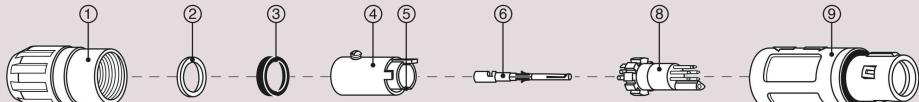


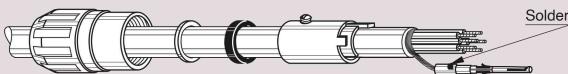
## Assembly instructions

Solder LV contacts

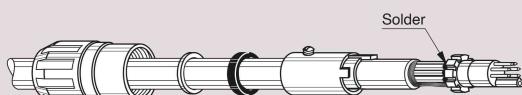


1. Strip the cable according to the lengths given in the table. Tin the conductors. In case of a screened cable separate the braid and twist it apart as shown.

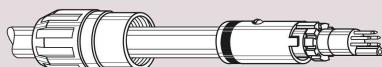
| Configuration | Dimensions (mm) |     |
|---------------|-----------------|-----|
|               | L               | T   |
| 306 - 310     | 13.0            | 3.0 |
| 314 - 318     | 13.0            | 3.0 |



2. Slide the collet nut ①, the washer ②, the seal ③ and the clamping sleeve ④. In case of a screened cable solder the braid into the earthing contact ⑥.

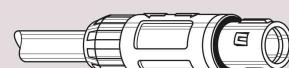


3. In case of a screened cable introduce the earthing contact ⑥ into the insert ⑧. Check that contact is correctly located and remains in position when given a gentle pull. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation.



4. Slide the clamping sleeve ④ forward and locate tag ⑤ into one of the insulator slot according to the selected polarization code. Make sure that same code is used for plug and socket.

Tight the screw of the clamping sleeve ④ to secure the cable. Slide washer and seal against clamping sleeve.



5. Push the whole assembly into the shell ⑨ whilst turning it to insure that the tag ⑤ is correctly located in the inside slot of the shell. Tighten the collet nut ① to the maximum torque of 1.2 Nm.

– Socket mounting nut or screws = 2.3 Nm.

### 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 LV contacts**
