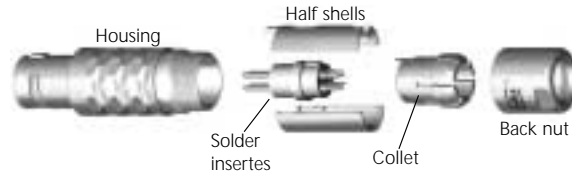


Assembly Instructions



Assembly Instruction

For unsealed Connectors Series L (IP 50)



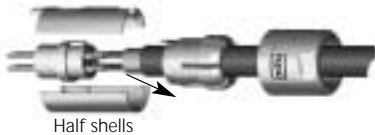
1. Slide Back nut and Collet over the cable.



2. Strip cable and wire
3. Pre-tinning of strands recommended



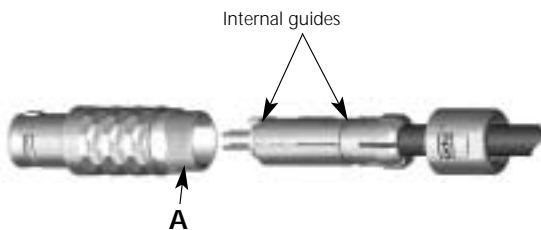
4. Solder each wire to the corresponding contact



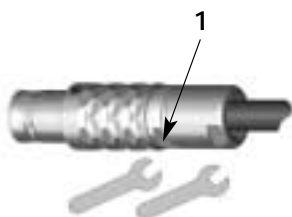
5. Bend cable shield outwards, assemble half shells.



6. Slide the EMI-Ring against the sleeve and clamp the shield between it.



7. Now you can put the assembled cable into the plug-housing. If needed, secure thread (A) with locking glue.



8. Screw back nut on the plug, hold against flat 1 and fasten cable in the housing*.

Attention! Torque value:

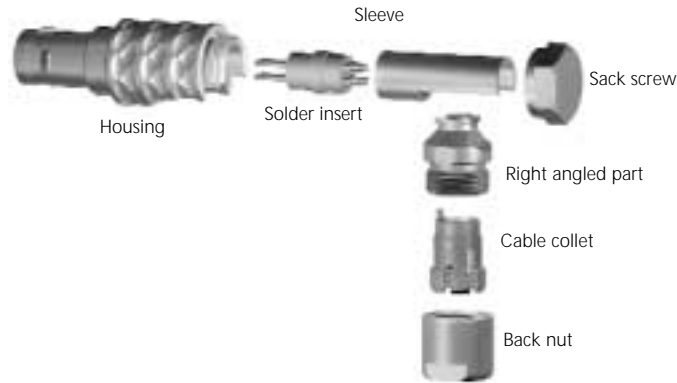
Size	00	0	1	2	3	4
Nm	0,5	0,6	1,0	2,0	3,5	4

Now the plug is assembled.

* ODU-Spanner-Wrench: see page 112

Assembly Instruction

For unsealed right-angle plug connectors (IP 50), series L



1. Slide back nut, collet, right-angled-part and sleeve over the cable.



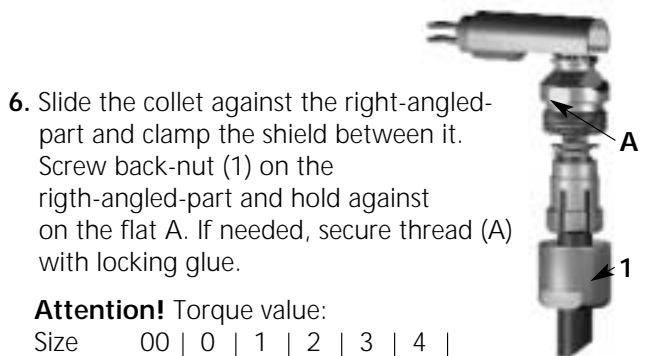
2. Strip cable and wire
3. Pre-tinning of strands recommended



4. Solder each wire to the corresponding contact (Crimp version see straight Connector to Page 119)



5. Pull cable back and bend 90° down. Spread the cable shield over collet ring. Slide sleeve over insulator.



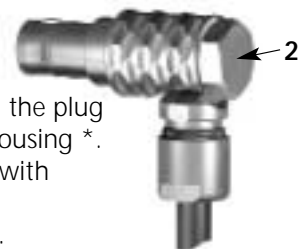
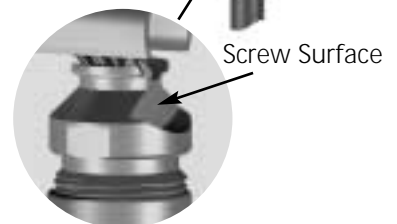
6. Slide the collet against the right-angled-part and clamp the shield between it. Screw back-nut (1) on the righth-angled-part and hold against on the flat A. If needed, secure thread (A) with locking glue.

Attention! Torque value:

Size	00	0	1	2	3	4
Nm	0,5	0,6	1,0	2,0	3,5	8



7. Now you can put the assembled cable into the plug-housing.



8. Mount back-screw (2) on the plug and fasten cable in the housing *. If needed, secure thread with locking glue.

Attention! Torque value:

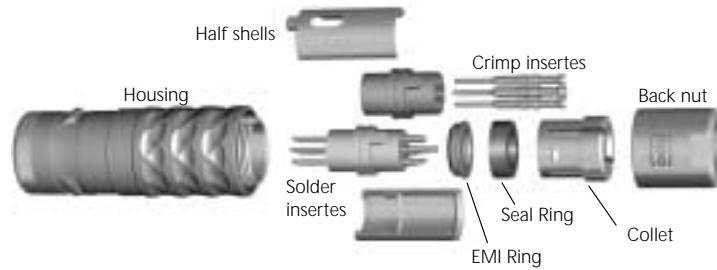
Size	00	0	1	2	3	4
Nm	0,2	0,3	0,4	0,9	1,3	2,0

Now the plug is assembled.

* ODU-Spanner-Wrench: see page 112

Assembly Instruction

For sealed connectors (IP 68) Series K



1. Slide Back nut, Collet, Seal Ring and EMI-Ring over the cable.

Crimp termination

Detail information see page 106-111



Part number see page 106

2. Strip cable and wire
3. Fit wire into the contact barrel and crimp

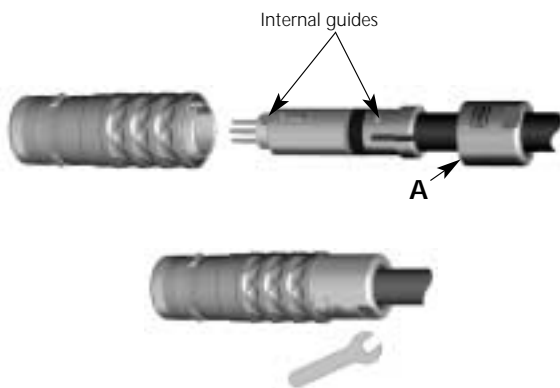


Part number see page 107-108

4. Insert contacts into insulator, use the insertion tool to push them in



Half shells



Solder termination



2. Strip cable and wire
3. Pre-tinning of strands recommended



Solder iron

4. Solder each wire to the corresponding contact
5. Bend cable shield outwards, assemble half shells.
6. Slide the EMI-Ring against the sleeve and clamp the shield between it.
7. Now you can put the assembled cable into the plug-housing. If needed, secure thread (A) with locking glue.

8. Screw back nut on the plug and fasten cable in the housing*.

Attention! Torque value:

Size	0	1	2	3	4
Nm	0,6	1,0	2,0	3,5	4

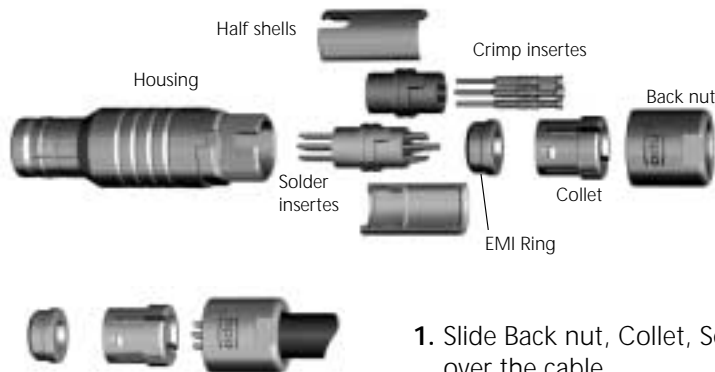
Now the plug is assembled.

* ODU-Spanner-Wrench: see page 112

Watertight connectors require a grommet seal designed for the intended cable. We require either the exact specification or a sample of the cable.

Assembly Instruction

For unsealed connectors Series B (IP 50)



1. Slide Back nut, Collet, Seal Ring and EMI-Ring over the cable.

Crimp termination

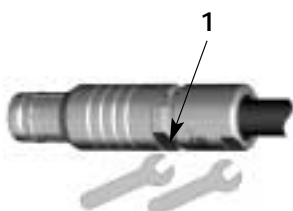
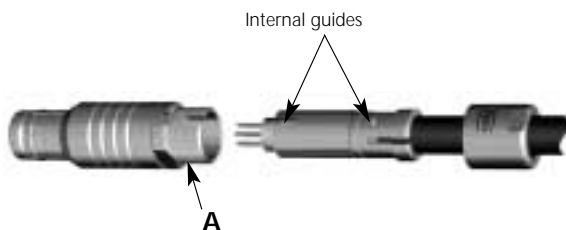
Detail information see page 106-111



2. Strip cable and wire
3. Fit wire into the contact barrel and crimp



4. insert contacts into insulator, use the insertion tool to push them in



Solder termination



2. Strip cable and wire
3. Pre-tinning of strands recommended



4. Solder each wire to the corresponding contact

5. Bend cable shield outwards, assemble half shells.

6. Slide the EMI-Ring against the sleeve and clamp the shield between it.

7. Now you can put the assembled cable into the plug-housing. If needed, secure thread (A) with locking glue.

8. Screw back nut on the plug, hold against flat 1 and fasten cable in the housing*.

Attention! Torque value:

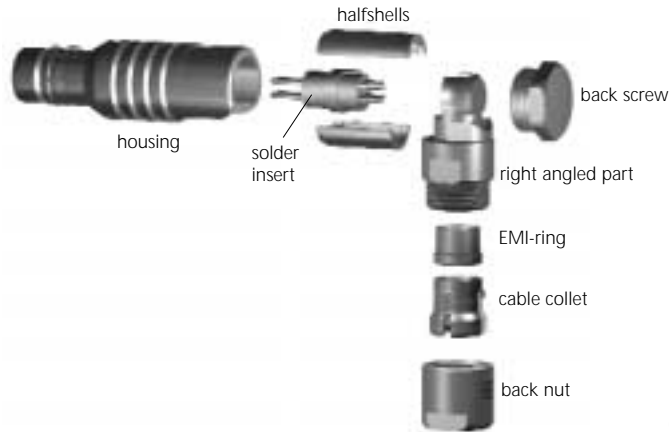
Size	0	1	2	3
Nm	0,6	1,0	2,0	3,5

Now the plug is assembled.

* ODU-Spanner-Wrench: see page 112

Assembly Instructions

For unsealed right-angle plug connectors (IP 50), series B



1. Slide back nut, collet, EMI-ring and right-angled-part over the cable.



2. Strip cable and wire
3. Pre-tinning of strands recommended

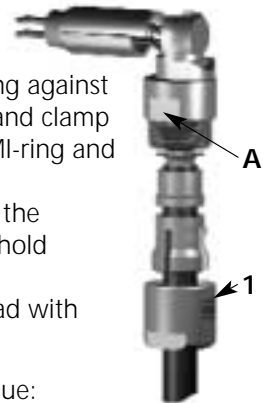


4. Solder each wire to the corresponding contact



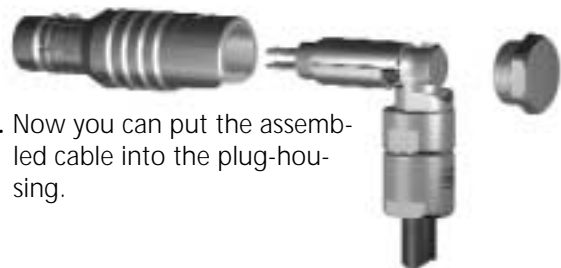
5. Pull cable back and bend 90° down. Place halfshells over insulator.

6. Slide collet and EMI-ring against the right-angled-part and clamp the shield between EMI-ring and right-angled-part. Screw back-nut (1) on the right-angled-part and hold against on flat (A). If needed, secure thread with locking glue.



Attention! Torque value:

Size	0	1	2	3
Nm	0,6	1,0	2,0	3,5



7. Now you can put the assembled cable into the plug-housing.



8. Mount back-screw (2) on the plug and fasten cable in the housing. If needed, secure thread with locking glue.

Attention! Torque value:

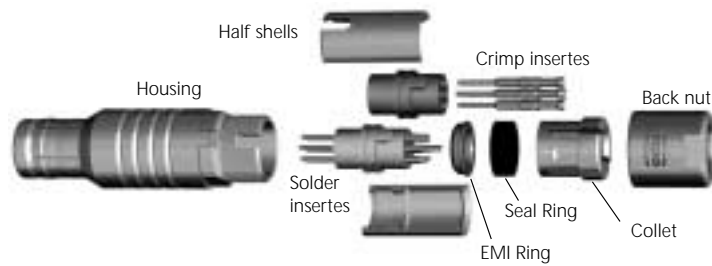
Size	0	1	2	3
Nm	0,3	0,4	0,9	1,3

Now the plug is assembled.

* ODU-Spanner-Wrench: see page 112

Assembly Instruction

For sealed connectors Series B (IP 68)



1. Slide Back nut, Collet, Seal Ring and EMI-Ring over the cable.

Crimp termination

Detail information see page 106-111



Part number see page 106

2. Strip cable and wire
3. Fit wire into the contact barrel and crimp



Part number see page 107-108

4. Insert contacts into insulator, use the insertion tool to push them in



Half shells



Solder termination



2. Strip cable and wire
3. Pre-tinning of strands recommended



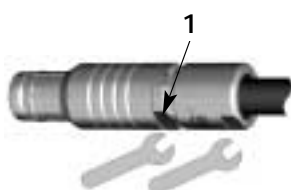
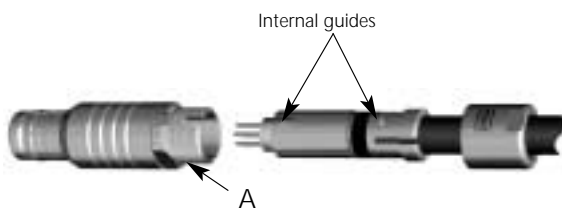
Solder iron

4. Solder each wire to the corresponding contact

5. Bend cable shield outwards, assemble half shells.

6. Slide the EMI-Ring against the sleeve and clamp the shield between it.

7. Now you can put the assembled cable into the plug-housing. If needed, secure thread (A) with locking glue.



8. Screw back nut on the plug, hold against flat 1 and fasten cable in the housing*.

Attention! Torque value:

Size	0	1	2	3
Nm	0,6	1,0	2,0	3,5

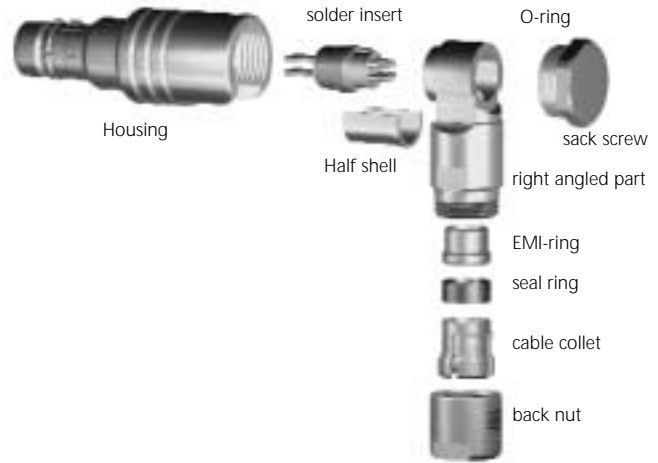
Now the plug is assembled.

* ODU-Spanner-Wrench: see page 112

Watertight connectors require a grommet seal designed for the intended cable. We require either the exact specification or a sample of the cable.

Assembly Instruction

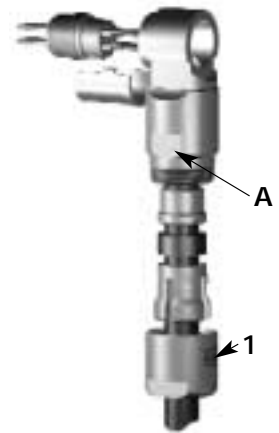
For sealed right-angle plug connectors (IP 68) Series B



1. Slide back nut, collet, seal ring, EMI-ring and right-angled-part over the cable.
2. Strip cable and wire
3. Pre-tinning of strands recommended



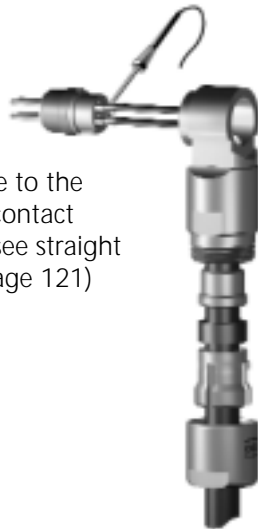
6. Slide collet, seal ring and EMI-ring against the right-angled-part and clamp the shield between EMI-ring and right-angled-part. Screw back-nut (1) on the right-angled-part and hold against on flat (A). Please halfshell over insulator. If needed, secure thread with locking glue.



Attention! Torque value:

Size	0
Nm	0,6

4. Solder each wire to the corresponding contact (Crimp version see straight Connector to Page 121)

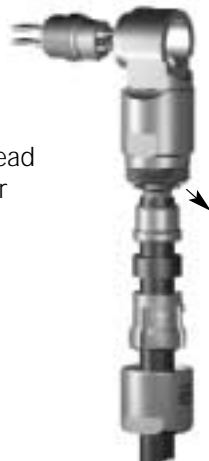


Part No.700 412 106 000

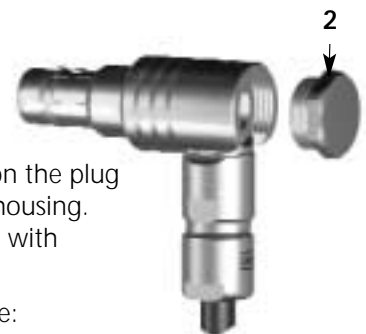


7. Now you can put the assembled cable into the plug-housing.

5. Pull cable back. Spread the cable shield over collet ring.



8. Mount back-screw (2) on the plug and fasten cable in the housing. If needed, secure thread with locking glue.



Attention! Torque value:

Size	0
Nm	0,3

Now the plug is assembled.

* ODU-Spanner-Wrench: see page 112

Torque for back-nuts

Torque for styles

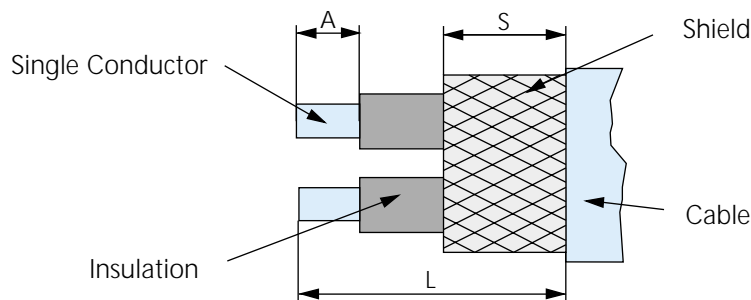
- Straight plug S1; S2; S3; S4
- Right-angled-plug W1; W2; W3; W4
- Break-apart-plug A5; A6; A7; A8
- In-line-receptacle K1; K2; K3; K4
- Receptacle G6; G7

Size	00	0	1	2	3	4
Torque	0,5 Nm	0,6 Nm	1,0 Nm	2,0 Nm	3,5 Nm	4 Nm

1 Nm = 8,85 inch-pounds

Cable Preparation:

The following Table provides recommended guidelines for cable preparation:



- A = Stripping length single conductor
- L = Stripping length cable jacket
- S = Stripping length braided shield

Size	Contact Ø	Solder Termination			Crimp Termination		
		L	A	S	L	A	S
Size 00	0.5	5	2	2	-	-	-
Size 0	0.5	7	2	2,5	-	-	-
	0.7	7	2	2,5	10	3	2,5
Size 1	0.9	7	2	2,5	10	3	2,5
	0.5	9	2	2,5	-	-	-
	0.7	9	2	2,5	12	3	2,5
Size 2	0.9	9	2	2,5	12	3	2,5
	1.3	-	-	-	-	-	-
	0.5	11	2	2,5	-	-	-
	0.7	11	2	2,5	14	3	2,5
	0.9	11	2	2,5	14	3	2,5
Size 3	1.3	11	2	2,5	14	3	2,5
	1.6	11	2	2,5	14	3	2,5
	2.0	-	-	-	-	-	-
	0.5	13	2	2,5	-	-	-
	0.7	13	2	2,5	17	3	2,5
Size 4	0.9	13	2	2,5	17	3	2,5
	1.3	13	2	2,5	17	3	2,5
	1.6	13	2	2,5	17	3	2,5
	2.0	-	-	-	-	-	-
	3.0	-	-	-	-	-	-

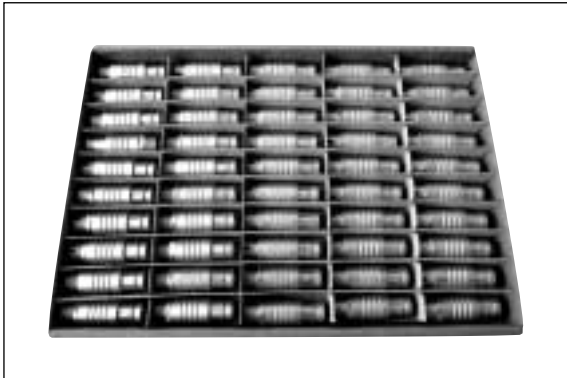
All dimensions in mm

Tolerance: + 10 %

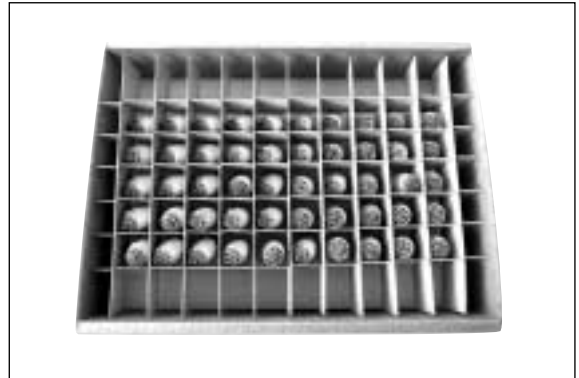
Exceptions are noted on special instructions.
Right-angle plugs have special instructions.

Standard Packing

• Plug



Housing



Contact Inserts



Back Nut



Accessories (Collet nuts, Cable Bend Reliefs etc.)

• Receptacles



Receptacles with Solder- Crimp- and PCB-Contacts

There are different packings possible, due to different sizes, quantities, styles ect.