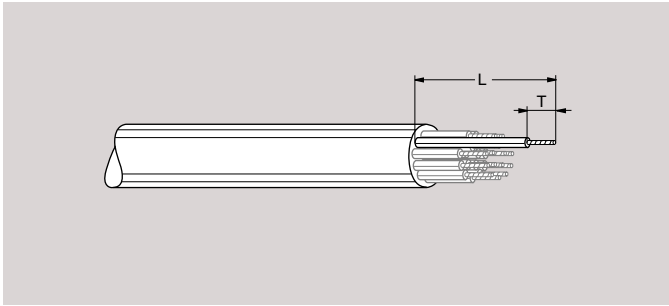
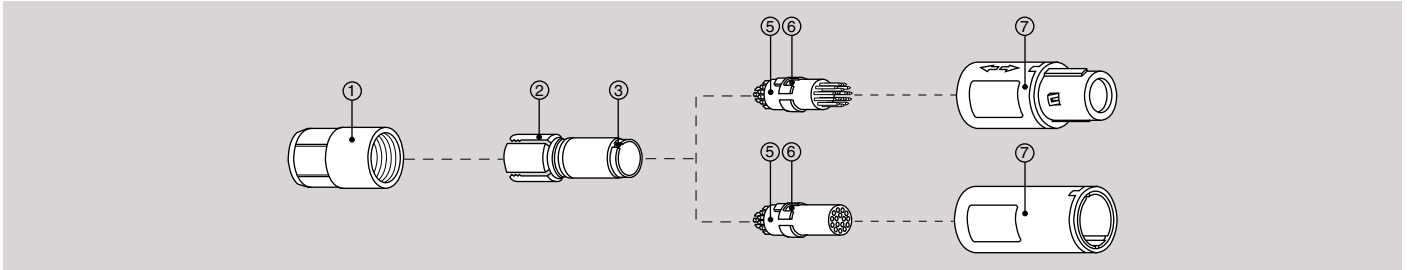


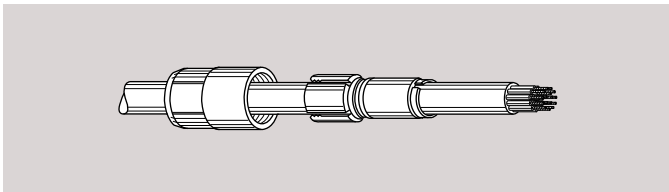
Assembly instructions

Solder contacts

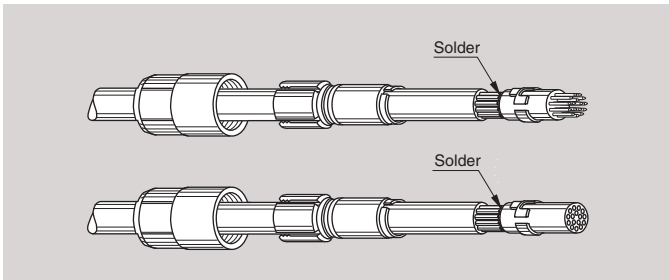


1. Strip the cable according to the lengths given in the table. Tin the conductors.

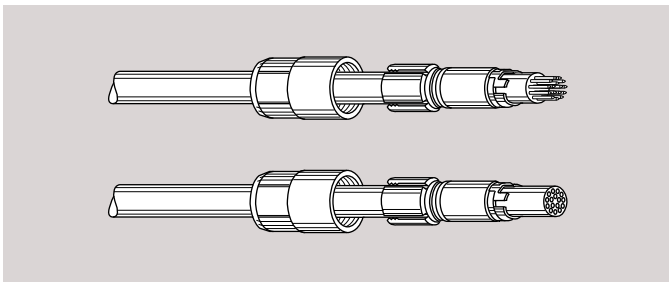
Configuration	Dimensions (mm)	
	L	T
M02	19.0	4.0
M03	19.0	3.5
M04, M05, M06, M07	18.0	3.5
M08, M10, M12, M16, M19	17.0	3.0
M26, M32	17.0	2.5



2. Slide the collet nut ① and then the collet ② onto the cable.

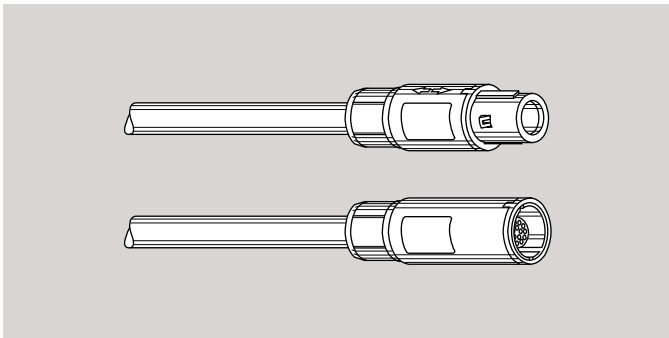


3. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation.



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

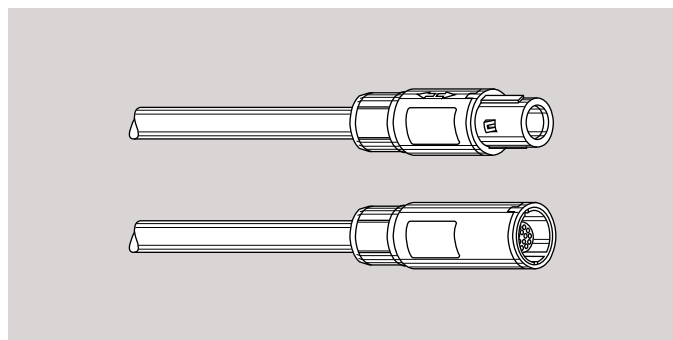
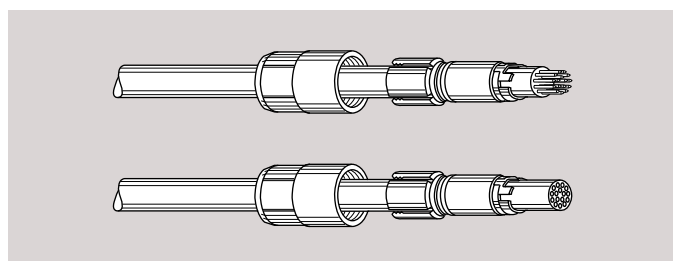
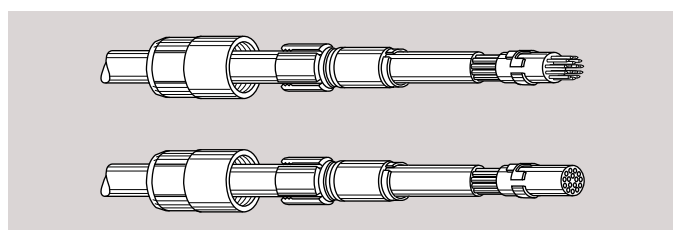
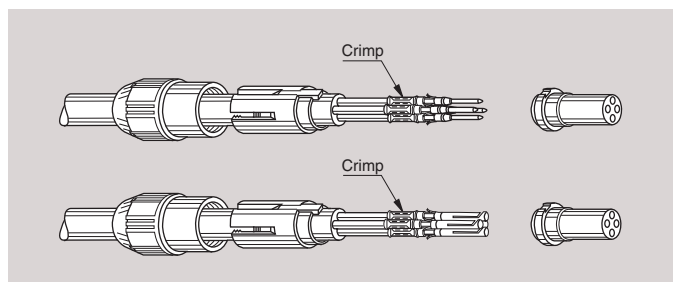
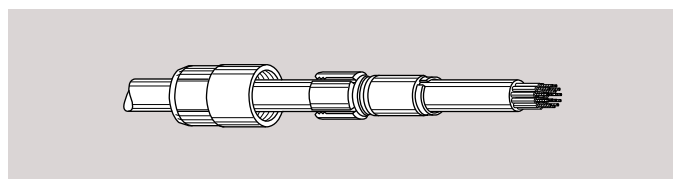
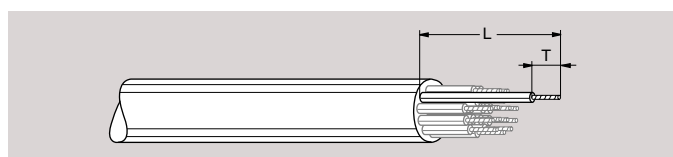
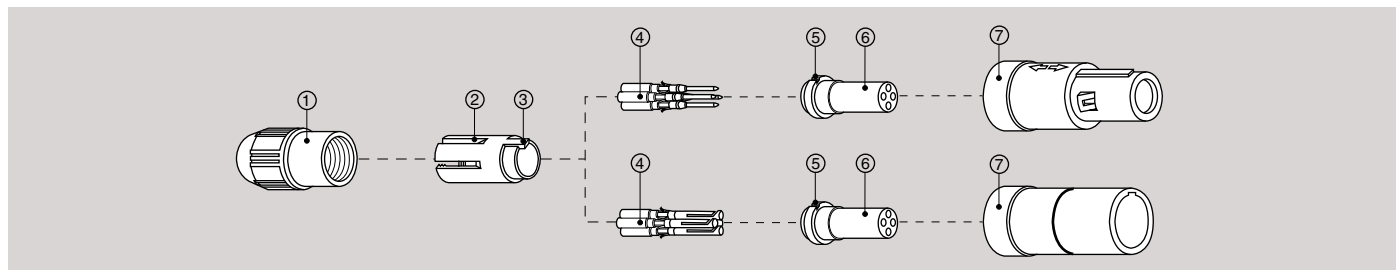
Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ whilst positioning it to ensure that the slot ⑥ of insulator ⑤ locates in the inside key of the shell. Tighten the collet nut ① to the maximum torque of 0.5 Nm.



For PSU only:

We recommend ONLY the use of VTCS-6 Clear Vibra-tite or ThreeBond 1401 to secure the connector backnut. 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	17.0	5.5
M03	17.0	5.5
M04, M05, M06, M07	15.0	4.0
M08, M10, M12	15.0	4.0
M16, M19	15.0	4.0

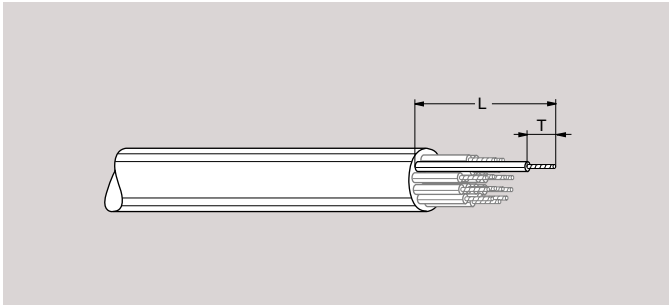
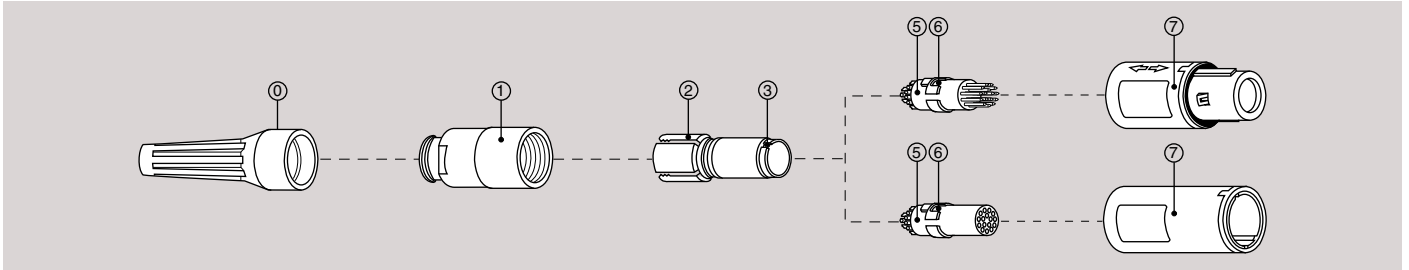
2. Slide the collet nut ① and then the collet ② onto the cable.
3. Fix the appropriate positioner (table page 45) in the crimping tool. Set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into contact ④ and make sure it is visible through 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.

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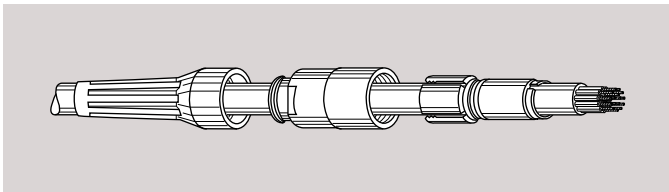
Assembly instructions for watertight models

Solder contacts

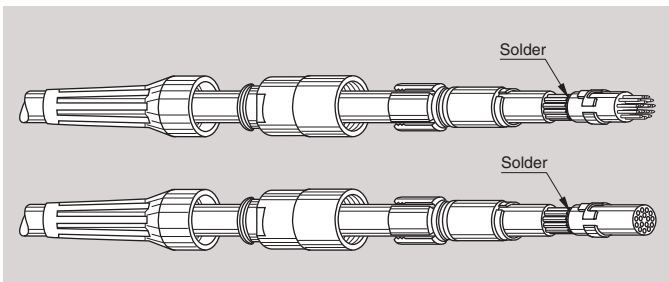


1. Strip the cable according to the lengths given in the table. Tin the conductors.

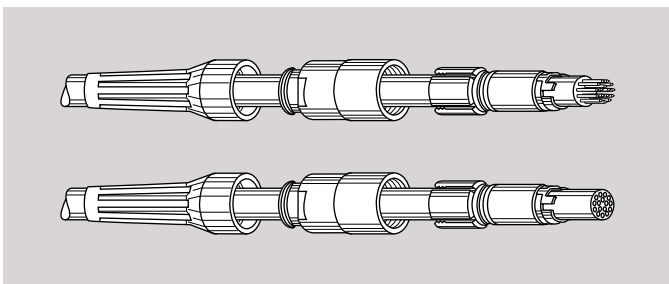
Configuration	Dimensions (mm)	
	L	T
M02	19.0	4.0
M03	19.0	3.5
M04, M05, M06, M07	18.0	3.5
M08, M10, M12, M16, M19	17.0	3.0
M26, M32	17.0	2.5



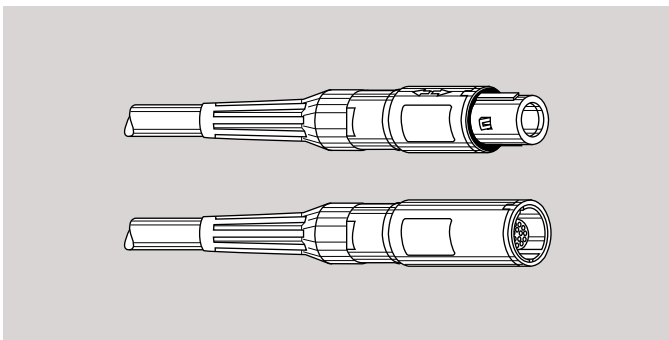
2. Slide the bend relief ⑧, the collet nut ① and then the collet ② onto the cable.



3. Solder conductors into contacts, making sure that neither solder nor flux gets onto the insulator or cable insulation. Fill up completely the inside of the collet ② and the gap between conductors with the adhesive/sealant DOW CORNING type 3145RTV.



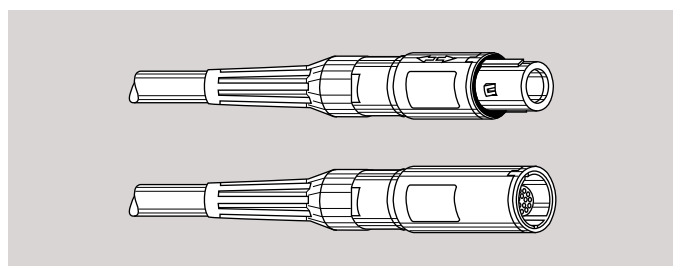
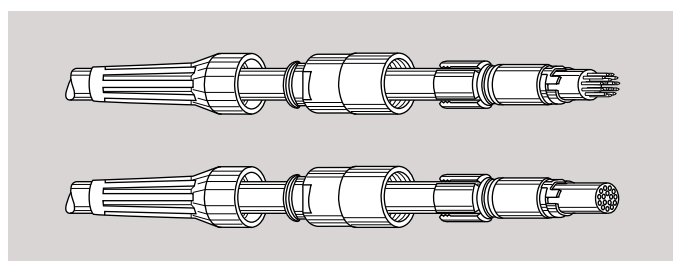
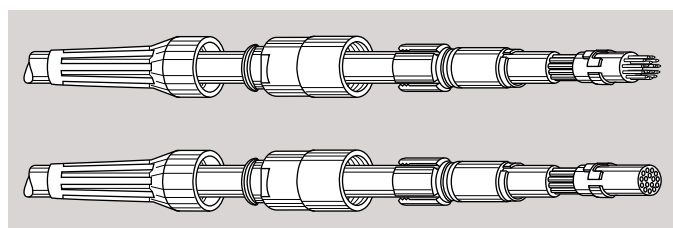
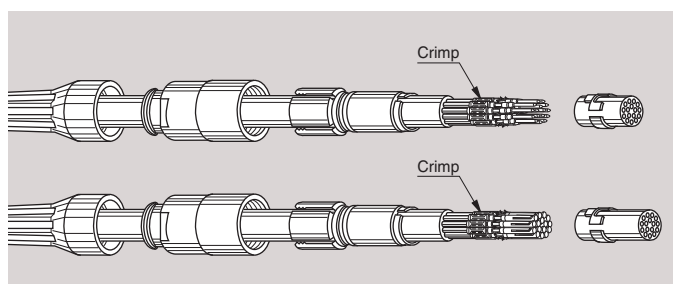
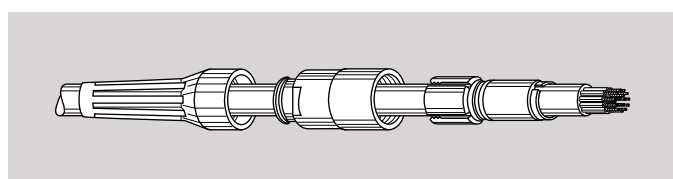
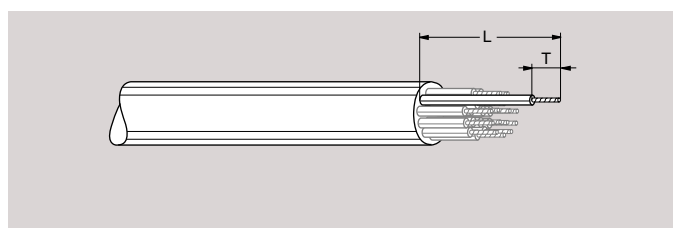
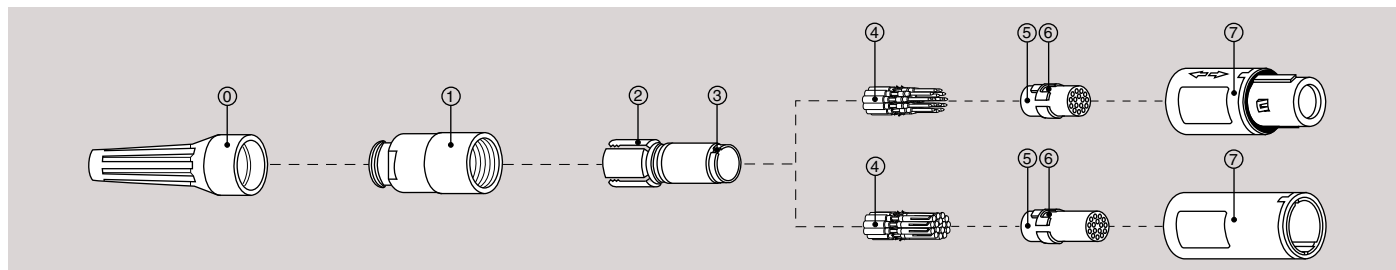
4. Slide the collet ② forward and locate slot ③ in the key of the insulator ⑤.
Slide collet nut ① over collet ② and then push the whole assembly into the shell ⑦ whilst positioning it to ensure that the slot ⑥ of insulator ⑤ locates in the inside key of the shell. Tighten the collet nut ① to the maximum torque of 0.5 Nm. Push the bend relief ⑧ onto the collet nut ①.



For PSU only:

We recommend ONLY the use of VTCS-6 Clear Vibra-tite or ThreeBond 1401 to secure the connector backnut. 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	17.0	5.5
M03	17.0	5.5
M04, M05, M06, M07	15.0	4.0
M08, M10, M12	15.0	4.0
M16, M19	15.0	4.0

2. Slide the bend relief[®], the collet nut ① and then the collet ② onto the cable.

3. Fix the appropriate positioner (table page 45) 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 ④. 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 ⑤ of insulator ④ locates in the inside slot of the shell. Tighten the collet nut ① to the maximum torque of 0.5 Nm.
Push the bend relief[®] onto the collet nut ①.

For PSU only:

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