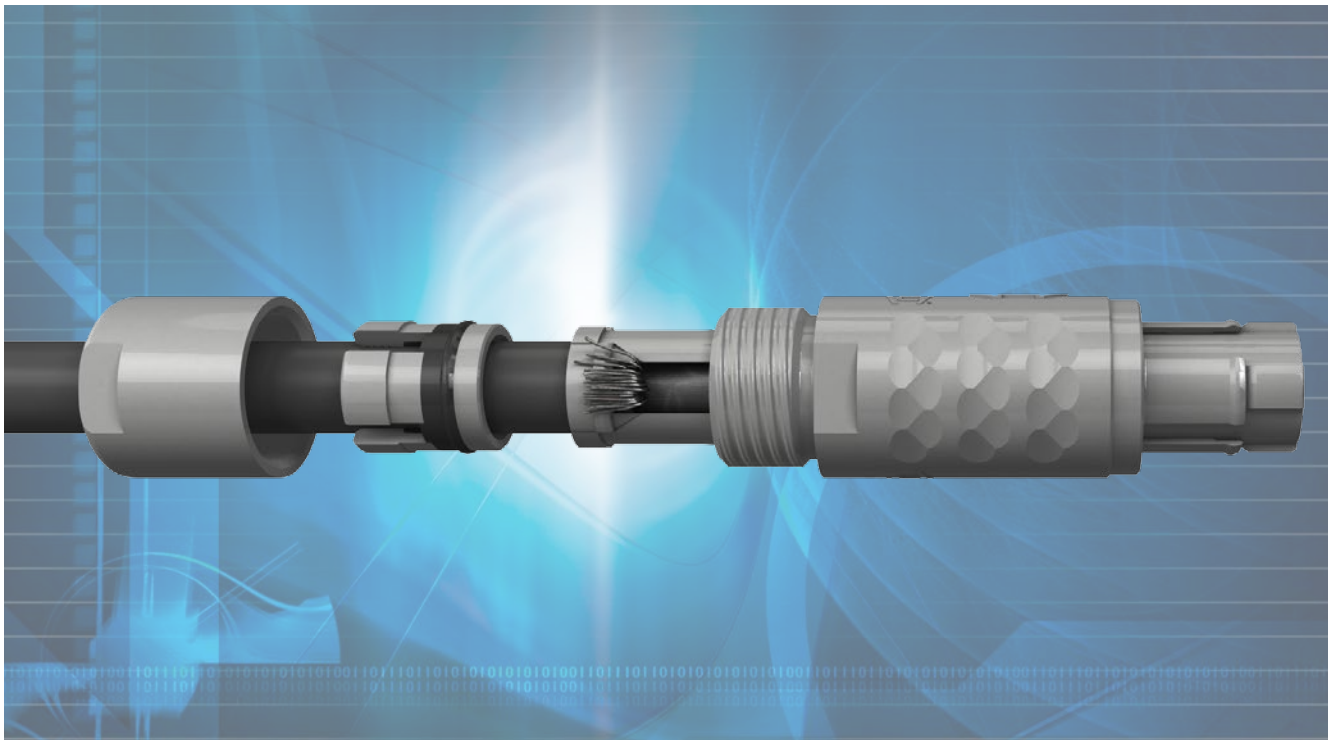
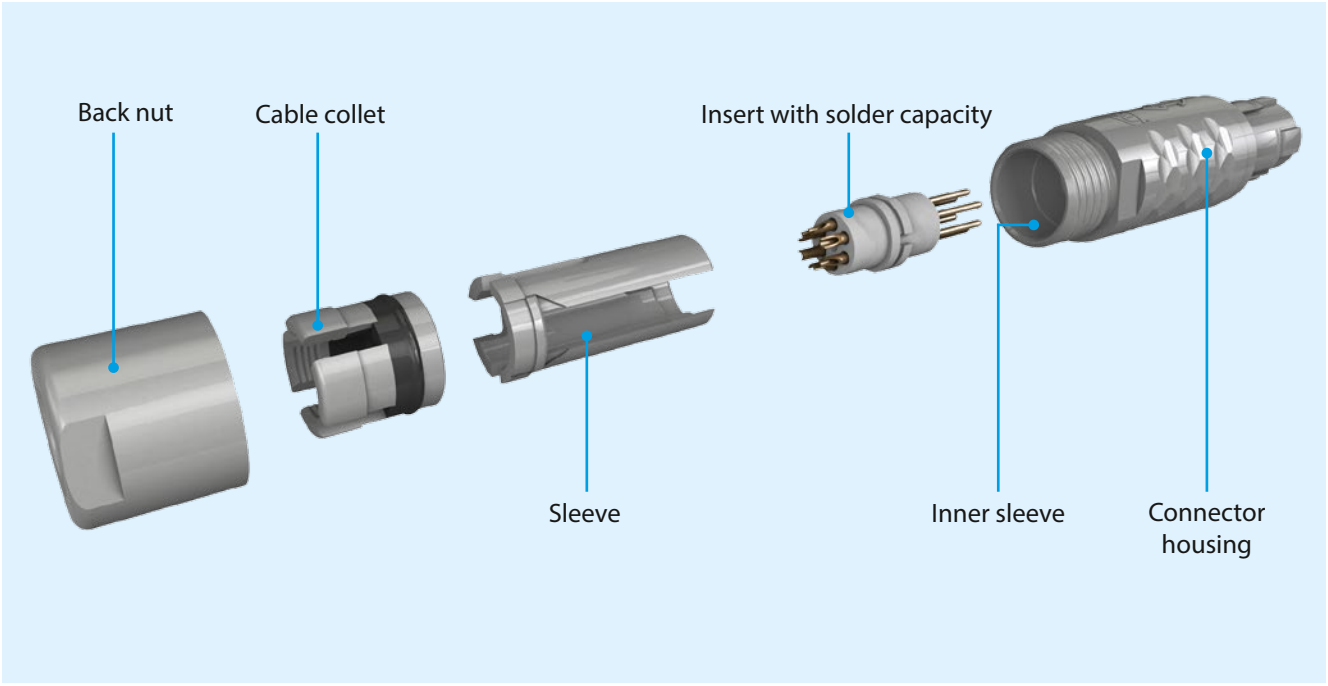
# Assembly Instructions

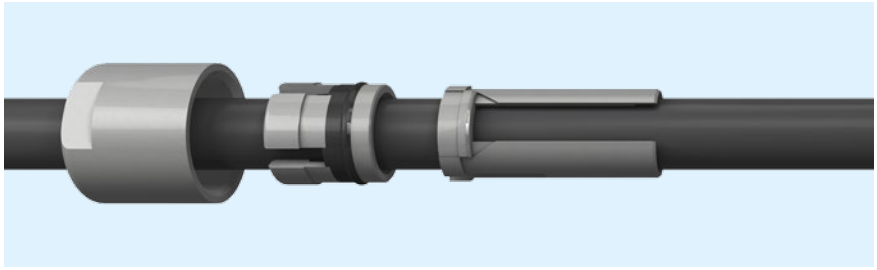


**Shielded and Unshielded Version**
**(IP 50 and IP 67)**
**– Solder Version**
**– Crimp Version**

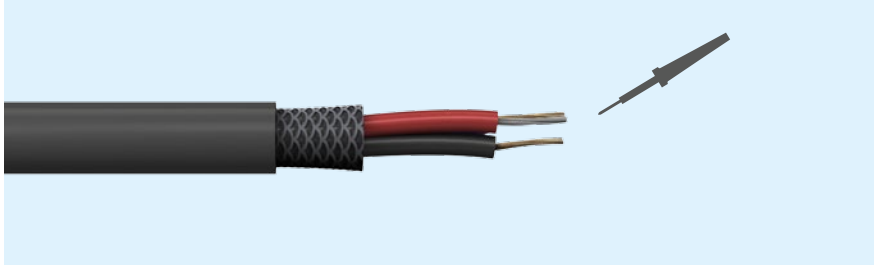
# Assembly Shielded and Unshielded Version IP 50 and IP 67
# Solder Version



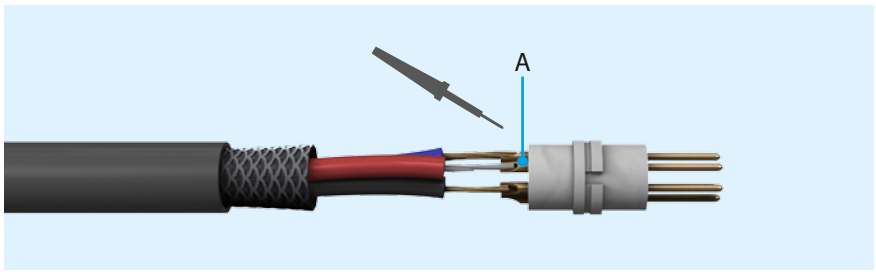

1. Slide back nut, cable collet and sleeve over stripped cable.



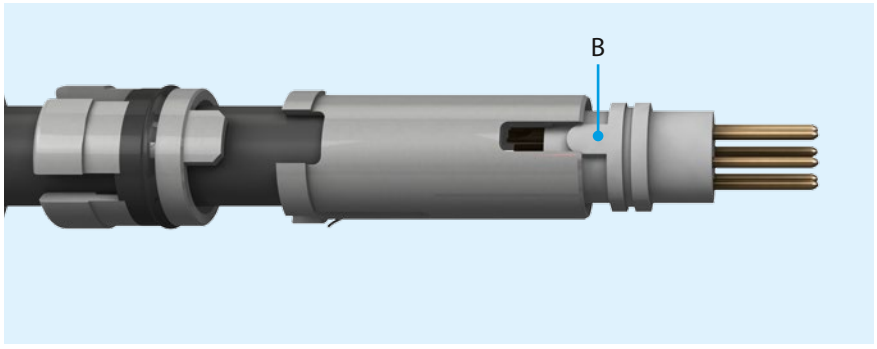
2. Strip cable and wire corresponding the table (see page 6).
3. Pre-tinning of strands.



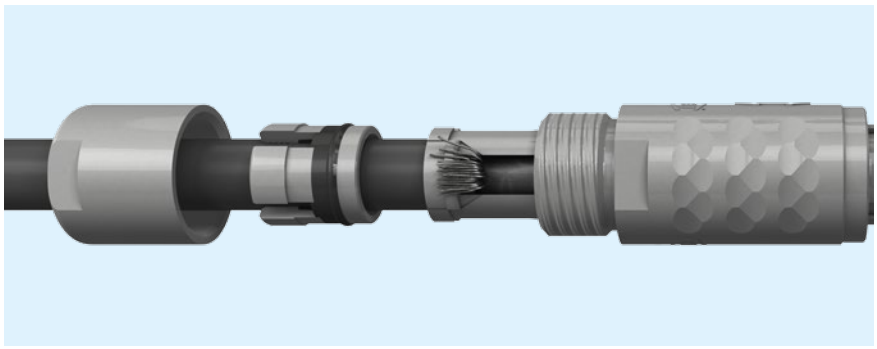
4. Solder each wire (A) to the corresponding contact.



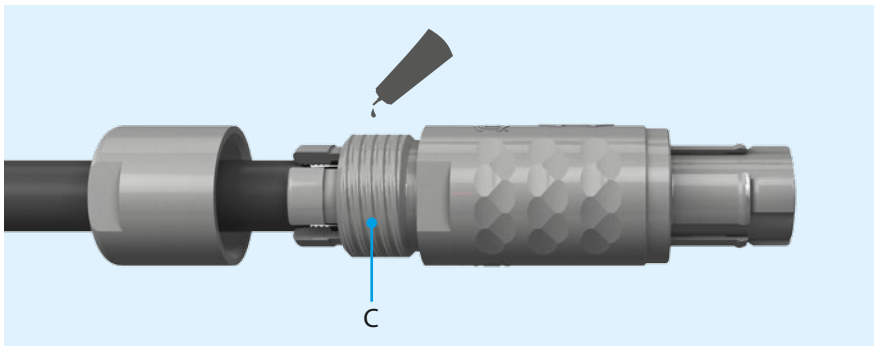
5. Slide the sleeve on up to the insert.
   Caution! Check the position: insulator nose (B) in the narrow slit of the sleeve.




6. Shielded version: turn the cable shield back through the wide slit of the sleeve.

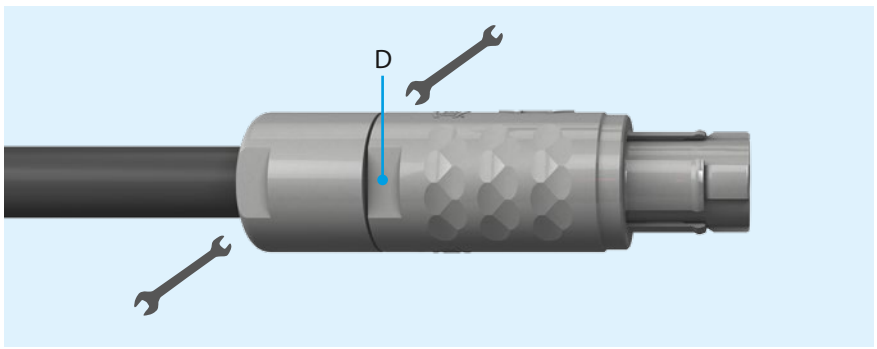


7. Slide sleeve and cable collet into the connector housing.
   Caution! Check the position.
   If necessary, secure thread (C) with adhesive (see page 6).

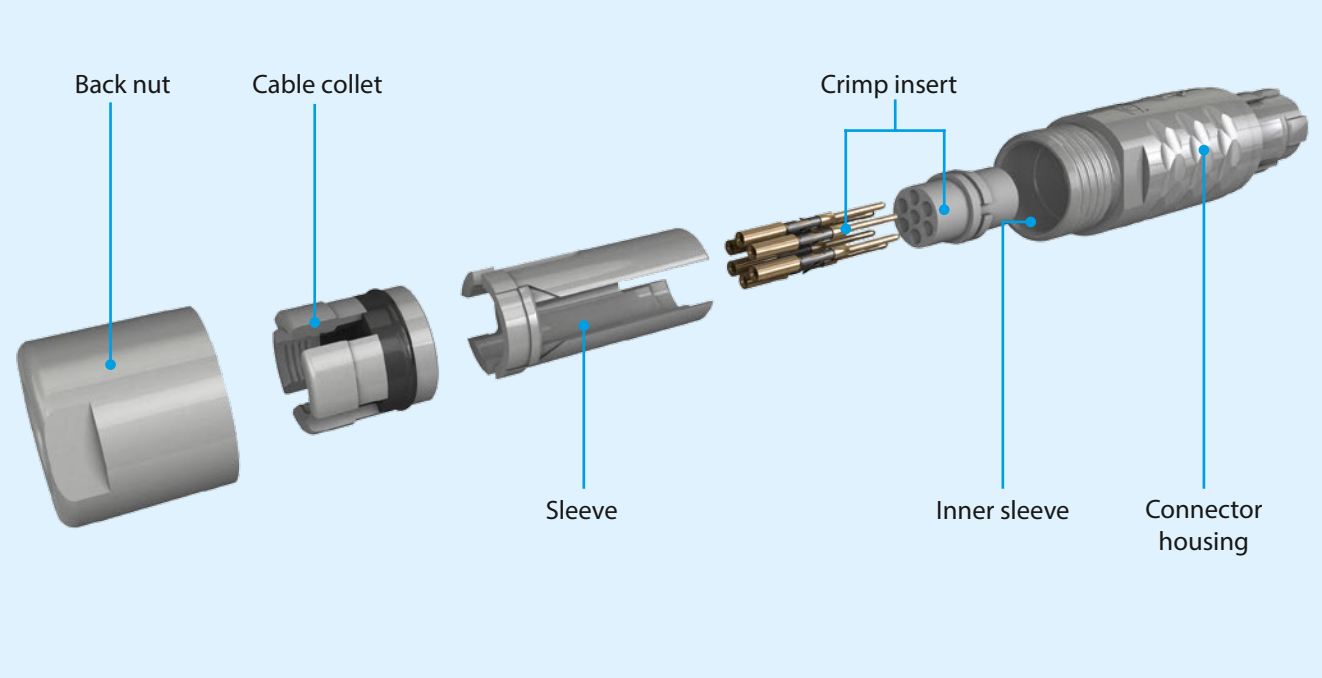



8. Screw the back nut on to the assembled plug, hold it against the spanner flat and tighten it (D) with the ODU spanner wrench.

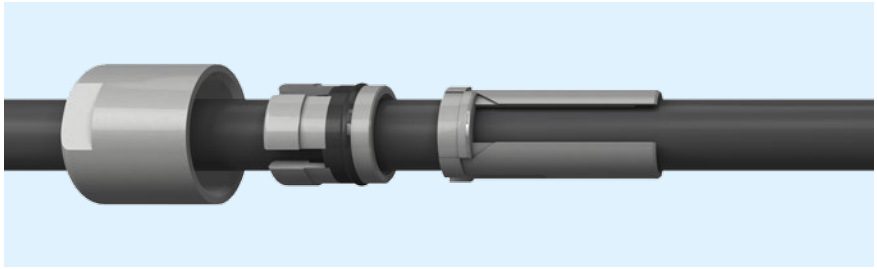
   Caution! Consider tightening torque (see page 6).
   The assembly is finished.



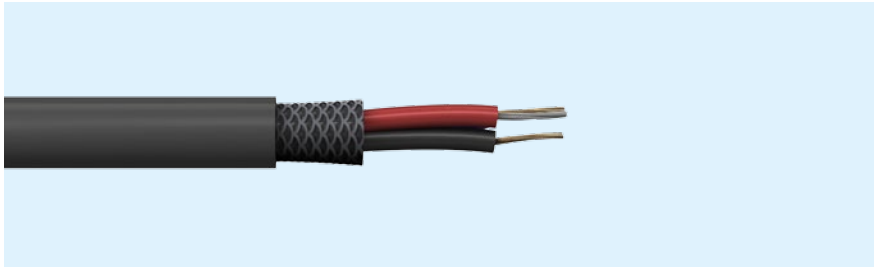
## Assembly Shielded and Unshielded Version IP 50 and IP 67
## Crimp Version



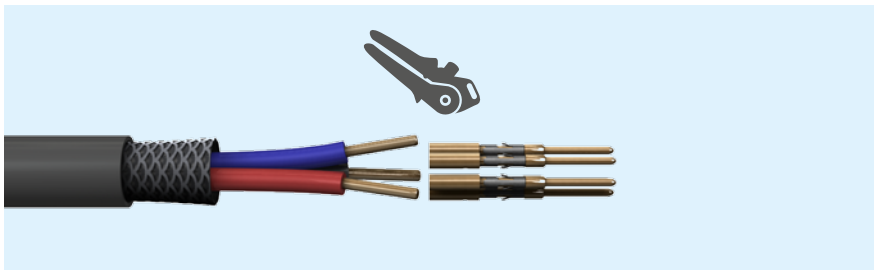

1. Slide back nut, cable collet and sleeve over stripped cable.



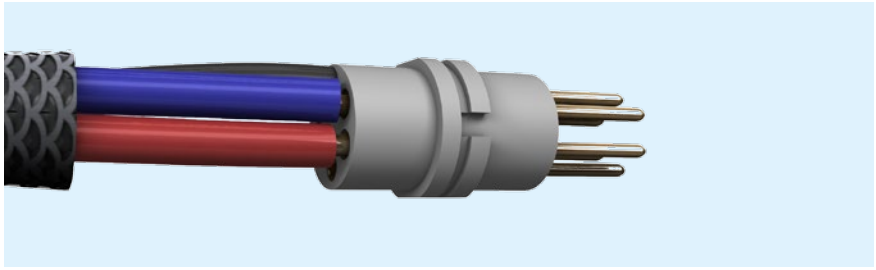
2. Strip cable and wire corresponding the table (see page 6).



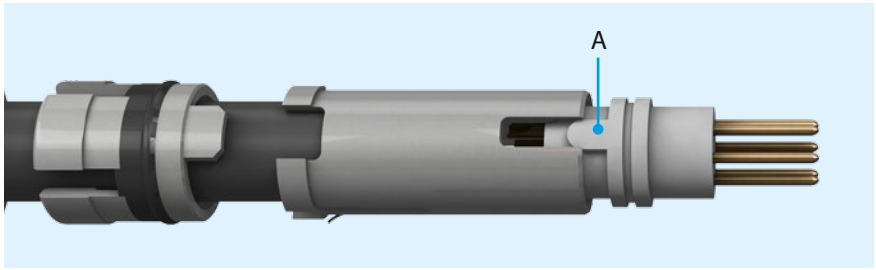
3. Fit wire into the contact barrel and crimp.



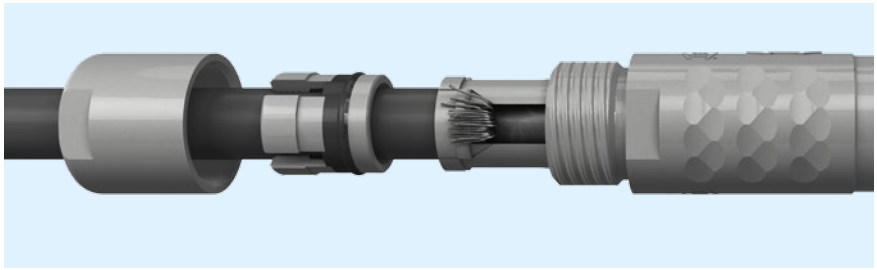
4. Insert contacts into insulator according to contact arrangement.



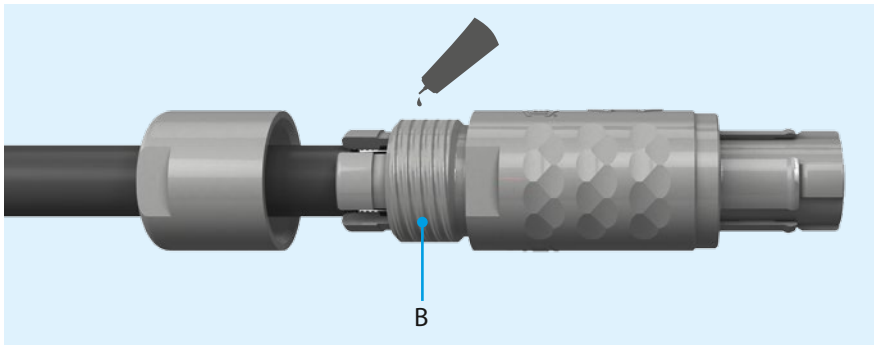
5. Slide the sleeve on up to the insert.
   Caution! Check the position: insulator nose (A) in the narrow slit of the sleeve).




6. Shielded version: turn the cable shield back through the wide slit of the sleeve.

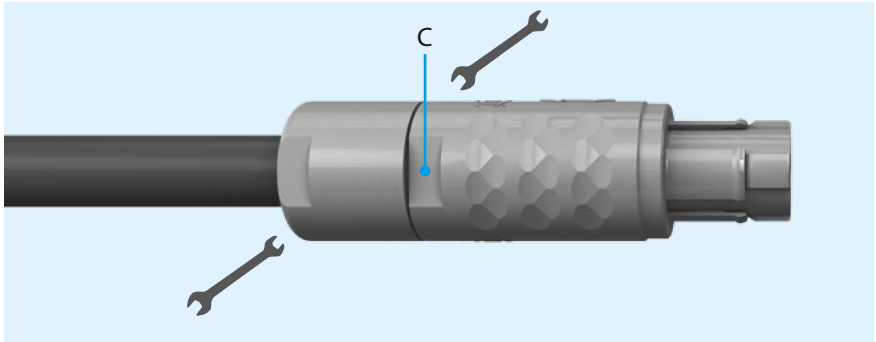


7. Slide sleeve and cable collet into the connector housing.
   Caution! Check the position.
   If necessary, secure thread (B) with adhesive (see page 6).




8. Screw the back nut on to the assembled plug, hold it against the spanner flat and tighten it (C) with the ODU spanner wrench.

   Caution! Consider tightening torque (see page 6).
   The assembly is finished.

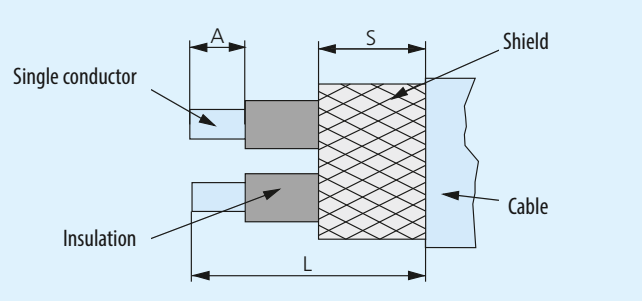


# Notes

## 1. Recommended stripping length

| Size | Solder termination | | | Crimp termination | | |
|---|---|---|---|---|---|---|
| | L | A | S | L | A | S |
| 1 | 13.0 | 2.5 | 8.0 | 16.5 | 3.0 | 8.0 |
| 2 | 14.5 | 2.5 | 9.0 | 18.0 | 3.0 | 9.0 |
| 3 | 18.0 | 2.5 | 11.0 | 21.5 | 3.0 | 11.0 |

All dimensions in mm, dimension tolerance: +10 %




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

## 2. Tightening torque

| Size | Torque moment Nm |
|---|---|
| 1 | 0.5 |
| 2 | 0.5 |
| 3 | 0.7 |

## 3. Tools/Accessories

– ODU open-ended spanner see ODU MINI-SNAP PC, product catalogue section accessories and tools
– ODU crimping tool see ODU MINI-SNAP PC, product catalogue section accessories and tools

## 4. Recommended adhesive for back nut

Scotch-Weld™ DP 190 (grey),
ODU part number 890.204.000.030.025
Recommended cleaning agent: Isopropyl Alcohol.
Caution! If adhesives that have not been released are used, cracks may appear after some time. Use only the indicated adhesive.