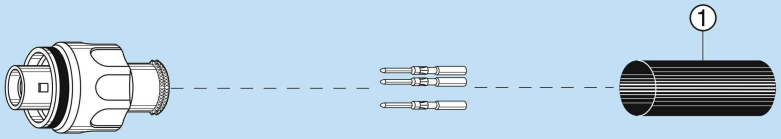
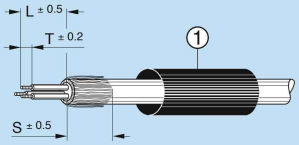
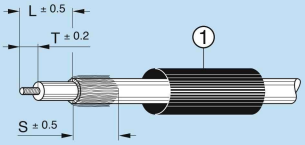
Assembly instructions

For cable mounted models



① heatshrink boot option to be ordered separately





① heatshrink boot to be placed on cable if desired

Cable preparation

- Remove cable jacket and resses the shield onto the cable (shield can be temporary fixed using adhesive tape).
- Strip the cable elements using the dimensions specified in the table below. Dimensions must be selected according to the backshell variant in use.

Multipole

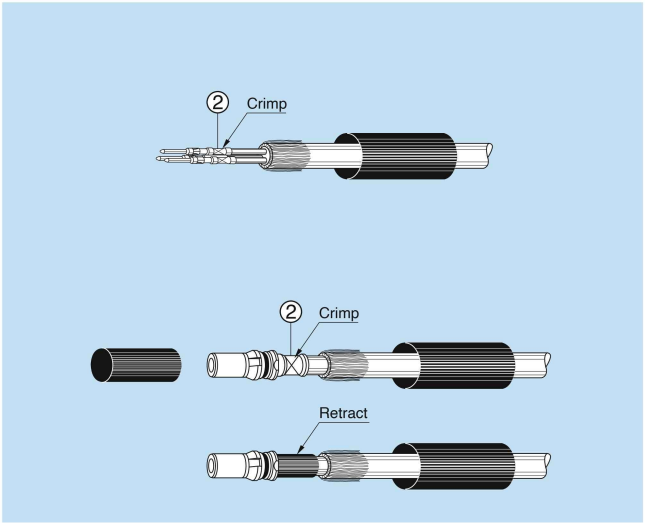
Series	Cable stripping length [1)2)] (mm)					
	P●● / FG● / FM●			FA● / FX● / FW●		
	L	S	T [3)]	L	S	T [3)]
MM	16	18	3.0	21	18	3.0
0M	16	18	3.5	21	18	3.5
1M	16	18	3.5	21	18	3.5
2M	18	20	3.5	23	20	3.5
3M	18	20	3.5	23	20	3.5
TM	20	23	3.5	26	23	3.5
4M	20	23	3.5	26	23	3.5
LM	20	23	3.5	26	23	3.5
5M	20	23	3.5	26	23	3.5

Note:
[1)] indicative values, may need to be adapted according to your cable construction and specific pin allocation.
[2)] for mixed, high speed, USB 2.0, fibre optic models please contact technical support for specific stripping length.
[3)] for 1.3 mm contact «T» = 4 mm (1M.302/1M.303/2M.304).

High Power

Reference	Cable stripping length [1)] (mm)					
	P●● / FG● / FM●			FA● / FX● / FW●		
	L	S	T	L	S	T
3M.H14	24.0	33	10	24.0	27	10
TM.H15	24.0	33	10	24.0	27	10
4M.H16	24.0	33	12	24.0	27	12
LM.H18	27.0	39	13	27.0	33	13
5M.H18	27.0	39	13	27.0	33	13
5M.H34	24.0	30	10	24.0	25	10
5M.G33	24.0 27.5 [2)]	30 30	10 3.5	24.0 27.5 [2)]	25 25	10 3.5 [2)]

Note:
[1)] indicative values, may need to be adapted according to your cable construction and specific pin allocation.
[2)] low power contact.



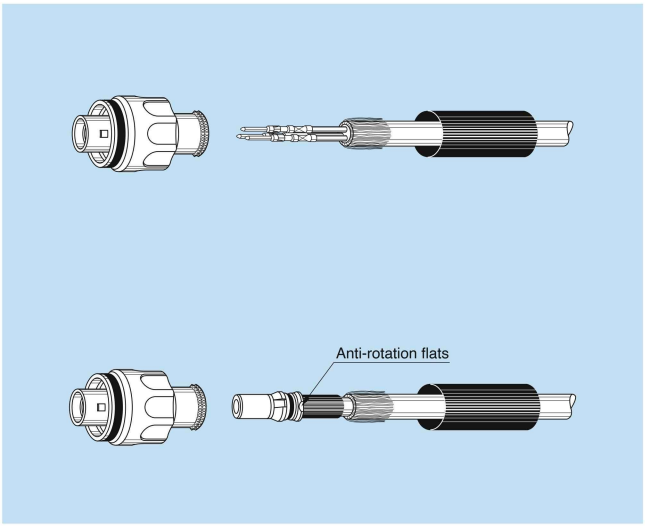
Contact crimping

Multipole versions

- Fix the appropriate positioner onto the crimping tool (see page 41).
- Set the tool selector on the corresponding AWG. Crimping tool setting can be found on the positioner label.
- Insert the conductor into the contact barrel ②; make sure that the conductor is visible through the contact's inspection hole.
- Slide the conductor-contact assembly into the crimping tool and push the contact fully into the positioner.
- Proceed with crimping and check that conductor is securely crimped in the contact. Also check that the conductor is still visible in the contact inspection hole.

• High Power versions

- Select the appropriate crimping tool (see page 44).
- Insert the conductor into the contact barrel ②.
- Slide the conductor-contact assembly into the crimping tool.
- Proceed with crimping and check that conductor is securely crimped in the contact. Also check that all conductor strands are securely fixed into the contact barrel.
- Place the supplied heatshrink tube to cover the crimped zone and cable inner jacket.
- Retract the heatshrink tube in the desired position using a heat gun.



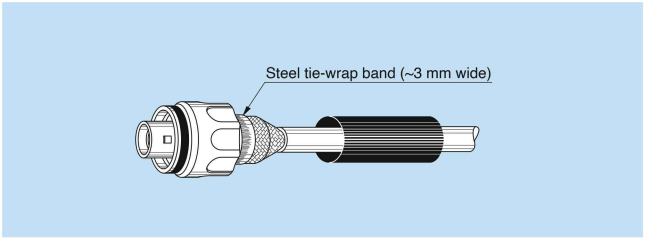
Contact insertion

Multipole versions

- Arrange the conductor-contact assemblies according to the desired pin layout.
- Push the contact firmly into the insulator until mechanical click can be felt. The use of tweezers can facilitate contact insertion.
- Check that all contacts are correctly located in the insulator by verifying:
  1) the alignment of the contacts at the front of the insulator.
  2) by gently pulling on each conductor to verify that they are properly secured into the insulator.
- In case a crimp contact must be disassembled from insulator extraction tool can be found on page 41.

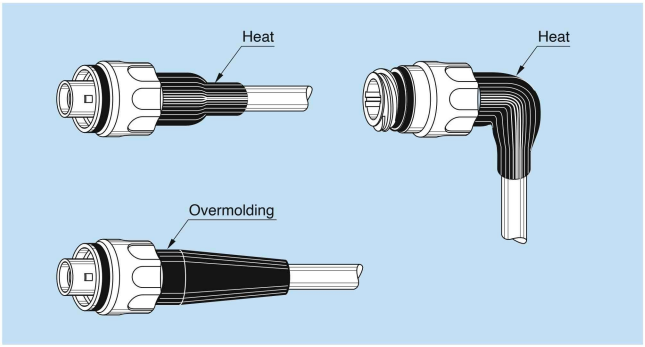
High Power versions

- Arrange the conductor-contact assemblies according to the desired pin layout (multipole only).
- Insert the contact into the insulator, aligning the anti-rotation flats of the contact with the corresponding anti-rotation lugs inside the insulator.
- Push the contact firmly into the insulator until mechanical click can be felt.
- Check that the contact is correctly secured by gently pulling on the conductor.



Braid connection

- Bring the braid around the backshell of the connector.
- Position the braid fixing accessory (tie-wrap or constant force spring clips, to be ordered separately).
- Proceed to braid fixing accessory installation using the dedicated tool.
- Recess the excess braid over the braid fixing accessory and trim the excess length.



Bend relief installation

Heatshrink boot versions

- Position the heatshrink boot (to be ordered separately) over the backshell by taking special care of keeping the braid in position under the boot.
- Gently retract the heatshrink boot using a heat gun.

Overmolding versions

- For overmolding versions previous steps like contact insertion might need special preparation according to overmolding process in use. Contact us for details on specific overmolding preparation.

Note: the elbow version in not recommended for High Power versions.