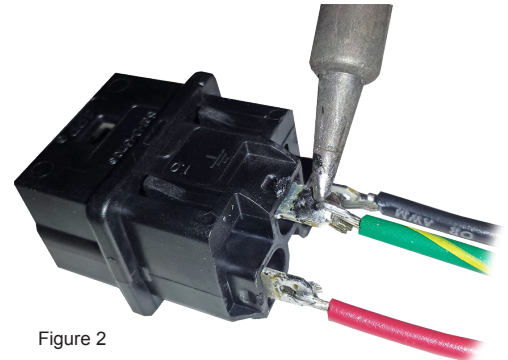


Figure 2

If a longer duration solder time is required, a mating plug can be installed before soldering to avoid overheating the housing.

After soldering has been completed, height of the power contacts can be verified with a gauge pin as shown in (Figure 4). The contact should not be nose up after soldering, beyond what is shown below which will avoid mating issues with the plug.

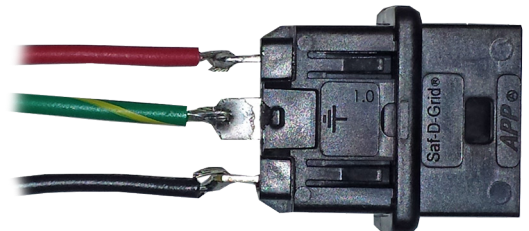


Figure 3

It is recommended to cover the solder joint with shrink tubing. An example of a completed assembly is shown in (Figure 5).



Figure 5

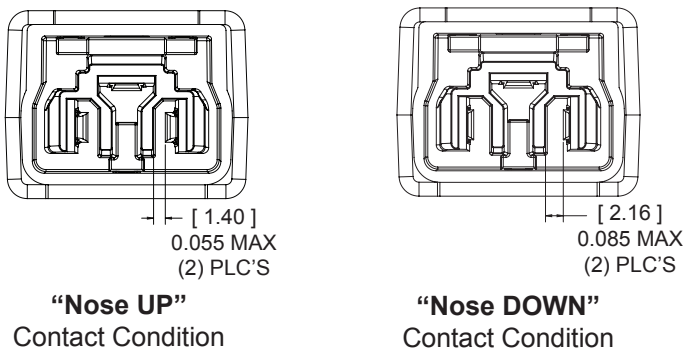


Figure 4

Soldering Method #2, 2300GX Series Saf-D-Grid Receptacle with contacts sold separately

A 1/8" wide screwdriver tip and Ø.032" lead-free solder is recommended for use. Solder of 99.2 Sn/0.3 Ag/0.5 Cu composition works well.

Prior to soldering, strip back the wire insulation 0.35" ± 0.01" (8.9 mm ± 0.3 mm). 2016G1-LPBK contacts should be used with 18 AWG wires only. 2016G2-LPBK contacts should be used with 12 and 10 AWG wires. The conductors should be looped through the hole in the contact prior to soldering (Figure 6). Example solder joints are shown in (Figure 7).

Once the contacts have been soldered, they should be inserted into the receptacle housing (Figure 8). The ground contact should be inserted into the top position, ⊥ perpendicular to the power contacts. The line wire should be inserted in the position marked with a "L" on the bottom of the housing. The neutral wire should be inserted in the position marked with a "N" on the bottom of the housing. Once the contacts have been inserted, pull slightly to verify they are fully seated past the internal spring.



Figure 6



Figure 7

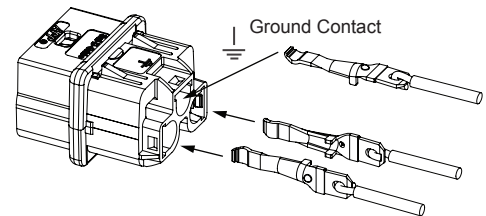


Figure 8

For demonstration of **Soldering Method #1**, see the below referenced video on YouTube.



http://youtu.be/Xh64r_LwvWA

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