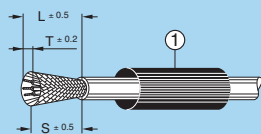
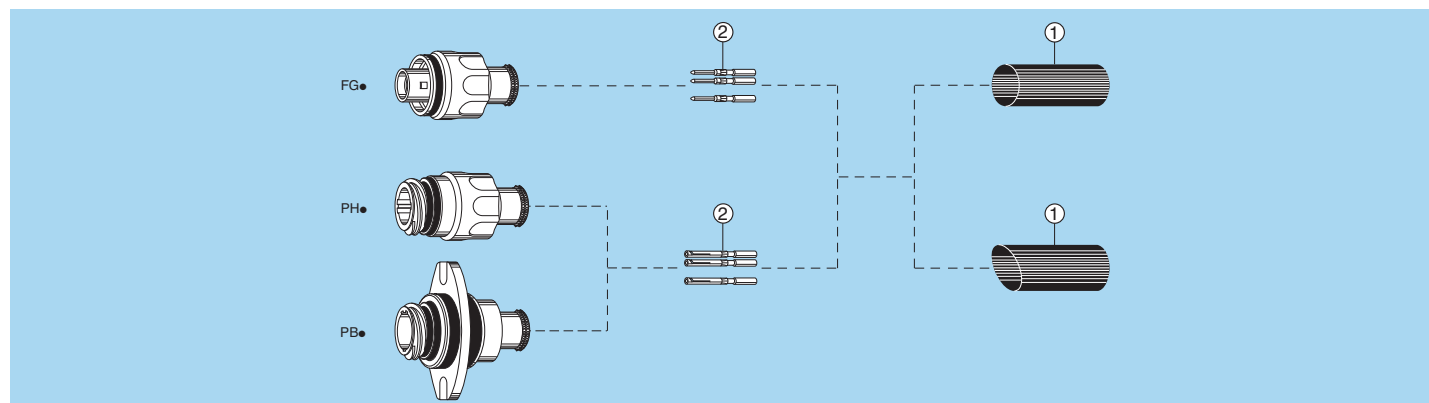


Assembly instructions for plugs and sockets



1. Cable preparation

First place the heatshrink boot ① over the cable. Strip the cable according to dimensions of the table, then widen the shield.

Series	L	S	T
0M to 5M	20	15	3.5

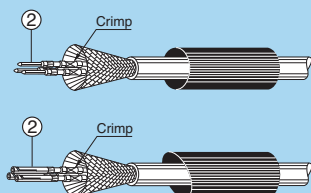
Note: dimensions are in mm.

2. Cable termination

2.1 With shielded cables, widen and pull the shield all the way to the back. Fix the appropriate positioner onto the crimping tool and set the selector to the number corresponding to the AWG of the conductor used as indicated on the positioner label.

Fit the conductor into the contact ②; make sure it is visible through the contact's inspection hole.

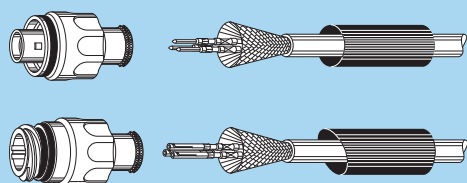
Slide the conductor-contact assembly into the open crimping tool; make sure that the contact is pushed fully into the positioner. Close the tool. Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole.



2.2 Arrange the conductor-contact assemblies according to the markings, into the rear cable seal.

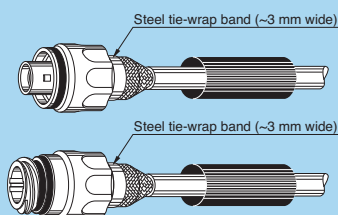
Push them deeply into the insulator, using tweezers if necessary; check that all the contacts are correctly located in the insulator: 1) by verifying the alignment of the contacts at the front of the insulator and 2) by gently pulling on each conductor.

Verification should also be made using the appropriate retention testing tool.

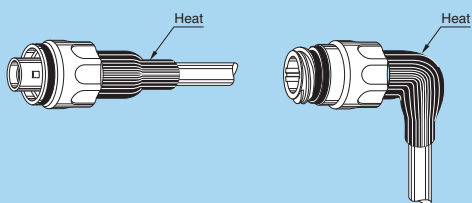


2.3 Bring the shield around the rear of connector.

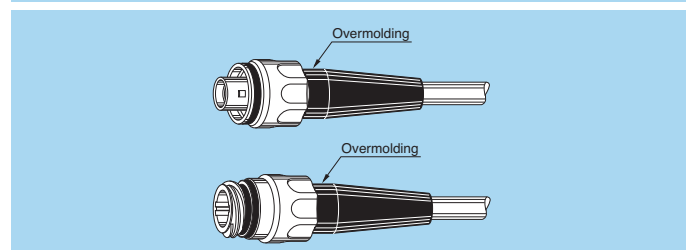
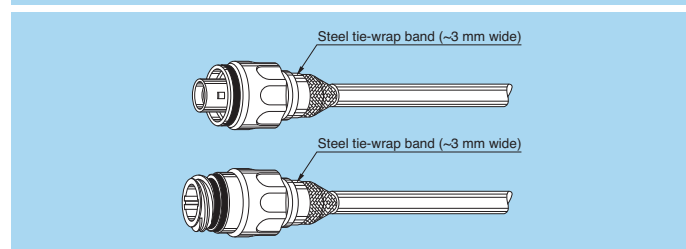
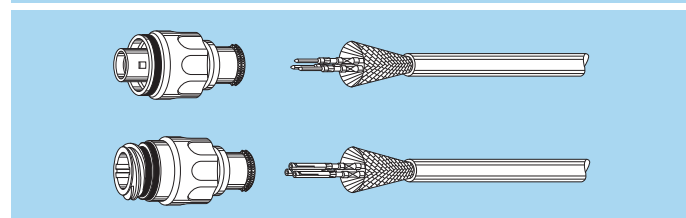
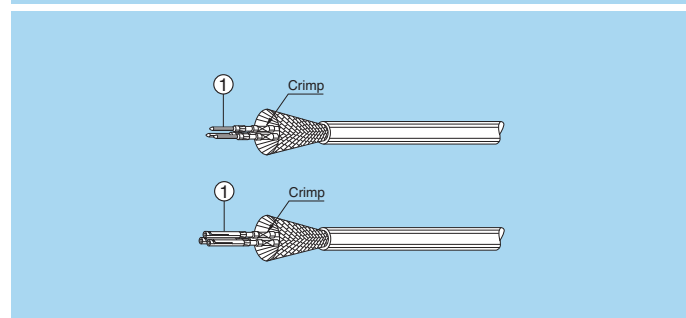
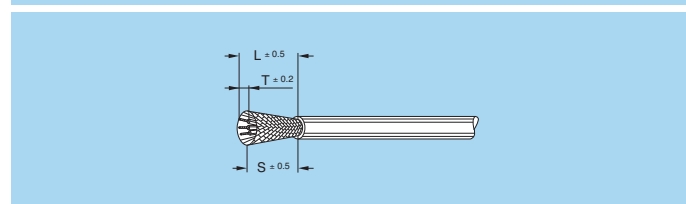
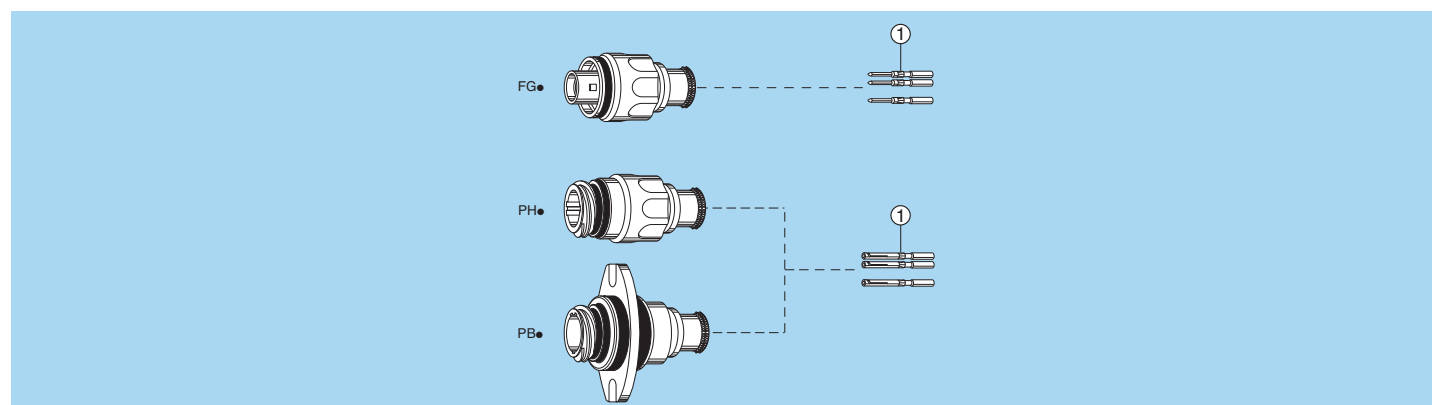
Secure it with a band-it tie-wrap (not furnished) to fix the shield in place. Cut off the possible shield surplus.



2.4 Put the heatshrink boot in place and heat gently until it retracts.



Assembly instructions for plugs and sockets (with optional mold stop)



1. Cable preparation

Strip the cable according to dimensions of the table, then widen the shield.

Series	L	S	T
OM to 5M	20	15	3.5

Note: dimensions are in mm.

2. Cable termination

2.1 With shielded cables, widen and pull the shield all the way to the back. Fix the appropriate positioner onto the crimping tool and set the selector to the number corresponding to the AWG of the conductor used as indicated on the positioner label. Fit the conductor into the contact ①; make sure it is visible through the contact's inspection hole. Slide the conductor-contact assembly into the open crimping tool; make sure that the contact is pushed fully into the positioner. Close the tool. Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole.

2.2 Arrange the conductor-contact assemblies according to the markings, into the rear cable seal. Push them deeply into the insulator, using tweezers if necessary; check that all the contacts are correctly located in the insulator: 1) by verifying the alignment of the contacts at the front of the insulator and 2) by gently pulling on each conductor. Verification should also be made using the appropriate retention testing tool.

2.3 Bring the shield around the rear of connector until the mold stop. Secure it with a band-it tie-wrap (not furnished) to fix the shield in place. Cut off the possible shield surplus.

2.4 Custom overmold cable assembly.