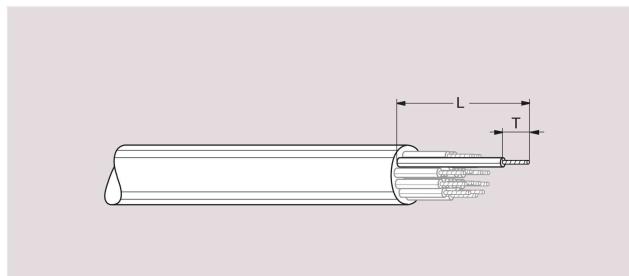
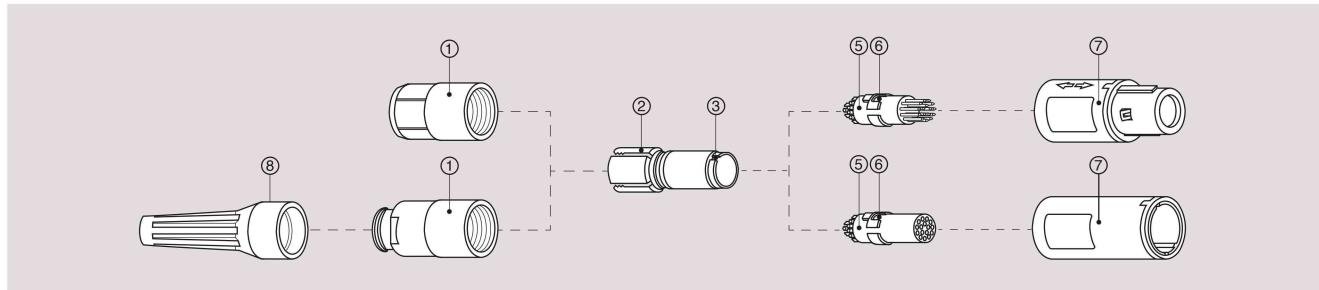


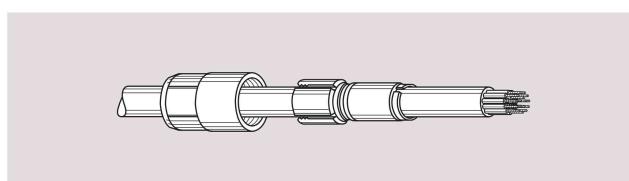
Assembly instructions

Solder contacts

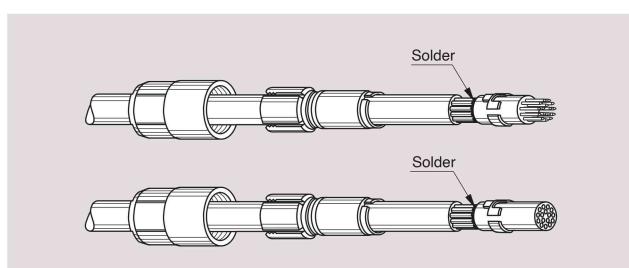


1. Strip the cable according to the lengths given in the table. Tin the conductors.

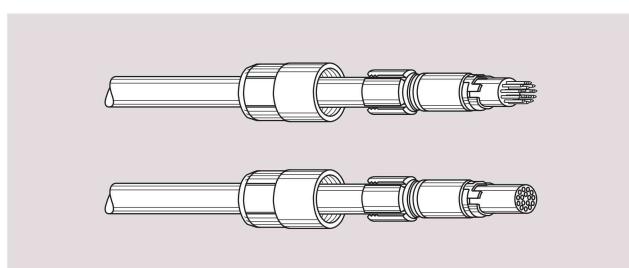
Configuration	Dimensions (mm)	
	L	T
M02	18.0	4.0
M03, M04, M05, M06, M07	18.0	3.5
M08, M10, M12, M16, M19	18.0	3.0
M26, M32, M34	17.0	2.5



2. Slide the collet nut ① and then the collet ② onto the cable. Slide the bend relief ⑧ (if ordered separately) onto the cable.



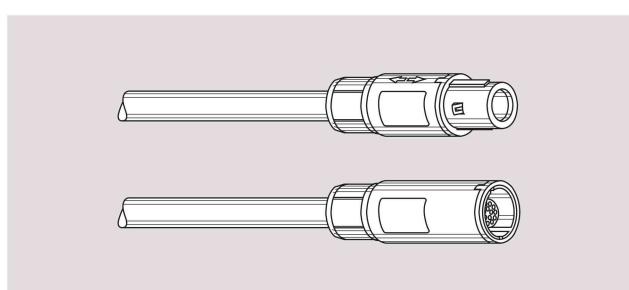
3. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation.



4. Slide the collet ② forward and locate slot ③ in the key of the insulator ⑤.

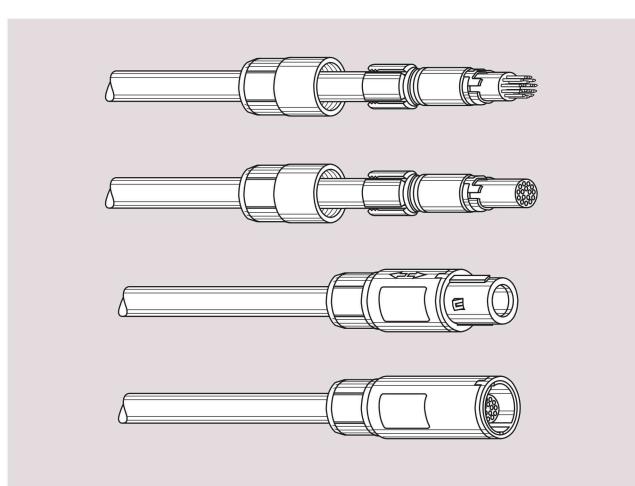
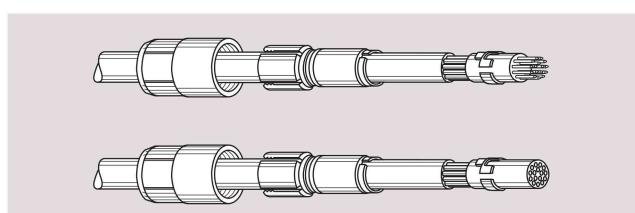
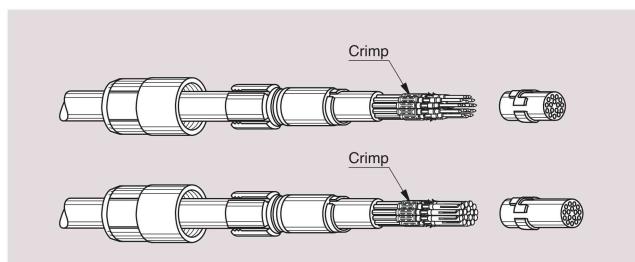
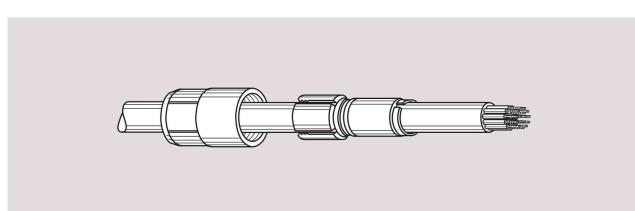
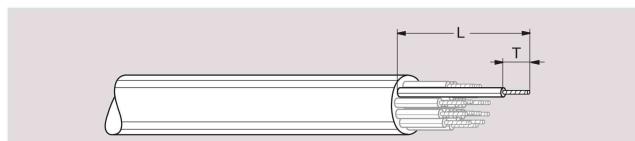
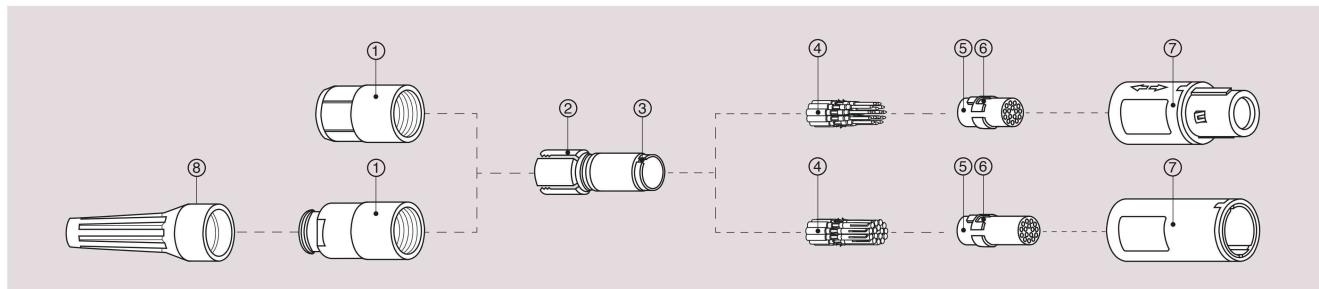
Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ whilst positioning it to ensure that the slot ⑥ of insulator ⑤ locates in the inside key of the shell. Tighten the collet nut ① to the maximum torque of 0.5 Nm.

Push the bend relief ⑧ (if ordered separately) onto the collet nut ①.



For PSU only:

We recommend the use of Vibra-tite VC-6, Araldite CW2243 + Aradur HY 2966, Ablestik FDA2 Trapax or ThreeBond 1401 to secure the connector collet nut. The use of other materials could result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

Crimp contacts


1. Strip the cable according to the lengths given in the table.

Configuration	Dimensions (mm)	
	L	T
M02, M03	21.0	5.5
M04, M05, M06, M07, M08, M10, M12, M16, M19	21.0	4.0

2. Slide the collet nut (1) and then the collet (2) onto the cable. Slide the bend relief (8) (if ordered separately) onto the cable.

3. Fix the appropriate positioner (table page 46) in the crimping tool. Set selector to the number corresponding to the conductor AWG as indicated on the positioner label.

Fit conductor into contact (4) and make sure it is visible through the inspection hole in the crimp barrel. Slide conductor-contact combination into the open crimping tool; make sure that the contact is fully pushed into the positioner. Close the tool. Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole.

4. Now arrange contact-conductor combinations according to the insert marking and locate them into the insert (6). Check that all contacts are correctly located and remain in position when given a gentle pull.

5. Slide the collet (2) forward and locate slot (3) in the key of the insulator (5). Slide collet nut (1) over collet (2) and then push the whole assembly into the shell (7) whilst positioning it to ensure that the slot (6) of insulator (5) locates in the inside key of the shell. Tighten the collet nut (1) to the maximum torque of 0.5 Nm.

Push the bend relief (8) (if ordered separately) onto the collet nut (1).

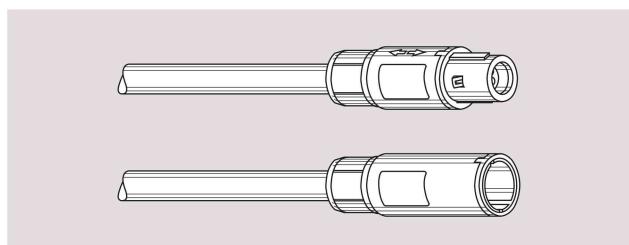
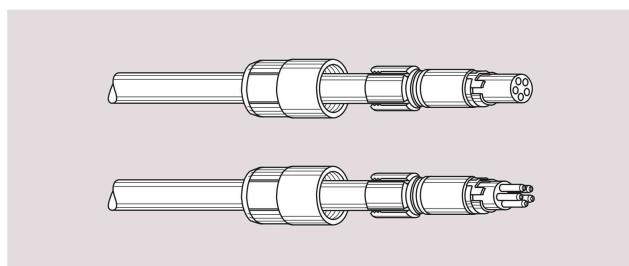
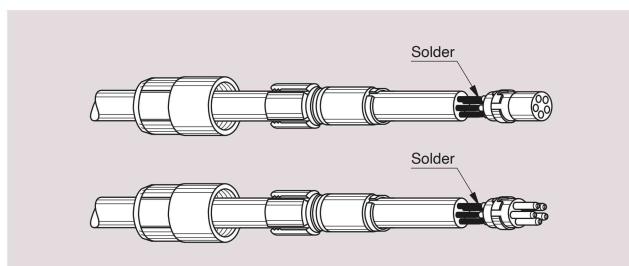
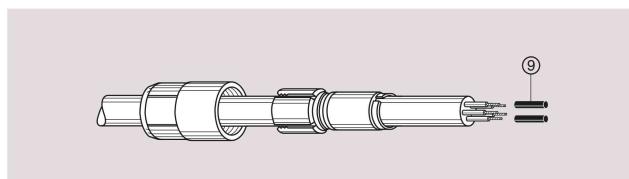
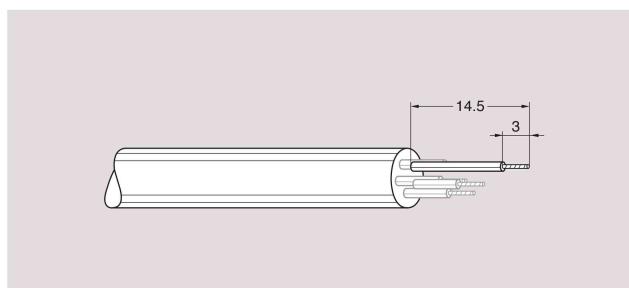
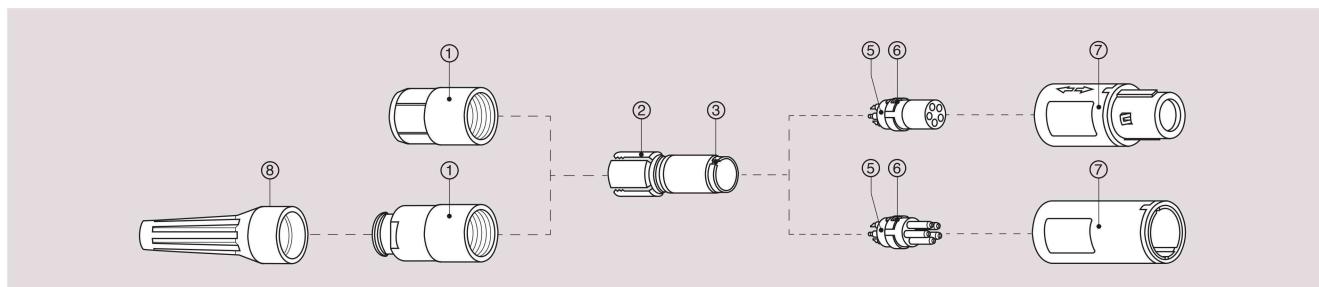
For PSU only:

We recommend the use of Vibra-tite VC-6, Araldite CW2243 + Aradur HY 2966, Ablestik FDA2 Trapax or ThreeBond 1401 to secure the connector collet nut. The use of other materials could result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.

Assembly instructions for high voltage configurations

For H02, H05 and H08 configurations (not applicable for 2P PFA models)

Solder contacts



1. Strip the cable according to the lengths given in the drawing. Tin the conductors.

*** For insert configurations H02, H05 and H08:**

The use of potting type Epoxy* or / and adhesive-lined (strongly recommended) heatshrink tubes (not provided with the connector) over each termination is necessary to achieve the indicated Air Clearance and Creepage distance values as well as the indicated Test voltage.

2. Slide the collet nut ① and then the collet ② onto the cable. Slide the bend relief ⑧ (if ordered separately) onto the cable.

Place the heatshrink sleeve ⑨ (not provided with the connector) over the wires.

3. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation. Put the heatshrink sleeve ⑨ over the solder contacts and heat gently until it retracts.

4. Slide the collet ② forward and locate slot ③ in the key of the insulator ⑤.

Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ whilst positioning it to ensure that the slot ⑥ of insulator ⑤ locates in the inside key of the shell. Tighten the collet nut ① to the maximum torque of 0.5 Nm.

Push the bend relief ⑧ (if ordered separately) onto the collet nut ①.

For PSU only:

We recommend the use of Vibra-tite VC-6, Araldite CW2243 + Aradur HY 2966, Ablestik FDA2 Trapax or ThreeBond 1401 to secure the connector collet nut. The use of other materials could result in damage to the connector. The only recommended chemical cleaner is Isopropyl Alcohol.