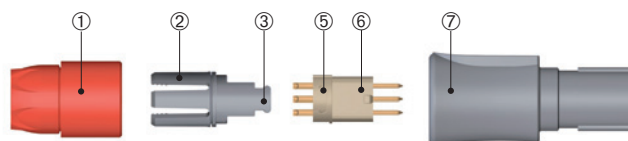


Assembly instructions

Solder contacts / Crimp contacts



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

Configuration	Dimensions (mm)			
	Solder contacts		Crimp contacts	
	L	T	L	T
M04	11.5	3.5	15.0	3.5
M06, M08	13.0	3.0	15.0	3.5
M10, M13	13.0	3.0	15.0	3.5
M16 to M22	12.5	2.5	14.5	2.5

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

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

Fix the appropriate positioner in the crimping tool. Set selector to the number corresponding to the conductor AWG as indicated on the positioner label. Fit conductor into contact 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.

- Slide the collet ② forward and locate both tags ③ in the slots ⑤ on the insulator ⑥. Push collet ② and insulator ⑥ assembly into the shell ⑦ whilst turning it to ensure that the tag ③ locates in the inside slot of the shell.

- Slide collet nut ① over collet ② and tighten the collet nut ① to the maximum torque of 0.3 Nm.

– Socket mounting nut torque = 1 Nm.