

# PP4x Connector

## Assembly Instructions

**WARNING** - Connectors should never be assembled or disassembled when contacts are live.

**NOTE:**  
Instructions are included with each crimp tool for terminating specific contacts. Use of non-Anderson Power crimp can effect UL & CSA approval. See website for comprehensive tooling data.

### Crimping Wire Contacts In Hand Tool

1. Strip insulation from the end of the wire to be terminated to dimension shown, being careful not to damage the copper conductors. (See Figure 1)

Follow the appropriate crimp instructions for either the hand tool (1S6506) or the manufacturer's instructions for semi-automatic crimp tool applicator (Part No. 680673-3). The maximum dimension across the crimp must not exceed 0.058 inches (1.47mm) or the contact will not latch into the housing. Note that the insulating jacket will not be encapsulated into the crimp. Crimps should be verified for the specific application due to variations in wire and stranding. See website for crimp instructions, [www.andersonpower.com](http://www.andersonpower.com).



[ 4.8 mm ]  
0.19 inches



Figure 1

### Insertion Of Contacts Into Housing

1. Crimped contacts are to be inserted from the rear side of the connector.
2. Insert Socket contacts first: Holding the connector in the "Hood Up" orientation (See Figure 2), position the crimped contact so that the contact seam is facing up (See Figure 3). The Socket contacts are inserted into the bottom holes. A tactile snap will be felt when contact is latched. Apply a slight tug to confirm latching. Contact retention should be 5.4 lbf (24N) minimum. Note that if the wire is rotated during insertion, so that the contact seam is not facing up, the contact will not insert properly into the housing.
3. Next insert the Pin contacts: Holding the connector in the "Hood Up" orientation (See Figure 2), position the crimped contact so that the contact seam is facing down (See Figure 4). The Pin contacts are inserted into the top holes. A tactile snap will be felt when contact is latched. Apply a slight tug to confirm latching. Contact retention should be 5.4 lbf (24N) minimum. Note that if the wire is rotated during insertion, so that the contact seam is not facing down, the contact will not insert properly into the housing.

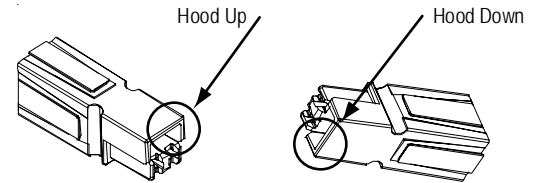


Figure 2

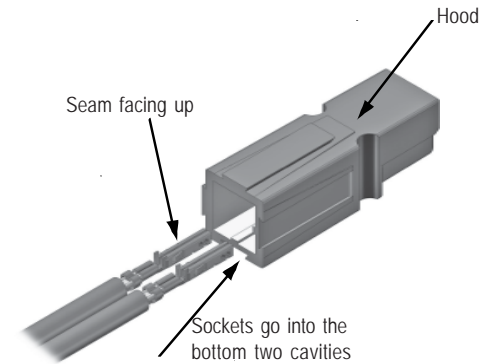


Figure 3

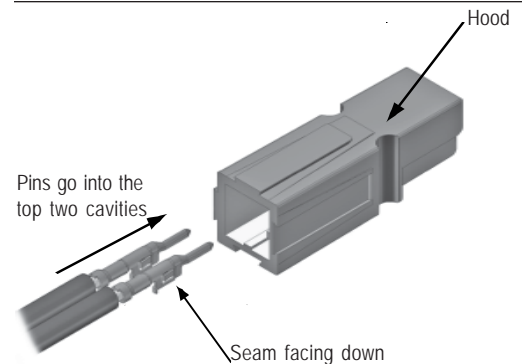


Figure 4

### Contact Removal

Contact removal from the PP4x housing is not recommended. If required, wires should be cut and re-crimped with new contacts. Existing housing and contacts should be disposed of.

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All Data Subject To Change Without Notice

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