

4) CONNECTOR TERMINATION INSTRUCTIONS SINGLE WIRES

Figure 14: Plug Example

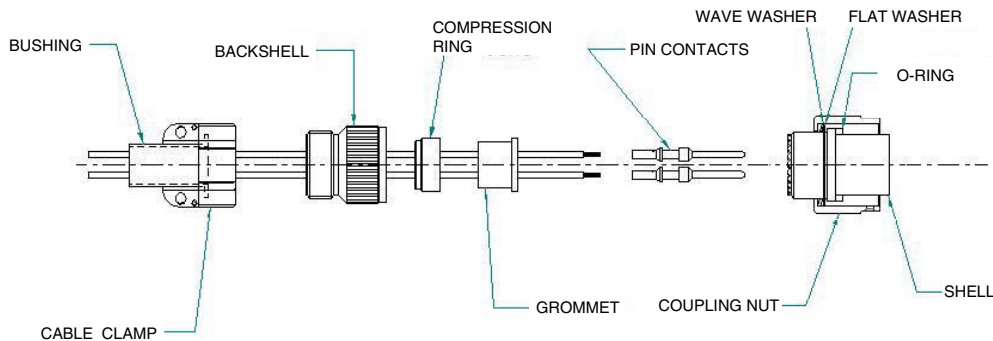
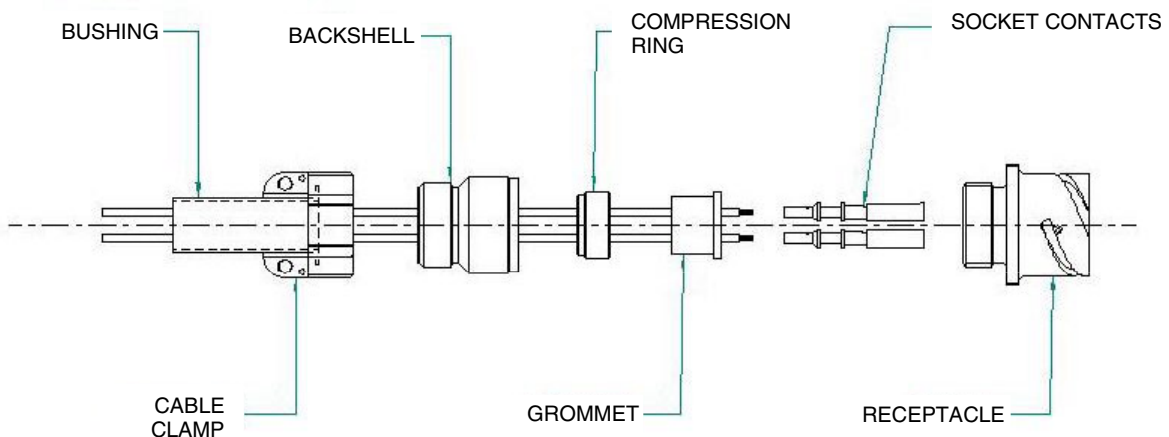


Figure 15: Receptacle Example



- 1) Assemble components as shown in figures 14 and 15 above.
- 2) Insert conductors in the grommet (when required), being careful to align the letters or numbers imprinted on the back side with the corresponding letters or numbers imprinted on the insert.
- 3) Cut conductors pursuant to Table 2 (page 10) using the correct tool. Be careful to not cut any of the individual wire strands.
- 4) Begin crimping contacts (see pages 13-15) or soldering contacts (see pages 10-12).

5) To insert crimped contacts, follow the instructions on pages 16-19.

6) Carefully clean the insulating components after using lubricant to facilitate contact insertion.

7) Assemble the components as follows:

7.1) PLUG

In the following sequence, attach the following components to the shell: flat washer, wave washer and the coupling nut. Take care to assure that the wave washer and flat washer are properly fitted, and then attach the connector to its secured and fixed mate to facilitate assembly.

7.2) RECEPTACLE

Lock the flange, taking care to not damage it.

8) Assemble the insert, grommet and compression ring in sequence.

9) Check to see that the backshell O-Ring is lubricated when required, and in the correct position.

10) Screw the backshell onto the connector using cushioned pliers (P/N: M120002) or a strap wrench (P/N: M120001) to avoid damaging the external plating. For correct torque, consult Table 7 below:

**Table 7 : Torque forces
Connector Torque (N/m)**

| Size | Min. | Max. |
|------|------|------|
| 10SL | 1.5 | 2.5 |
| 14S | 4.4 | 5.4 |
| 16S | 6.4 | 7.4 |
| 16 | 6.4 | 7.4 |
| 18 | 6.9 | 7.8 |
| 20 | 7.8 | 9.8 |
| 22 | 9.8 | 11.8 |
| 24 | 10.8 | 14.7 |
| 28 | 13.7 | 18.6 |
| 32 | 14.7 | 20.6 |
| 36 | 18.6 | 26.5 |
| 40 | 20.6 | 39.2 |



- 11) If the cable is sleeved, pull it close to the backshell, then screw the cable clamp to the backshell pursuant to Table 7 on page 21.
- 12) Tighten the saddle clamp screws to help assure a sufficiently tight mechanical grip on the cable.

MULTIPLE RUBBER-COATED CABLES

Figure 16: Plug Example

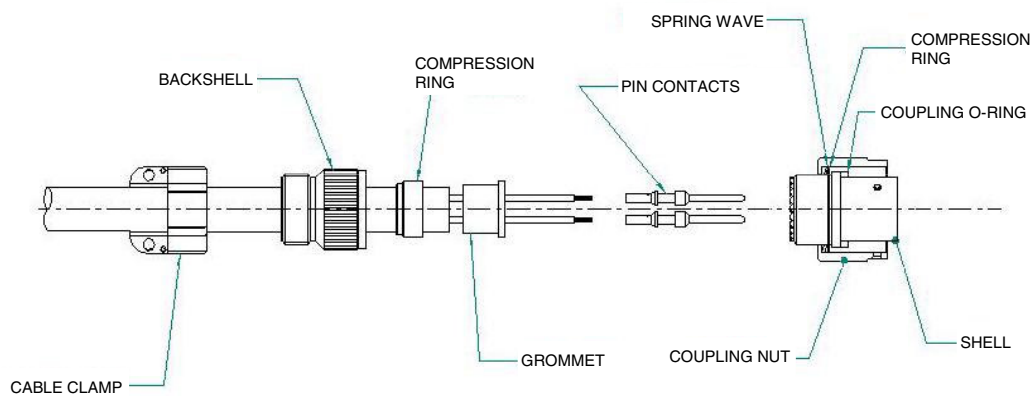


Figure 17: Receptacle Example

