

## Assembly Instructions for Saf-D-Grid® Ultra Short Receptacle

2016G1-LPBK Receptacle Contact, Solder Type  
2006G Series Receptacle Housing

### Soldering Method #1, 2006G1 (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 .35" [8.9mm] ± .01" [0.3mm]. These contacts should not be soldered to wires smaller than 18AWG and larger than 14AWG.

The conductors should be looped through the hole in the contact prior to soldering (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.

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.

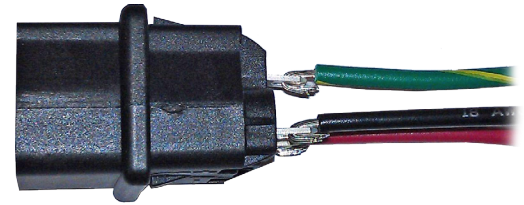


Figure 1

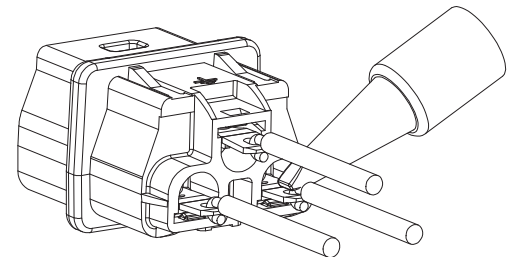


Figure 2

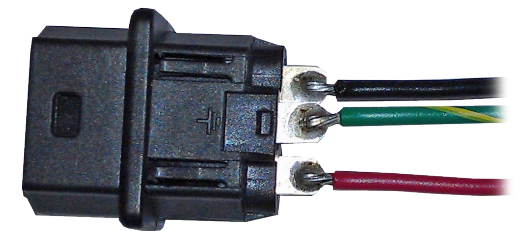


Figure 3

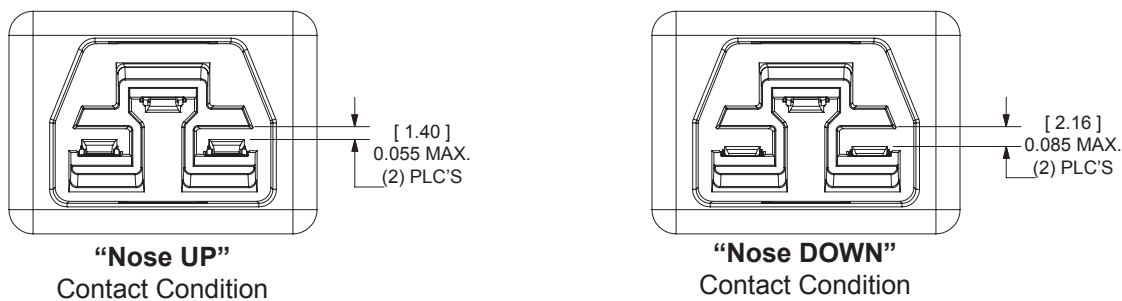


Figure 4

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

### Soldering Method #2, 2006G1-NC and 2016G1-LPBK

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" [8.9mm] ± .01" [0.3mm]. These contacts should not be soldered to wires smaller than 18AWG and larger than 14AWG.

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 inverted relative to the power contacts. The positive wire should be inserted in the position marked with a "+" on the bottom of the housing. The negative wire should be inserted in the position marked with a "-" on the bottom of the housing. Once the contacts have been inserted, pull slightly to verify they are fully seated past the internal spring.

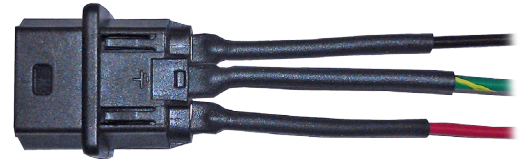


Figure 5



Figure 6



Figure 7

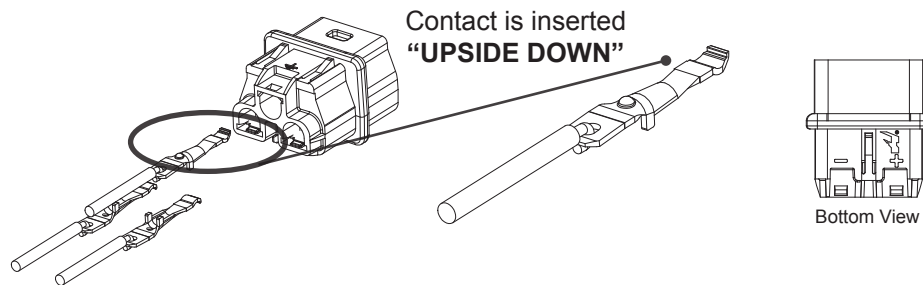


Figure 8

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



[http://youtu.be/Xh64r\\_LwvWA](http://youtu.be/Xh64r_LwvWA)

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