

Title (en)
ELECTRICAL HARNESS FABRICATION METHOD AND APPARATUS

Publication
EP 0216464 B1 19920909 (EN)

Application
EP 86305723 A 19860725

Priority
US 77810385 A 19850920

Abstract (en)
[origin: EP0216464A1] A double-ended electrical cable harness is produced in which the wires (40) of a first end thereof are mass terminated to an electrical connector (14) having a plurality of insulation displacement terminals (18). A connector (14) is loaded onto a first transport assembly (50), and the first ends of the wires (40) are terminated to the connector at a termination station (58). The second harness end is prepared by removably mounting one of a plurality of different modules (68) to a second transport assembly (52), and actuating the module at the termination station (58) to finish the second harness end. The apparatus performs various operations on a connector (14) having at least two rows of terminal receiving cavities (32). stacked one on top of the other in a staggered fashion, so that wires (40) may be inserted in each of the cavities from a common connector surface (20). The operations include elevating the connector (14) toward an array of wires (40) so as to form and align the wires for simultaneous termination in all of the cavities (32). Other operations include separating a connector stick into a number of independent connector modules (46), by removing web portions (44) integrally molded with the connector modules (46). Another operation includes removing polarizing pegs (116) extending from one end of a connector stick, prior to its separation into individual modules (46).

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CPC (source: EP)
H01R 43/28 (2013.01); **H01R 43/01** (2013.01)

Citation (examination)
US 4091531 A 19780530 - GRUBB DANIEL BAKER, et al

Cited by
CN103682951A; US5155907A; CN103317342A; CN110752501A; US10522985B2

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EP 86305723 A 19860725; DE 3686691 T 19860725; JP 21368786 A 19860910