

**AIPS**  
**Airbus Industrie Process Specification**

**Installation of plug connector ASNE0511**

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## 1 Scope

The purpose of this specification is to give Design and Quality requirements to manufacturers. Although the essential requirements of a process will be described in detail, the specification does not give complete in-house operating instructions, these shall be given in the manufacturers supporting work instructions.

This specification shall not be used as an inspection document unless parts or assemblies have been manufactured to this specification.

This document specifies the process to be used to install plug connector ASNE0511.

## 2 Normative references

AIPS 07-02-001 General requirements for the stripping of electrical cables

## 3 Applicability, limitations and definitions

This document is applicable for any manufacture or installation of bundles and harnesses during the life time of the aircraft.

Only the practices defined in this document are authorized.

## 4 Requirements to be met by a process

### 4.1 Design requirements

See AIPS 07-02-001.

### 4.2 Quality requirements

See § 6.2.

## 5 Process qualification

Not applicable

## 6 Process work and quality control instructions

### 6.1 Process work instructions

#### 6.1.1 Products (See also relevant standard)

##### 6.1.1.1 Plug connectors

Electric plug connectors ASNE0511 are used for the electrical connection of the standby compass lighting.

These plug connectors are cylindrical, consist of 4 items screwed together and are made of copper alloy (non-magnetic).

Locking to corresponding receptacle is ensured by clipping.

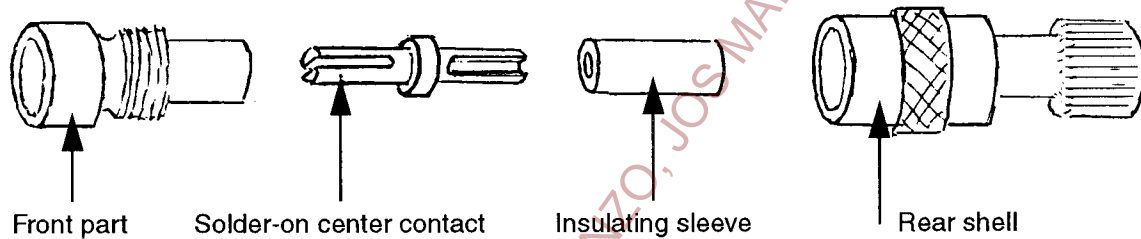


Figure 1

The characteristics of these connectors can be found in standard ASNE0511.

##### 6.1.1.2 Associated items

- A flat stainless steel washer AN 960 C4 or AN 960 C4L must be placed between the insulating sleeve and the rear shell.
- Cable as per NSA 935344 XE.

##### 6.1.2 Tools

- Stripping tools as per AIPS 07-02-001.

### 6.1.3 Process

#### 6.1.3.1 Stripping, preparation

- Cut the cable to length.
- Slide the rear shell over the cable.

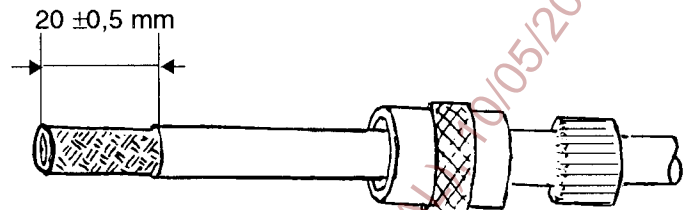


Figure 2

- Strip the braid over 20 mm and fold back over the cable.
- Strip the core and its insulation over the lengths shown opposite.

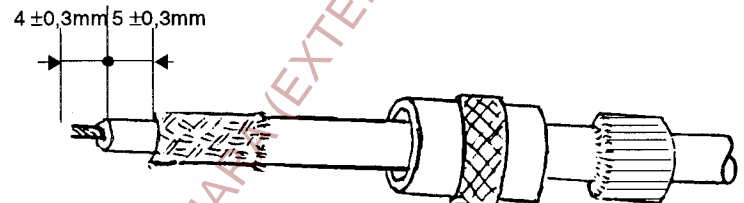


Figure 3

- Slide washer AN 960 C4 then the insulating sleeve over the cable.

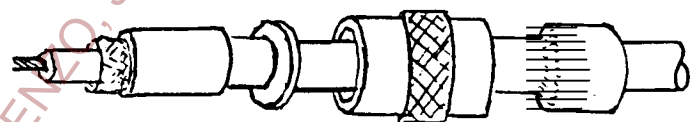


Figure 4

#### 6.1.3.2 Soldering and assembly

- Solder the center contact.
- Slide the insulating sleeve up to the center contact then the washer up to the sleeve.

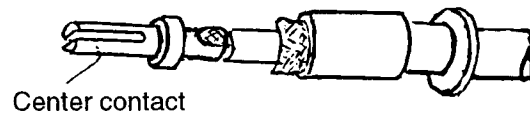


Figure 5

- Splay the braid against the washer to ensure correct contact on washer surface.
- Cut the strands with the scissors flush with the outside surface of the washer.

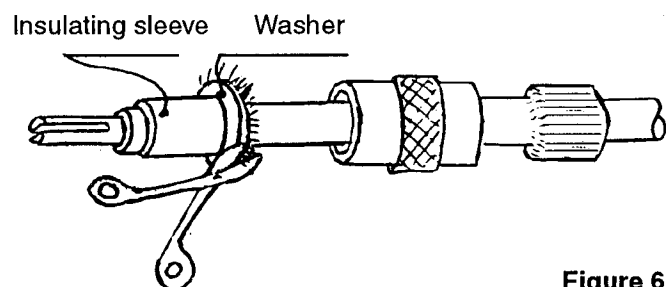


Figure 6

- Insert the assembly into the front part of the plug connector, slide up the rear shell and screw in fully ensuring that the front part does not turn.

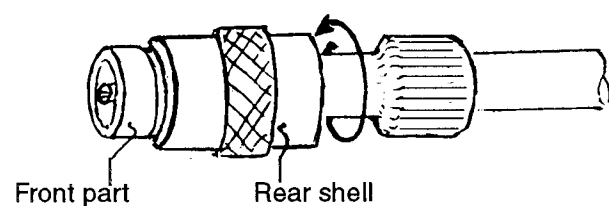


Figure 7

## 6.2 Quality control instructions

### 6.2.1 Results to be obtained

Correct installation of the connector conserving the electrical and mechanical characteristics of the component.

The following checks shall be performed by the Quality department, who will check that the quality of the operations is correct, or by an operator approved by the Quality department.

### 6.2.2 Inter-operation and final checks

- Check that stripping lengths are complied with and stripping operations performed in compliance with procedure defined in AIPS 07-02-001.
- Check the tightening of the rear shell.
- Check that the center contact is soldered correctly.

## 7 Health and safety

This specification does not necessarily detail all the precautions necessary to meet the requirements of health and safety.

It is the responsibility of the user of this specification to consult and establish appropriate Health and Safety precautions and the method should be operated only by trained personnel.