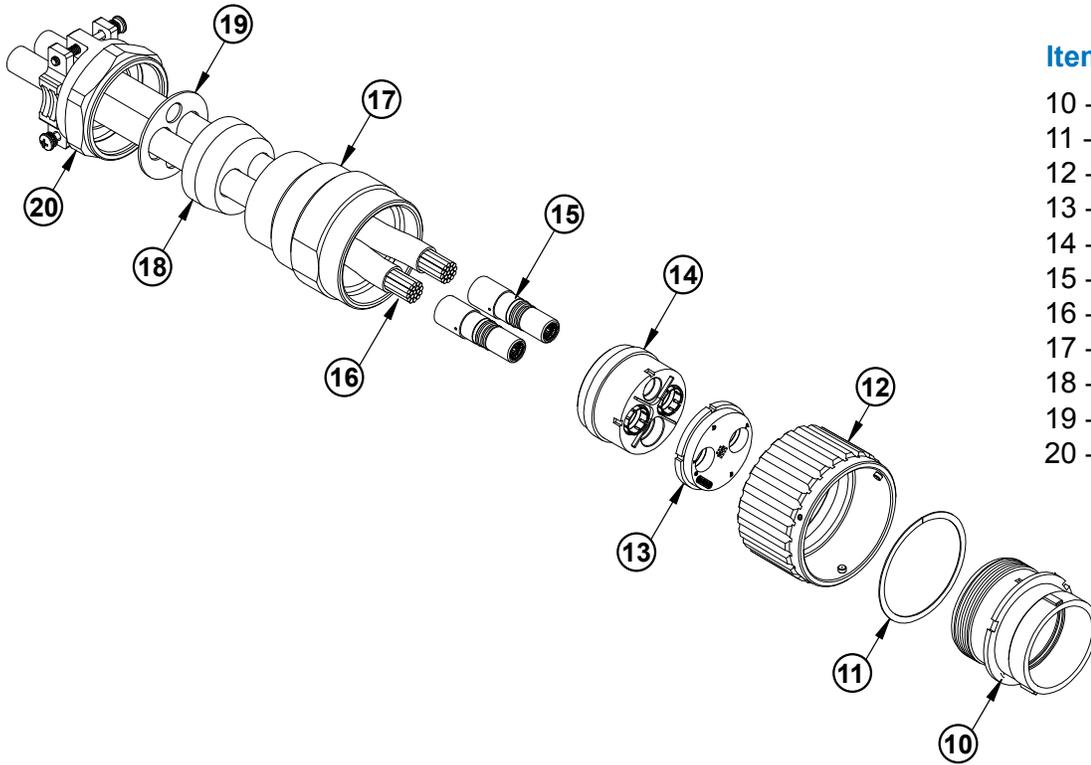


Assembly Instructions - Plug Connector



Items Description

- 10 - Plugshell
- 11 - Washer
- 12 - Coupling Nut
- 13 - Front Insert
- 14 - Back Insert Group
- 15 - Socket Contacts
- 16 - Wires (Not Supplied)
- 17 - Backshell
- 18 - Sealing Grommet
- 19 - Compression Ring
- 20 - Cable Clamp

B

Step 1

TABLE 5

Contact Type	B (mm)
1	12.7
2	14.0
3 (3A, 3B, 3C)	23.2
4 (4A, 4B, 4C)	23.2



Cut and strip the cable (See TABLE 5)

Step 2

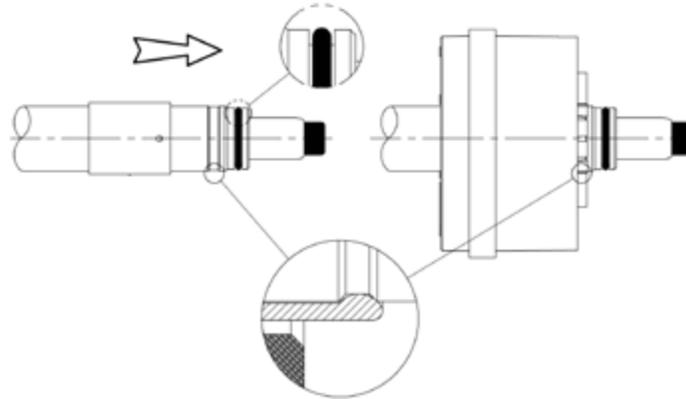


Crimp contacts (15) on conductors.

ITS 901 Series
Reverse Bayonet Multi Pole Power Connector
Assembly Instructions - Plug Connector

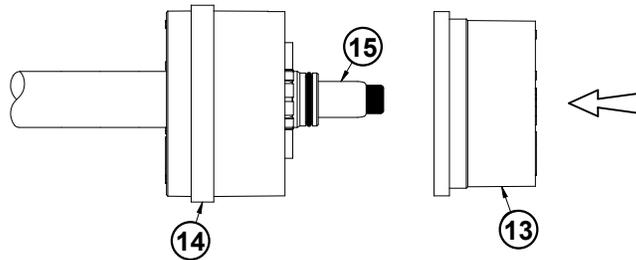


Step 3



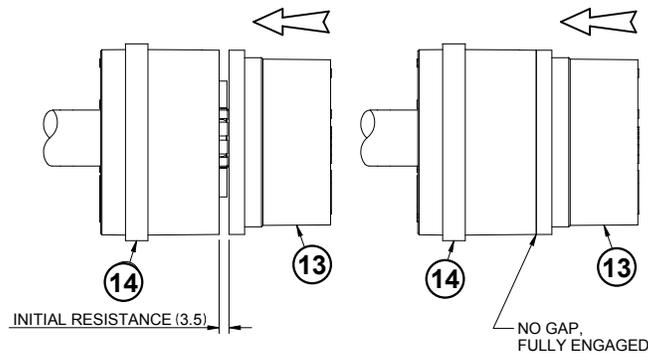
Insert the contact (15) crimped into the back insert (14) until to block in the retention clip.

Step 4



Close the back insert (14) to against the front insert (13) and check that is assembled correctly per the picture below (Step 5).

Step 5



Put the insert into the plugshell (10), according with internal key. Screw the backshell (17) and tighten.

Torque force = 30 N/m .

Put the grommet (18) and the Compression Ring (19) into the backshell (17) and tighten the clamp.

Torque force = 40 N/m .

Electrical Test: Insulation resistance 5000 Mohm (Min).

Test Voltage: 800 - 1000 Vdc (1 min.) according with the arrangement.