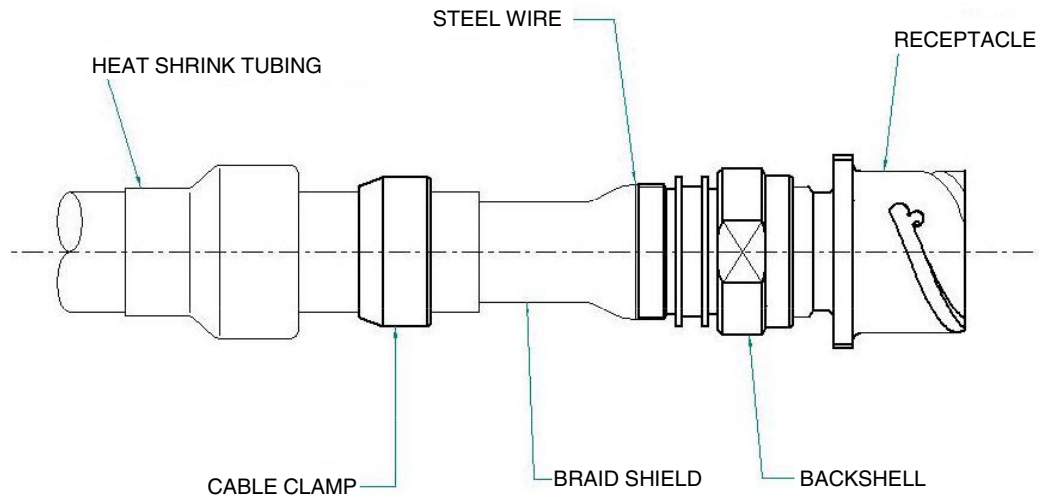


- 2) Assemble connector components as shown in figure 23, page 27.
- 3) Insert conductors in grommet, aligning the imprinted letters or numbers of the cavities on the backside of the insert with those imprinted on the front.
- 4) Strip the cables pursuant to the dimensions shown on Table 2, page 10, using the correct tool. Take care to not cut any wire strands comprising the braided shielding.
- 5) Begin crimping (pages 13-15) or soldering (pages 10-12) contacts.
- 6) Follow instructions on pages 16-19 for inserting crimped contacts.
- 7) If you use lubricant to facilitate contact insertion, carefully clean all insulating parts (Use only isopropyl alcohol as a lubricant).
- 8) Assemble components in the following manner:
 - 8.1) PLUG
In sequence, assemble the flat washer, wave washer and coupling nut onto the connector. Fasten the connector onto its fixed and secure mate or fixture to facilitate assembly.
 - 8.2) RECEPTACLE
Lock the flange taking care to not damage it.
- 9) Assemble the grommet and the compression ring on the back of the connector in sequence.
- 10) Make sure the backshell O-Ring is lubricated (when required) and in the correct position.
- 11) 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 on page 21.
- 12) Pull the braid up over and around the conical part of the backshell, and fix it in place with a stainless steel wire that fits in the seat provided between the conical part and the thread.

When this operation is complete, be sure that the steel retaining wire and the braided shielding do not interfere with the thread (see figure 24).

Figure 24: Receptacle Example



- 13) 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 on page 21.
- 14) Place the shrink boot tubing onto the backshell to position it on the joint seat. Using the proper heating tool, heat the leading side of the shrink boot to adhere it onto the backshell, then heat the rest of the shrink boot until it shrinks and adheres to the cable. When this operation is complete, maintain the cable in the correct position until the shrink boot has cooled.

MULTIPLE RUBBER-COATED CABLES WITH SHRINK BOOTS

The first 11 assembly steps to follow in this application are detailed for Rubber-Coated Cables on pages 22-24. Shrink Boot procedures are detailed in paragraph #14 above (page 29).