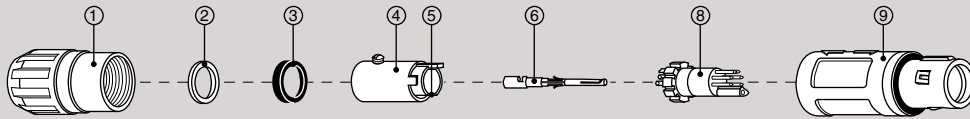


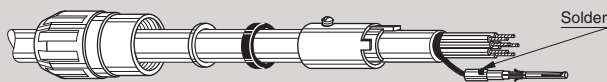
Assembly instructions

Solder LV contacts

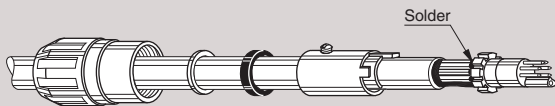


1. Strip the cable according to the lengths given in the table. Tin the conductors. In case of a screened cable separate the braid and twist it apart as shown.

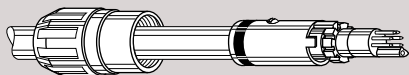
Configuration	Dimensions (mm)	
	L	T
306 - 310	13.0	3.0
314 - 318	13.0	3.0



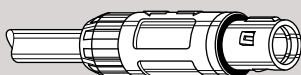
2. Slide the retaining nut ①, the washer ②, the seal ③ and the clamping sleeve ④. In case of a screened cable solder the braid into the earthing contact ⑥.



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.



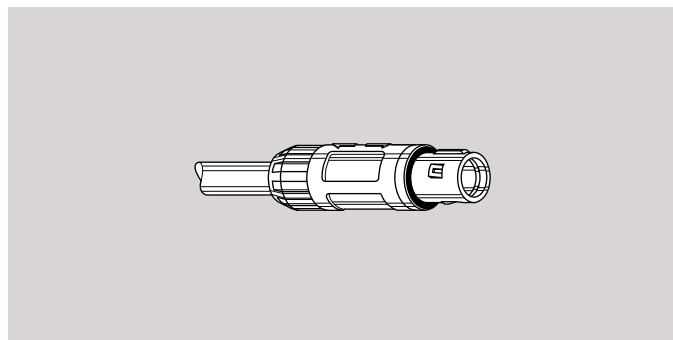
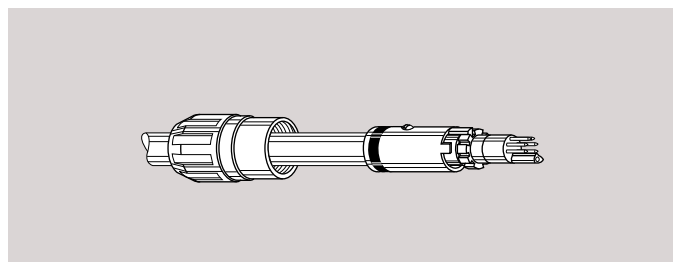
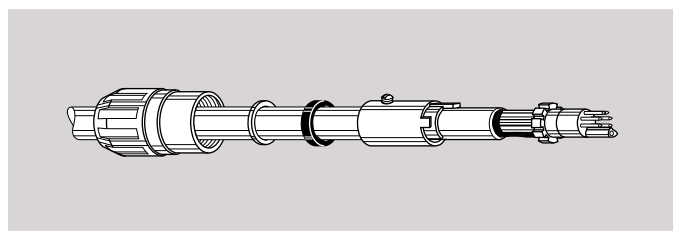
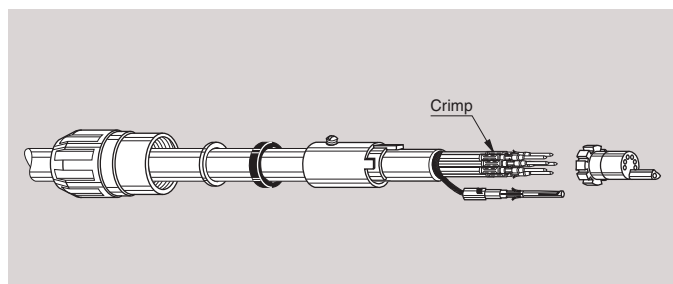
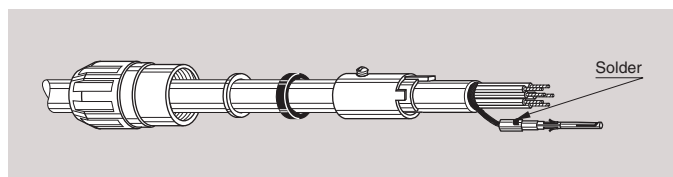
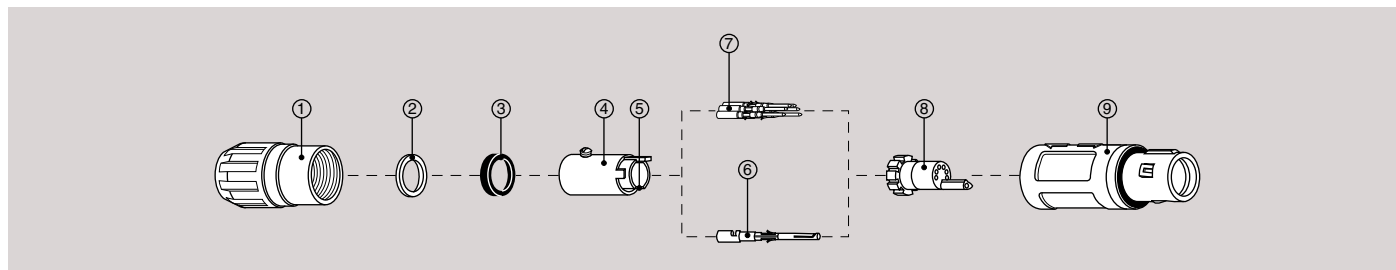
5. Push the whole assembly into the shell ⑨ whilst turning it to insure that the tag ⑤ is correctly located in the inside slot of the shell. Tighten the retaining nut ① to the maximum torque of 1.2 Nm.

– Socket mounting nut or screws = 2.3 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 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, 314	19.0	5.4

2. Slide the retaining 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. Fix the appropriate positioner (table page 51) in the crimping tool. Set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into contact ⑦ 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 ⑤. Check that all contacts are correctly located and remain in position when given a gentle pull. In case of a screened cable introduce the earthing contact ⑥ into the insert ⑤. Check that contact is correctly located and remains in position when given a gentle pull.

5. 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.

6. 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 retaining nut ① to the maximum torque of 1.2 Nm.

– Socket mounting nut or screws = 2.3 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.