

The insert blocks can be used to press-in **harbus[®] HM** male connectors without any special top tool. These blocks will be put into the connectors manually or automatically (using insertion removal station, see page 15.13).

To press-in the connector no precise position is needed and can be done by a simple flat rock die. This will accelerate the cycle time of the press-in process dramatically.

Insert blocks are developed for use with a loadnest.

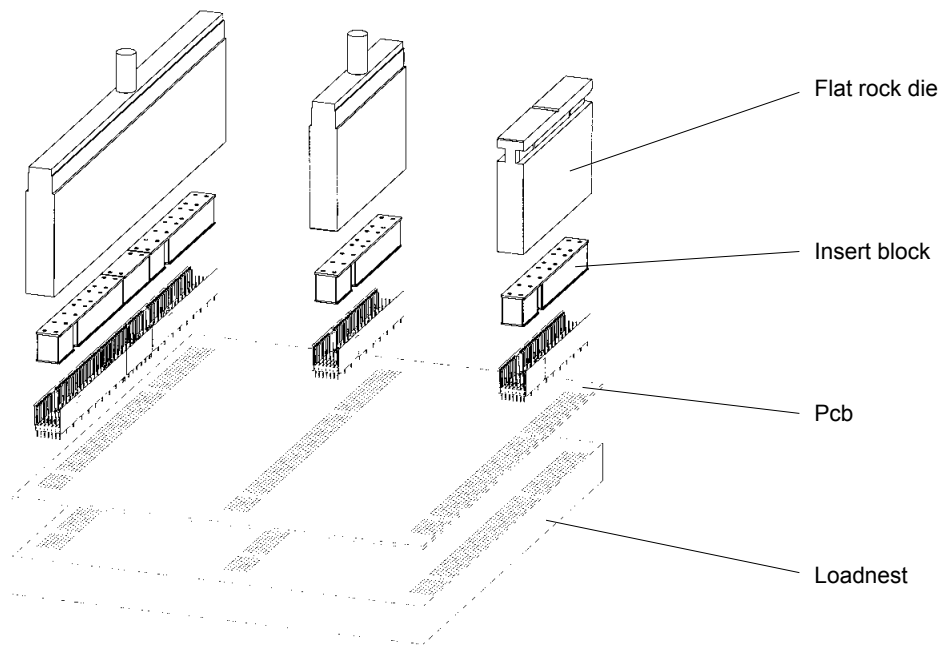


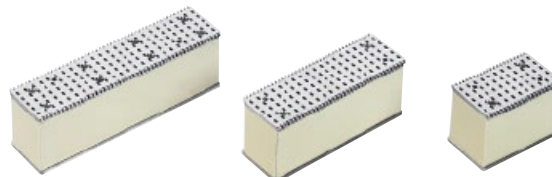
Fig. 5: Application samples for insert blocks

Insert blocks for straight male connectors

Part number connector	Tool identification	Quantity and part number tool
17 01 xxx xxxx	Insert block for type A	1 x 17 99 000 0009 or (2 x 17 99 000 0001)
17 04 xxx xxxx	Insert block for type B	1 x 17 99 000 0004
17 05 xxx xxxx	Insert block for type B	1 x 17 99 000 0002
17 02 xxx xxxx	Insert block for type B	1 x 17 99 000 0003
17 03 xxx xxxx	Insert block for type C	1 x 17 99 000 0001
17 06 xxx xxxx	Insert block for type Monoblock 47	1 x 17 99 000 0008 or (1 x 17 99 000 0001 and 1 x 17 99 000 0005)
17 11 xxx xxxx	Insert block for type D	2 x 17 99 000 0006
17 12 xxx xxxx	Insert block for type E	1 x 17 99 000 0007
17 13 xxx xxxx	Insert block for type AB	1 x 17 99 000 0069
17 14 xxx xxxx	Insert block for type AB	1 x 17 99 000 0070
17 15 xxx xxxx	Insert block for type AB	1 x 17 99 000 0071
17 10 xxx xxxx	Insert block for type DE	1 x 17 99 000 0072
17 4x xxx xxxx	Insert block for type 6-row with 72 contacts	1 x 17 99 000 0090
17 4x xxx xxxx	Insert block for type 6-row with 144 contacts	1 x 17 99 000 0091

Flat rock dies

Part number connector	Tool identification	Part number tool
17 xx xxx xxxx	Flat rock die for 6U	07 79 000 0155
17 xx xxx xxxx	Flat rock die for 3U	07 79 000 0156



The insert block 17 99 000 0001 e.g. can be used for the types A, C and Monoblock 47.