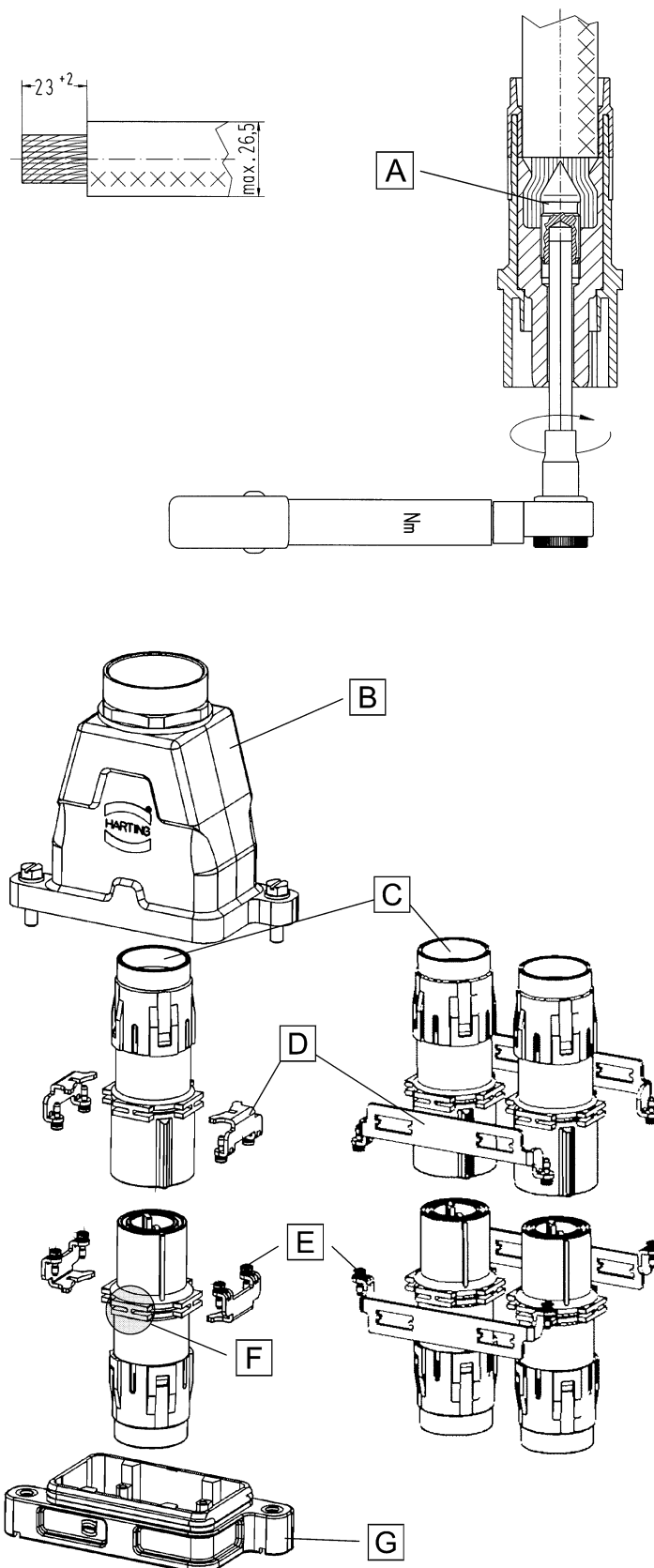


## Assembly instructions



1. Strip cable to  $23+2$  mm.

2. Push conductor through the cable gland and the housing. Push the stripped end of the conductor into the termination entry of the module until the insulation touches the contact.

3. To tighten the axial screw, a hexagonal wrench size 8 is needed. Insert the hexagonal wrench on the mating side of the contact. At the same time, push the conductor over the axial screw. The locking screw has to be tightened with the recommended tightening torque that is determined by the conductor's cross section.

4. Once the modules are terminated, they are mounted into the housing by using two metal frames (tightening torque of the fixing screws = 0.5 Nm). The modules have 4 pegs formed by 2 parallel ribs (each peg shapes like a "H"). Each rib takes 1 pole frame, where the lateral link has to go into the relief of the frame. The 2 pole frames have 2 cutouts on the wall which get fitted to the "H"-shaped pegs (see figure). The heads of the screws have to face the mating direction of the module. Coding can be established by rotating the contact by 90 degrees. Therefore it is important that the corresponding modules are assembled in the correct position otherwise mating is not possible.

5. After assembling the modules in the housing, the tightening torque of the locking screw can be checked and corrected if necessary.

6. After final assembly of the contacts, the user should ensure that the cable is adequately strain relieved to protect the contact from radial stress.

A - Axial screw, B - Hood, C - Termination entry,  
D - Frame, E - Fixing screws, F - parallel ribs with  
H-shape, G - Housings bulkhead mounting,