

Connectors M 16

TWINTUS
inclusive



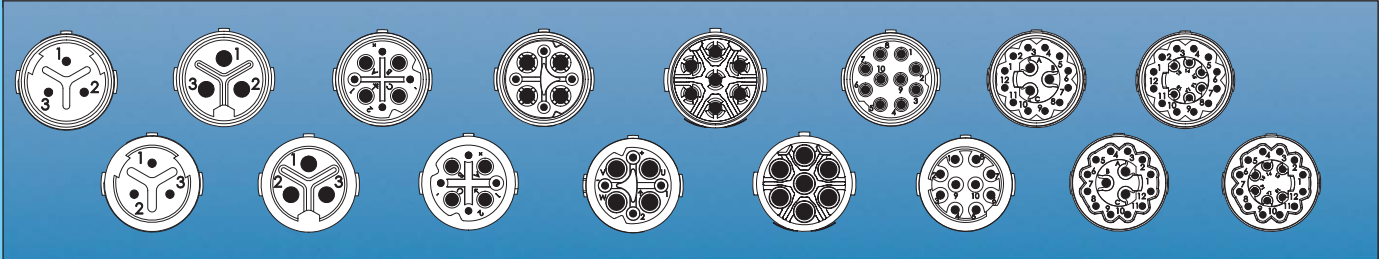
Housings

page 18



Inserts

page 22



Accessories

page 29



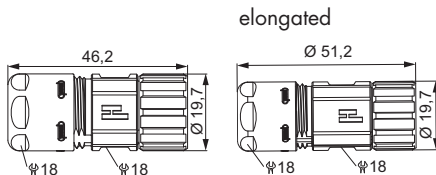
M 16 Control Signal Connectors

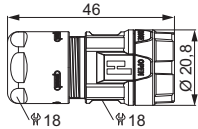
Mechanical Data	Materials and Technical Data
Housing	Copper-Zinc alloy Die Cast
Housing surface	Nickel plated other surface upon request
Inserts (for contacts)	Thermoplastic Polyamid PA 6 (Nylon 6/6), PBT Fire protection class V-0
Contacts	Brass Alloy
Contact surface at point of contact	Nickel and gold plated (0,25µm Au)
Minimum mating cycles	> 1000
Seals / O-Rings	Buna-N standard, optional Viton® (Viton is a registered trademark of DuPont)
Temperature range	-40° C – 125° C (-40 °F – 257 °F)
Type of contacts	Crimp, dip-solder (PCB)
Protection	IP 67 / IP 69K per EN 60 529 (connected), NEMA 4x
Cable diameter range	2 – 11 mm (.08 – .43")

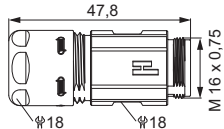
Electrical Data					
Number of positions	3 (3 x 1 mm)	3 (3 x 2 mm)	4 + 3 + PE / 320 V	4 + 3 + PE / 630 V	
Number of contacts	3	3	4 4	4 4	
Contact-Ø [mm]	1	2	0,8 1,6	0,8 1,25	
AWG [mm²]	0,14 – 1	0,5 – 2,5	0,08 – 0,34 0,34 – 1,5	0,08 – 0,34 0,34 – 1,5	
Nominal current ¹⁾ [A]	8	20	5 16	5 16	
Nominal voltage ²⁾ [V~] degree of protection 3 ⁴⁾	400	400	160 320	300 630	
Test voltage (Breakdown voltage) ³⁾ [V~]	2500	2500	1500 2500	1500 2500	
Insulation resistance [MΩ]	> 10 ¹⁰	> 10 ¹⁰	> 10 ¹⁰	> 10 ¹⁰	
Max. contact resistance [mΩ]	3	3	3	3 3	
Number of positions	6+PE	10	12 + 3	18	
Number of contacts	7	10	12 3	18	
Contact-Ø [mm]	1,25	1	0,8 1,25	0,8	
AWG [mm²]	0,5 – 1,5	0,14 – 0,75	0,08 – 0,34 0,5 – 1,5	0,08 – 0,34	
Nominal current ¹⁾ [A]	16	8	3 10	3	
Nominal voltage ²⁾ [V~] degree of protection 3 ⁴⁾	630	160	24 60	24	
Test voltage (Breakdown voltage) ³⁾ [V~]	2500	1500	1500 2500	1500	
Insulation resistance [MΩ]	> 10 ¹⁰	> 10 ⁶	> 10 ¹⁰	> 10 ¹⁰	
Max. contact resistance [mΩ]	3	3	3 3	3	

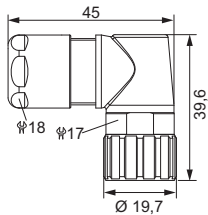
¹⁾, ²⁾, ³⁾, ⁴⁾ See Technical Information page 14

Connectors M 16 / Housing

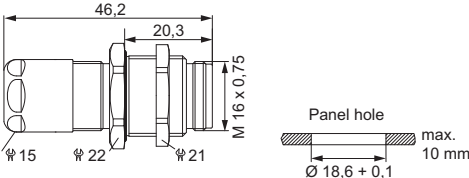
Straight Connector, Female Thread / elongated *		Cable-Ø	Part Number
		3 – 6 mm (.11 – .23").....	7.810.300.000
		5 – 9 mm (.20 – .35").....	7.810.400.000
		8 – 11 mm (.31 – .43").....	7.810.500.000
		* elongated	
		3 – 6 mm (.11 – .23").....	7.811.300.000
		5 – 9 mm (.20 – .35").....	7.811.400.000
		8 – 11 mm (.31 – .43").....	7.811.500.000
Contacts and inserts page 22 • Assembly instructions page 35 / 36			

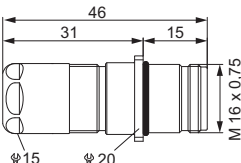
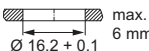
Straight Connector, Female Thread TWILOCK		Cable-Ø	Part Number
		3 – 6 mm (.12 – .24")	7.816.300.000
		5 – 9 mm (.20 – .35")	7.816.400.000
		8 – 11 mm (.31 – .43")	7.816.500.000
		Contacts and inserts page 22 • Assembly instructions page 35 / 36	

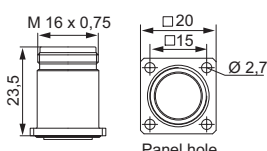
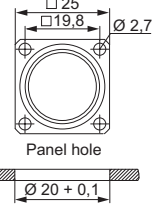
Straight Connector, Male Thread		Cable-Ø	Part Number
		3 – 6 mm (.11 – .23")	7.820.300.000
		5 – 9 mm (.20 – .35")	7.820.400.000
		8 – 11 mm (.31 – .43")	7.820.5000.00
		Contacts and inserts page 22 • Assembly instructions page 35 / 36	

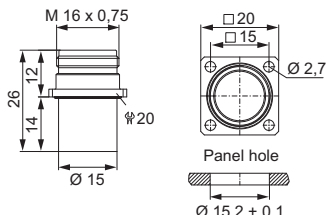
Right Angle Connector with positioning		Cable-Ø	Part Number
		3 – 6 mm (.11 – .23")	7.831.300.000
		5 – 9 mm (.20 – .35")	7.831.400.000
		8 – 11 mm (.31 – .43")	7.831.500.000
		Contacts and inserts page 22 • Assembly instructions page 37	

Connectors M 16 / Housing

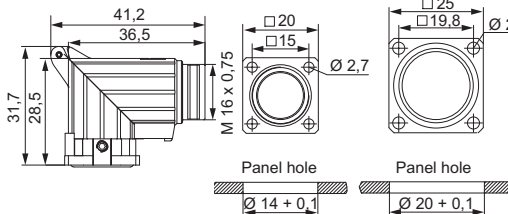
Cable-Ø	Part Number	Panel Connector with built in Cable Strain Relief	
Rear mounting, single hole mounted			
2 – 7 mm (.08 – .28")	7.852.300.000		
5 – 9 mm (.20 – .35")	7.852.400.000		
Including jam nut PG 11			
Contacts and inserts page 22 • Assembly instructions page 35/36			

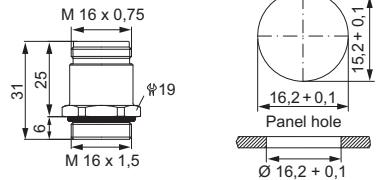
Cable-Ø	Part Number	Panel Connector with built in Cable Strain Relief	
Rear mounting, M2,5 x 4 single hole mounted			
2 – 7 mm (.08 – .28")	7.847.300.000		
5 – 9 mm (.20 – .35")	7.847.400.000		
Contacts and inserts page 22 • Assembly instructions page 35/36			

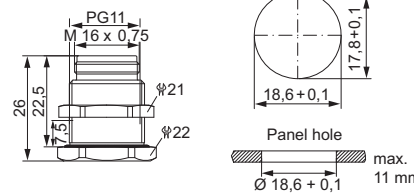
Type	Part Number	Panel Connector, Male Thread, Front Mounting	
4 x holes Ø 2,7 mm (.11") ..7.840.000.000 Flange 20 x 20 mm			
4 x holes Ø 2,7 mm.....7.840.100.000 Flange 25 x 25 mm			
Contacts and inserts page 22 • Assembly instructions page 38			

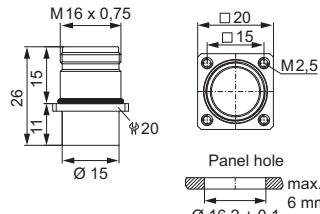
Type	Part Number	Panel Connector, Male Thread, Front Mounting	
Short version			
4 x holes Ø 2,7 mm (.11") ..7.840.200.000 Flange 20 x 20 mm			
			
Contacts and inserts page 22 • Assembly instructions page 38			

Connectors M 16 / Housing

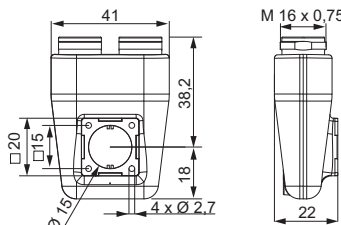
Right Angle Panel Connector, Male Thread, rotating	Type	Part Number
 	300° rotating, locking screw at flange 4 x holes Ø 2,7 mm (.11") ...7.843.000.000 Flange 20 x 20 mm 4 x holes Ø 2,7 mm7.843.100.000 Flange 25 x 25 mm	
Contacts and inserts page 22 • Assembly instructions page 39		

Panel Connector, Male Thread	Type	Part Number
 	Front mounting, single hole mounted Thread M 16 x 1,57.842.000.000	
Contacts and inserts page 22 • Assembly instructions page 38		

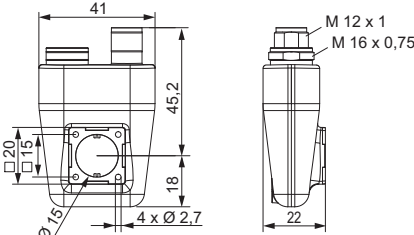
Panel Connector, Male Thread	Type	Part Number
 	Rear mounting, single hole mounted Including jam nut7.850.000.000	
Contacts and inserts page 22 • Assembly instructions page 38		

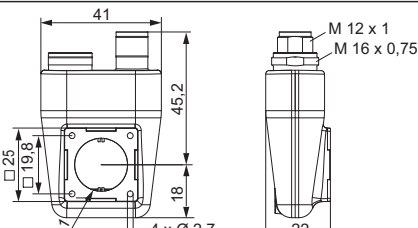
Panel Connector, Male Thread	Type	Part Number
 	Rear mounting, 4 x thread M 2,5 Flange 20 x 20 mm7.845.000.000	
Contacts and inserts page 22 • Assembly instructions page 38		

Connectors M 16 / Housing

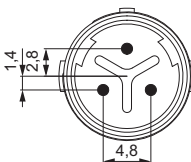
Type	Part Number	TWINTUS	
Flange 20 x 20 mm			
Uncoated	7.848.000.000		
Surface nickel plated	7.848.000.001		
Surface black conductive.....	7.848.000.00B		
Contacts and inserts page 22 • Accessories page 29 • Assembly instructions page 33			

Type	Part Number	TWINTUS	
Flange 25 x 25 mm			
Uncoated	7.848.100.000		
Surface nickel plated	7.848.100.001		
Surface black conductive.....	7.848.100.00B		
Contacts and inserts page 22 • Accessories page 29 • Assembly instructions page 33			

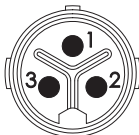
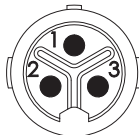
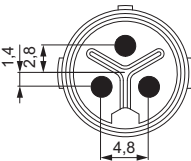
Type	Part Number	TWINTUS M 16 / M 12	
Flange 20 x 20 mm			
Uncoated	7.848.200.000		
Surface nickel plated	7.848.200.001		
Surface black conductive.....	7.848.200.00B		
Contacts and inserts page 22 • Accessories page 29 • Assembly instructions page 34			

Type	Part Number	TWINTUS M 16 / M 12	
Flange 25 x 25 mm			
Uncoated	7.848.300.000		
Surface nickel plated	7.848.300.001		
Surface black conductive.....	7.848.300.00B		
Contacts and inserts page 22 • Accessories page 29 • Assembly instructions page 34			

Connectors M 16 / Inserts / Pinouts

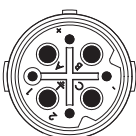
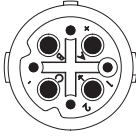
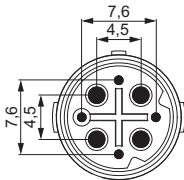
Inserts 3-pole (3 x 1 mm)		Type	Part Number	Part Number
			Pins	Sockets
 Insert pin mating view		Insert		
		without contacts	7.003.903.101	7.003.903.102
		Insert with dip solder contacts		
		Length 10 mm	7.001.903.127	7.001.903.108
		Insert with dip solder contacts		
 Insert socket mating view		Length 17 mm	7.001.903.137	7.001.903.118
		Required Contacts		
		3 x 1 mm	7.010.901.001	7.010.901.002 / 7.010.901.012
				

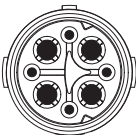
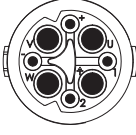
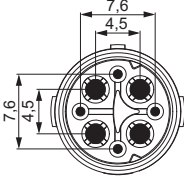
Contacts page 27-28

Inserts 3-pole (3 x 2 mm)	Type	Part Number	Part Number
		Pins	Sockets
	Insert		
Insert pin mating view	without contacts	7.003.983.101	7.003.983.102
	Insert with dip solder contacts		
	Length 10 mm	7.001.983.127	7.001.983.108
	Insert with dip solder contacts		
	Length 17 mm	7.001.983.137	7.001.983.118
			
Insert socket mating view			
	Required Contacts		
	3 x 2 mm	7.010.982.001	7.010.982.002
			

Contacts page 27-28

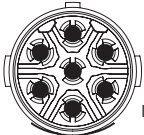
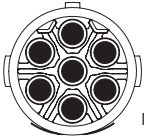
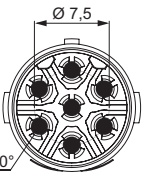
Connectors M 16 / Inserts / Pinouts

Type	Part Number	Part Number	Inserts 4+3+PE
	Pins	Sockets	
Insert			
without contacts	7.003.943.101	7.003.943.102	Insert pin mating view 
Insert RAL 2003 (DESINA orange)			
without contacts	7.053.943.101	7.053.943.102	
Insert with dip solder contacts			
Length 10 mm	7.001.943.127	7.001.943.108	
Insert with dip solder contacts			
Length 17 mm	7.001.943.137	7.001.943.118	Insert socket mating view 
Required Contacts			
4 x 0,8 mm	7.010.980.801	7.010.980.802	
4 x 1,6 mm	7.010.981.601	7.010.981.602	
Contacts page 27-28			

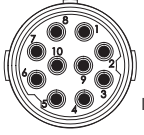
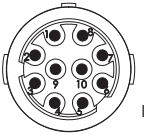
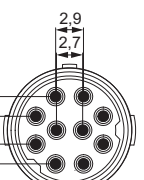
Type	Part Number	Part Number	Inserts 4+3+PE 630 V
	Pins	Sockets	
Insert			
without contacts	7.003.908.101	7.003.908.102	Insert pin mating view 
Insert RAL 2003 (DESINA orange)			
without contacts	7.053.908.101	7.053.908.102	
Insert with dip solder contacts			
Length 10 mm ¹⁾	7.001.908.127	7.001.908.108	
Insert with dip solder contacts			
Length 17 mm ¹⁾	7.001.908.137	7.001.908.118	Insert socket mating view 
Required Contacts			
4 x 0,8 mm	7.010.980.811	7.010.980.812	
4 x 1,25 mm	7.010.981.211	7.010.981.212	
Contacts page 27-28			

¹⁾ Under development

Connectors M 16 / Inserts / Pinouts

Inserts 6+PE	Type	Part Number	
		Pins	Sockets
 Insert pin mating view	Insert		
	without contacts	7.003.961.101	7.003.961.102
	Insert RAL 2003 (DESINA orange)		
 Insert socket mating view	without contacts	7.053.961.101	7.053.961.102
	Insert with dip solder contacts		
	Length 10 mm ¹⁾	7.001.961.127	7.001.961.108
 	Insert with dip solder contacts		
	Length 17 mm ¹⁾	7.001.961.137	7.001.961.118
	Required Contacts		
	7 x 1,25 mm	7.010.981.211	7.010.981.212

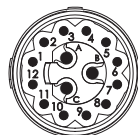
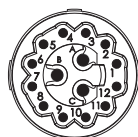
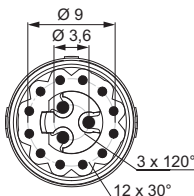
Contacts page 27-28

Inserts 10-pole	Type	Part Number	
		Pins	Sockets
 Insert pin mating view	Insert		
	without contacts	7.003.910.101	7.003.910.102
	Insert RAL 6018 (DESINA green)		
 Insert socket mating view	without contacts	7.053.910.101	7.053.910.102
	Insert with dip solder contacts		
	Length 10 mm	7.001.910.127	7.001.910.108
 	Insert with dip solder contacts		
	Length 17 mm	7.001.910.137	7.001.910.118
	Required Contacts		
	10 x 1 mm	7.010.981.001	7.010.981.002

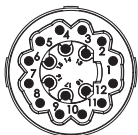
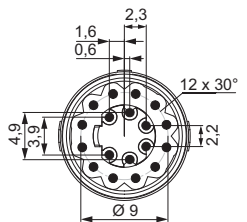
Contacts page 27-28

¹⁾ Under development

Connectors M 16 / Inserts / Pinouts

Type	Part Number	Part Number	Inserts 12+3-pole
	Pins	Sockets	
Insert			
without contacts	7.003.985.101	7.003.985.102	Insert pin mating view 
Insert with dip solder contacts			
Length 10 mm	7.001.985.127	7.001.985.108	
Insert with dip solder contacts			Insert socket mating view 
Length 17 mm	7.001.985.137	7.001.985.118	
Required Contacts			
12 x 0,8 mm	7.010.980.801	7.010.980.802	
3 x 1,25 mm	7.010.981.201	7.010.981.202	

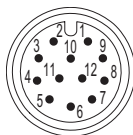
Contacts page 27-28

Type	Part Number	Part Number	Inserts 18-pole
	Pins	Sockets	
Insert			
without contacts	7.003.988.101	7.003.988.102	
Insert RAL 6018 (DESINA green)			
without contacts	7.053.988.101	7.053.988.102	
Insert with dip solder contacts			
Length 10 mm	7.001.988.127	7.001.988.108	
Insert with dip solder contacts			
Length 17 mm	7.001.988.137	7.001.988.118	
Required Contacts			
18 x 0,8 mm	7.010.980.801	7.010.980.802	

Contacts page 27-28

Connectors M 16 / Inserts / Pinouts

Inserts M 12 for TWINTUS M 16 / M 12 8-pole	Type	Part Number
 insert pin mating view	Pins Insert with solder contactsA712-7001908103	

Inserts M 12 for TWINTUS M 16 / M 12 12-pole	Type	Part Number
 insert pin mating view	Pins Insert with solder contactsA712-7001912103	

Connectors M 16 / Contacts

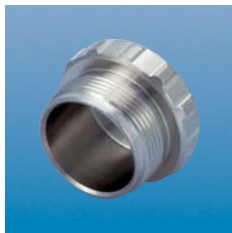
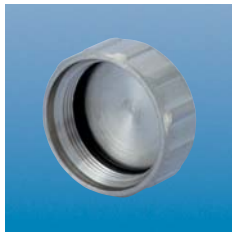
Type	Crimp Range	Part Number	Contacts
Crimp pin 0,8 mm, machined.....	0,08 – 0,34 mm ² (AWG 28 – 22)	7.010.980.801	
Crimp socket 0,8 mm, machined.....	0,08 – 0,34 mm ² (AWG 28 – 22)	7.010.980.802	
Crimp pin 0,8 mm, machined.....	0,08 – 0,34 mm ² (AWG 28 – 22)	7.010.980.811	
Crimp socket 0,8 mm, machined.....	0,08 – 0,34 mm ² (AWG 28 – 22)	7.010.980.812	
Crimp pin 1 mm, machined.....	0,08 – 0,75 mm ² (AWG 28 – 18)	7.010.981.001	
Crimp socket 1 mm, machined.....	0,08 – 0,75 mm ² (AWG 28 – 18)	7.010.981.002	
Crimp pin 1 mm, machined.....	0,14 – 1 mm ² (AWG 26 – 17)	7.010.901.001	
Crimp socket 1 mm, machined.....	0,08 – 0,56 mm ² (AWG 28 – 20)	7.010.901.012	
Crimp socket 1 mm, machined.....	0,34 – 1 mm ² (AWG 22 – 17)	7.010.901.002	
Crimp Tool Settings see page 31 / 32 Please see assembly instructions on page 40			

Connectors M 16 / Contacts

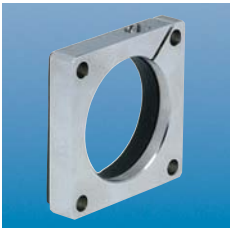
Contacts	Type	Crimp Range	Part Number
	Crimp pin 1,25 mm, machined.....	0,5 – 1,5 mm ² (AWG 20 – 16).....	7.010.981.201
	Crimp socket 1,25 mm, machined.....	0,5 – 1,5 mm ² (AWG 20 – 16).....	7.010.981.202
	Crimp pin 1,25 mm, machined.....	0,34 – 1,5 mm ² (AWG 20 – 16).....	7.010.981.211
	Crimp socket 1,25 mm, machined.....	0,34 – 1,5 mm ² (AWG 20 – 16).....	7.010.981.212
	Crimp pin 1,6 mm, machined.....	0,34 – 1,5 mm ² (AWG 22 – 16).....	7.010.981.601
	Crimp socket 1,6 mm, machined.....	0,34 – 1,5 mm ² (AWG 22 – 16).....	7.010.981.602
	Crimp pin 2 mm, machined.....	1,0 – 2,5 mm ² (AWG 17 – 14).....	7.010.982.001
	Crimp socket 2 mm, machined.....	1,0 – 2,5 mm ² (AWG 17 – 14).....	7.010.982.002

Crimp Tool Settings see page 31 / 32
Please see assembly instructions on page 40

Connectors M 16 / Accessories

Type	Part Number	Accessories
Plastic protective cap for connectors with male thread for connectors with female thread	7.000.980.161 7.000.980.162	
Brass protective cap for connectors with female thread	7.010.900.163	
Brass protective cap for connectors with male thread	7.010.900.162	
Brass protective cap with chain for connectors with female threadLength 70 mm	7.010.9S0.705	
Brass protective cap with chain for connectors with male threadLength 70 mm	7.010.9S0.704	

Connectors M 16 / Accessories

Accessories	Type	Part Number
	Crimp tool for manual crimping of machined crimp contacts for signal connectors M 16 and M 23	7.000.900.904
	See page 84 for crimp tool instructions	
	Adaptor flange for Straight Connectors	7.010.900.135
	Conduit adaptor	DN 107.010.900.200 Snapflex 16.....7.010.900.201 DN 127.010.900.202 Snapflex 16.....7.010.900.203
	EMC-sheet for TWINTUS Flange 20 x 20	7.040.848.101
	for TWINTUS Flange 25 x 25	7.040.848.102
	Plastic protective cap for TWINTUS	
	TWINTUS M 16	7.000.848.101
	TWINTUS M 16 / M 12	7.000.848.102

Crimp Tool for Connectors M 16

Crimp Tool Setting for HUMMEL Crimp Contacts (Crimp Tool 7.000.900.904)

Part Number	Crimp Contact	Cross Section (mm ²)	AWG	Crimp Tool Setting mm	Locator Setting
7.010.980.801	Crimp pin 0,8 mm	0,08	AWG 28	0,57	10
		0,14	AWG 26	0,60	
		0,25	AWG 24	0,64	
		0,34	AWG 22	0,73	
7.010.980.802	Crimp socket 0,8 mm	0,08	AWG 28	0,57	10
		0,14	AWG 26	0,60	
		0,25	AWG 24	0,64	
		0,34	AWG 22	0,73	
7.010.980.811	Crimp pin 0,8 mm	0,08	AWG 28	0,57	B7
		0,14	AWG 26	0,60	
		0,25	AWG 24	0,64	
		0,34	AWG 22	0,73	
7.010.980.812	Crimp socket 0,8 mm	0,08	AWG 28	0,57	B8
		0,14	AWG 26	0,60	
		0,25	AWG 24	0,64	
		0,34	AWG 22	0,73	
7.010.981.001	Crimp pin 1 mm	0,08	AWG 28	0,60	7
		0,14	AWG 26	0,65	
		0,25	AWG 24	0,67	
		0,34	AWG 22	0,71	
		0,56	AWG 20	0,75	
		0,75	AWG 18	0,82	
7.010.981.002	Crimp socket 1 mm	0,08	AWG 28	0,60	8
		0,14	AWG 26	0,63	
		0,25	AWG 24	0,66	
		0,34	AWG 22	0,69	
		0,56	AWG 20	0,75	
		0,75	AWG 18	0,83	
7.010.901.001	Crimp pin 1 mm	0,14	AWG 26	0,70	1
		0,25	AWG 24	0,76	
		0,34	AWG 22	0,82	
		0,50	AWG 20	0,90	
		0,75	AWG 18	1,00	
		1,0	AWG 17	1,10	
7.010.901.012	Crimp socket 1 mm (0,08-0,56 mm ²)	0,08	AWG 28	0,75	2
		0,14	AWG 26	0,78	
		0,25	AWG 24	0,82	
		0,34	AWG 22	0,86	
		0,56	AWG 20	0,90	

These values are only guidelines and actual conductor cross sections depend on manufacturer tolerances.

See page 40 for crimp tool instructions

Crimp Tool for Connectors M 16

Crimp Tool Setting for HUMMEL Crimp Contacts (Crimp Tool 7.000.900.904)

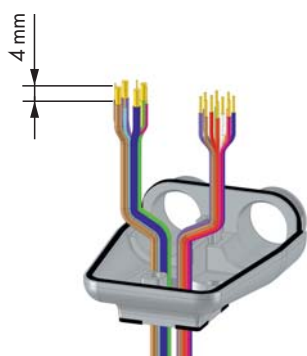
Part Number	Crimp Contact	Cross Section (mm ²)	AWG	Crimp Tool Setting mm	Locator Setting
7.010.901.002	Crimp socket 1 mm (0,34 – 1 mm ²)	0,34	AWG 22	0,77	2
		0,56	AWG 20	0,82	
		0,75	AWG 18	0,88	
		1,0	AWG 17	0,95	
7.010.981.201	Crimp pin 1,25 mm	0,5	AWG 20	0,70	2
		0,75	AWG 18	0,73	
		1,0	AWG 17	0,79	
		1,5	AWG 16	0,88	
7.010.981.202	Crimp socket 1,25 mm	0,5	AWG 20	0,70	2
		0,75	AWG 18	0,73	
		1,0	AWG 17	0,79	
		1,5	AWG 16	0,88	
7.010.981.211	Crimp pin 1,25 mm	0,34	AWG 22	0,80	B9
		0,5	AWG 20	0,84	
		0,75	AWG 18	0,90	
		1,0	AWG 17	1,00	
		1,5	AWG 16	1,10	
7.010.981.212	Crimp socket 1,25 mm	0,34	AWG 22	1,00	B10
		0,5	AWG 20	1,04	
		0,75	AWG 18	1,10	
		1,0	AWG 17	1,20	
		1,5	AWG 16	1,30	
7.010.981.601	Crimp pin 1,6 mm	0,34	AWG 22	0,80	6
		0,56	AWG 20	0,84	
		0,75	AWG 18	0,90	
		1,0	AWG 17	1,00	
		1,5	AWG 16	1,10	
7.010.981.602	Crimp socket 1,6 mm	0,34	AWG 22	0,83	9
		0,56	AWG 20	0,90	
		0,75	AWG 18	0,97	
		1,0	AWG 17	1,02	
		1,5	AWG 16	1,10	
7.010.982.001	Crimp pin 2 mm	1,0	AWG 17	1,35	4
		1,5	AWG 16	1,45	
		2,5	AWG 14	1,60	
7.010.982.002	Crimp socket 2 mm	1,0	AWG 17	1,35	5
		1,5	AWG 16	1,45	
		2,5	AWG 14	1,60	

These values are only guidelines and actual conductor cross sections depend on manufacturer tolerances.

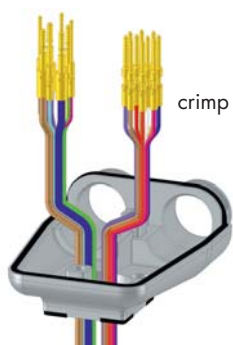
See page 40 for crimp tool instructions

TWINTUS

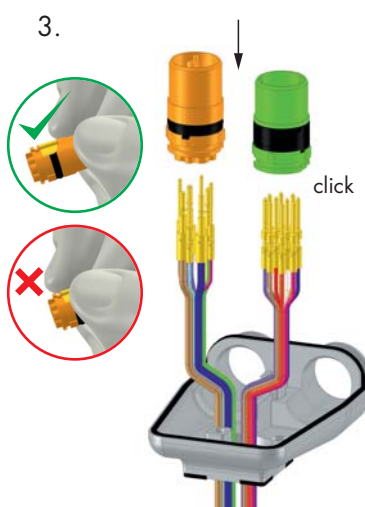
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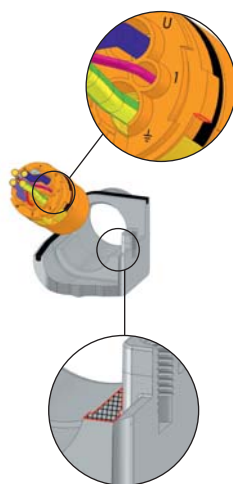
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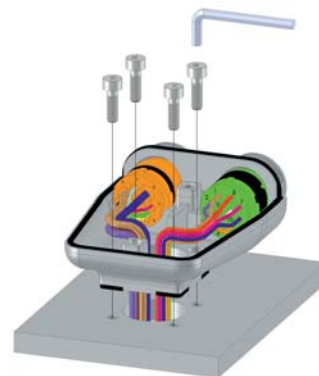
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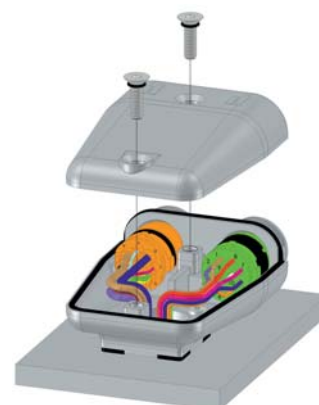
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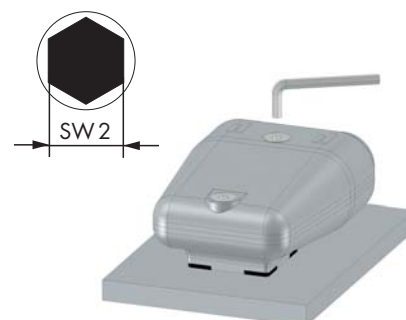
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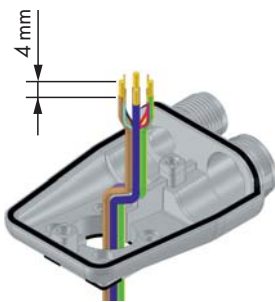
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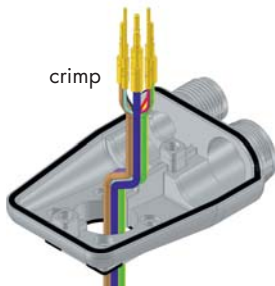
Connectors M 16 / Assembly Instructions

TWINTUS M16 / M12

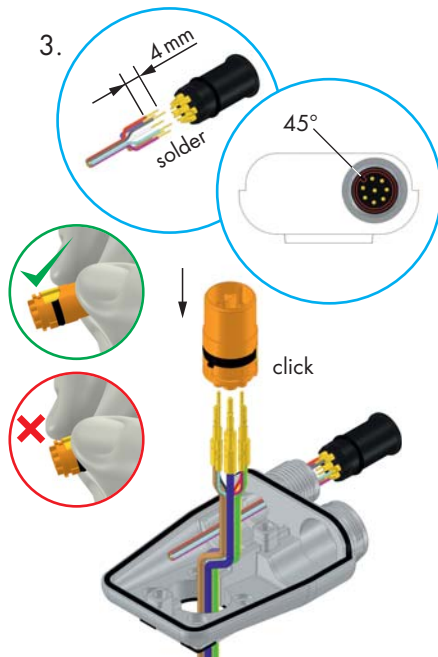
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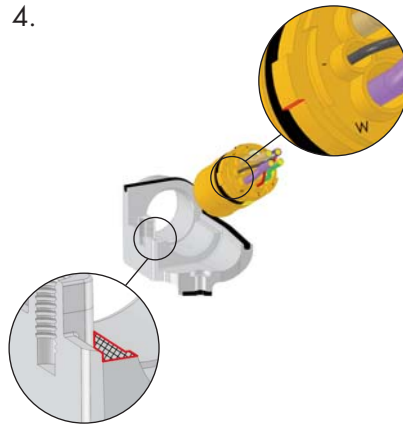
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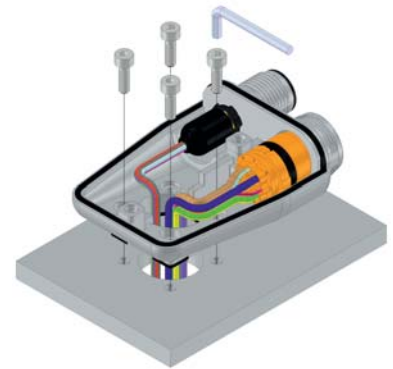
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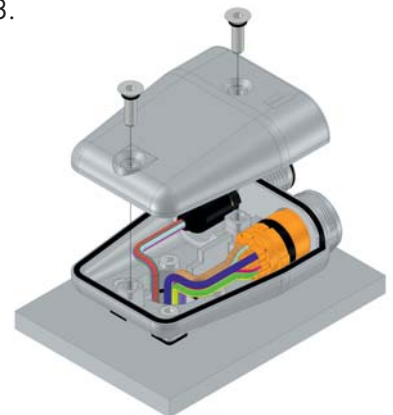
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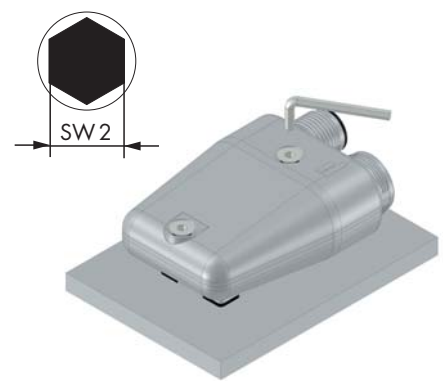
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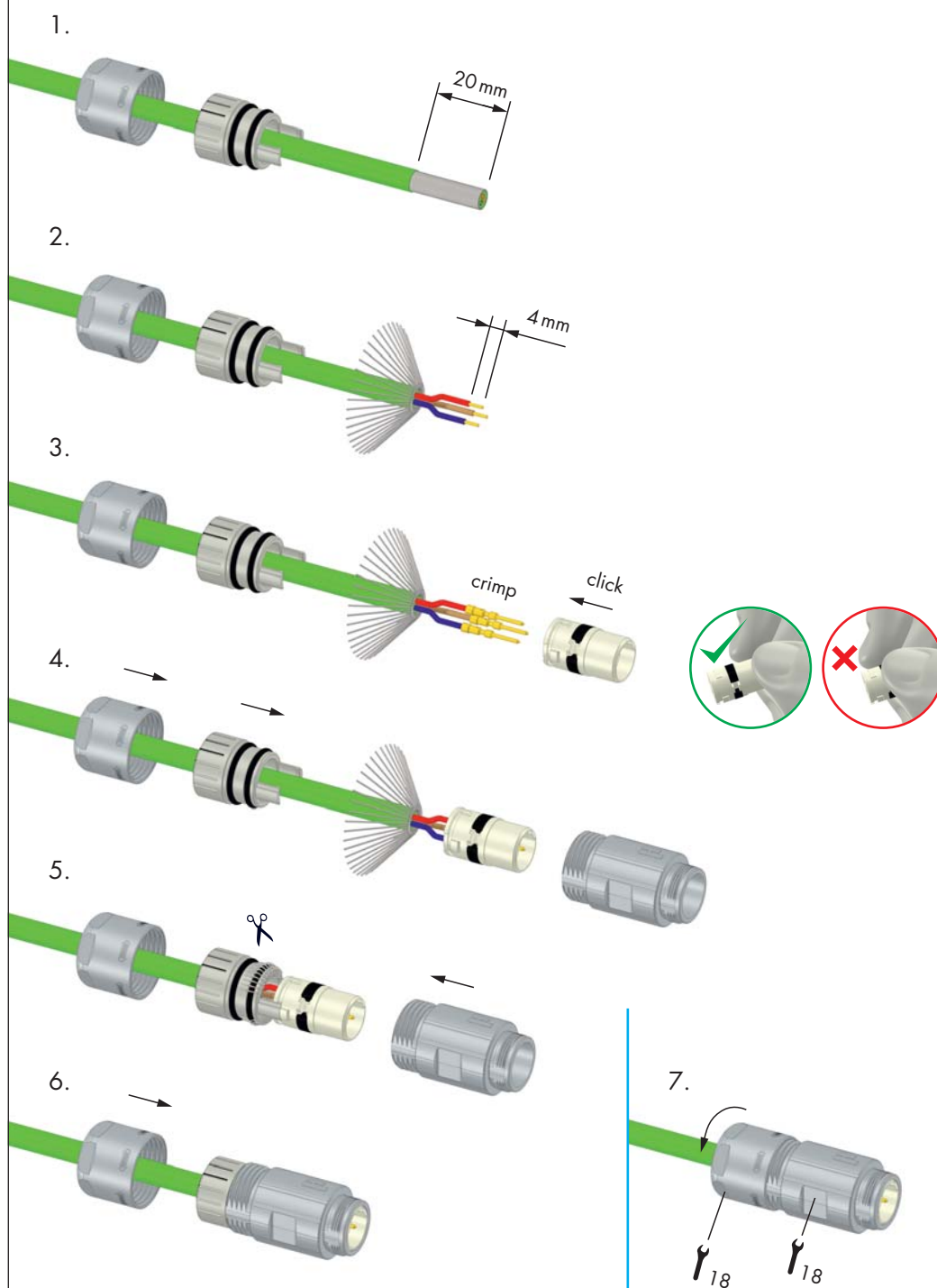


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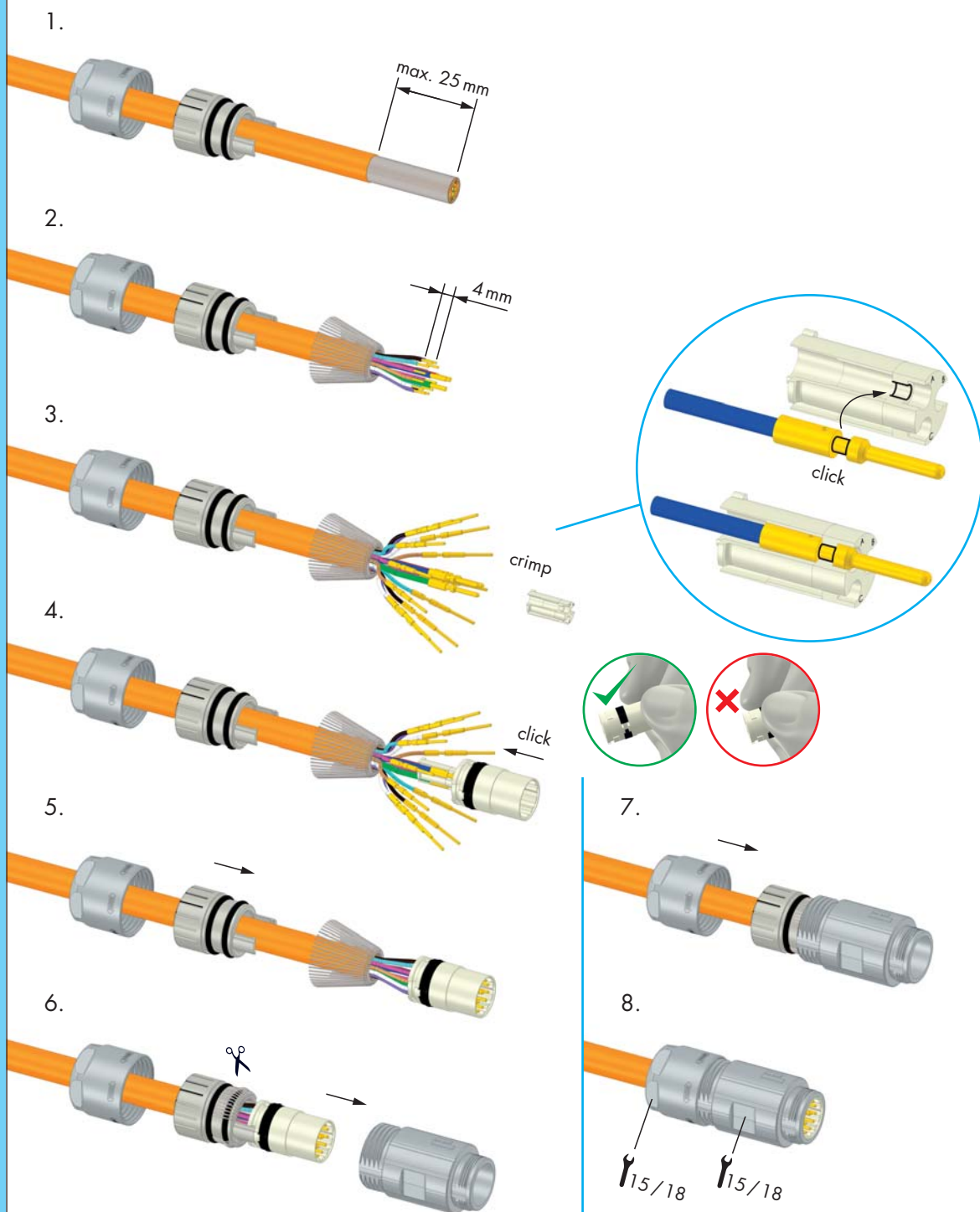
Connectors M 16 / Assembly Instructions

Female Threaded Connector / Male Threaded Connector



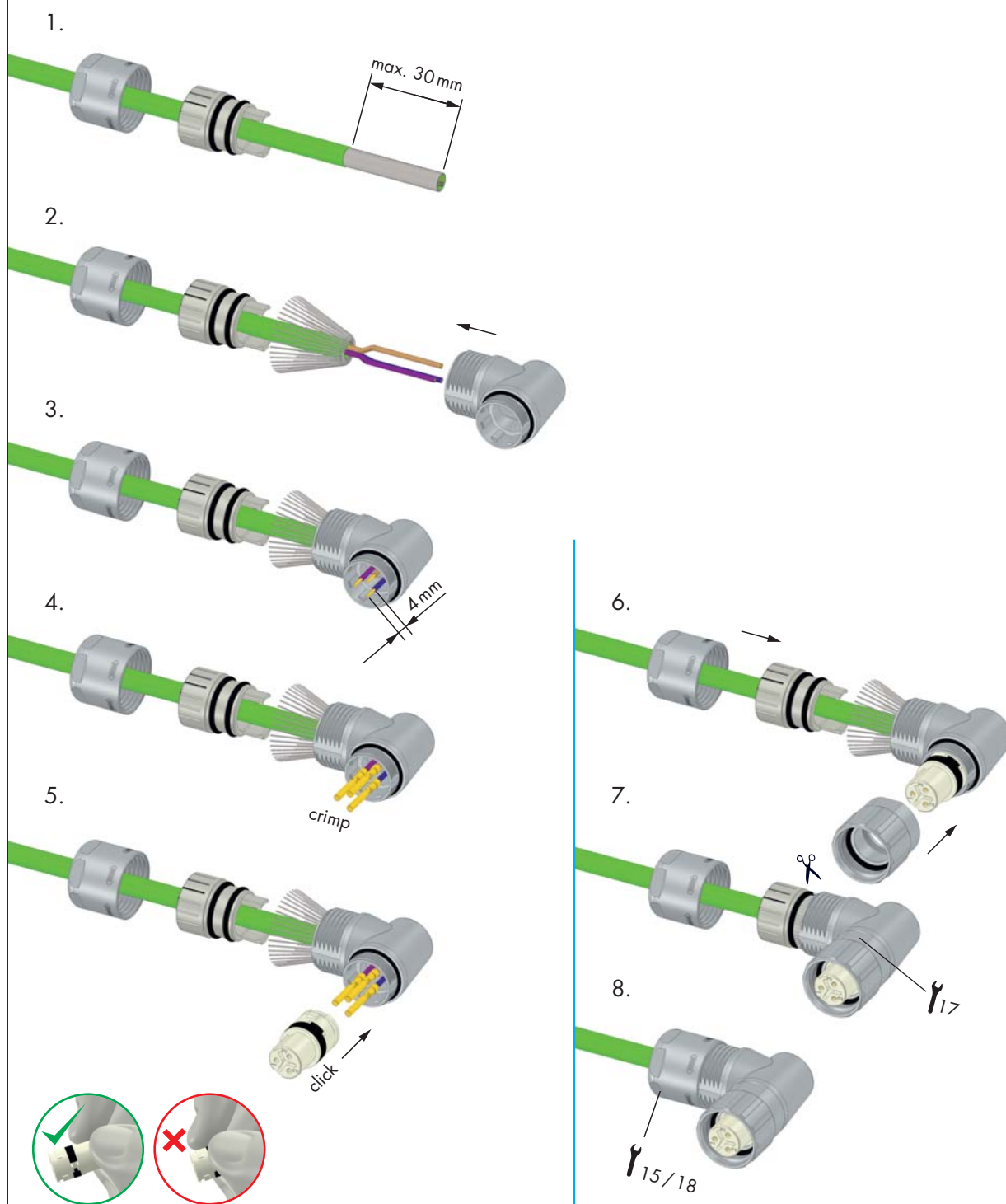
Connectors M 16 / Assembly Instructions

Female Threaded Connector / Male Threaded Connector 12+3



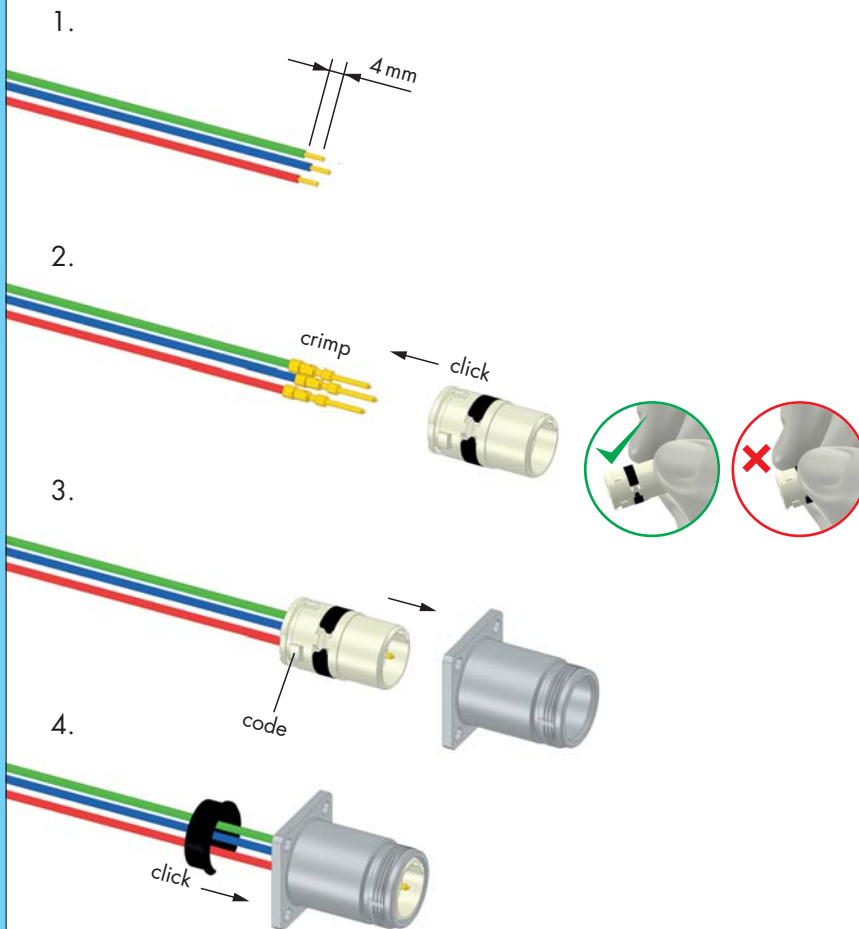
Connectors M 16 / Assembly Instructions

Right angle connector with positioning



Connectors M 16 / Assembly Instructions

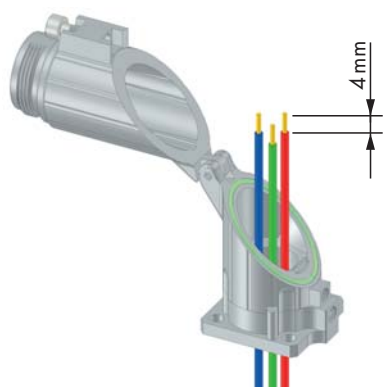
Panel Connector



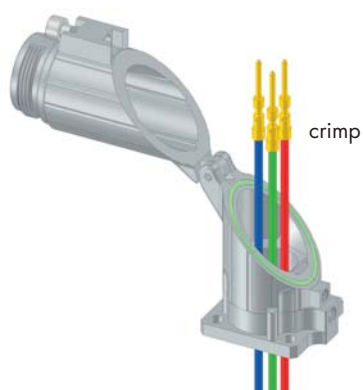
Connectors M 16 / Assembly Instructions

Right Angle Panel Connector

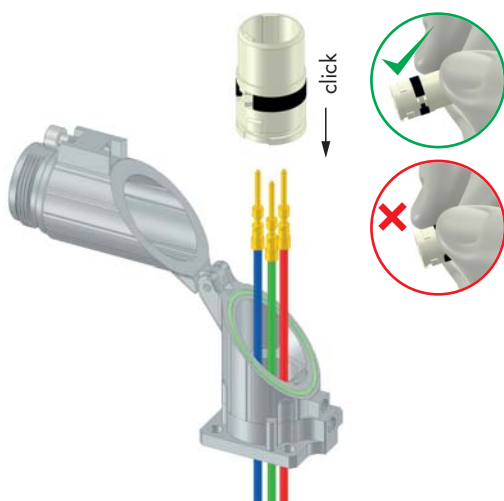
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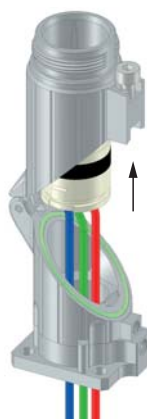
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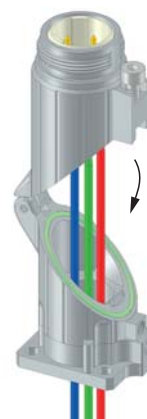
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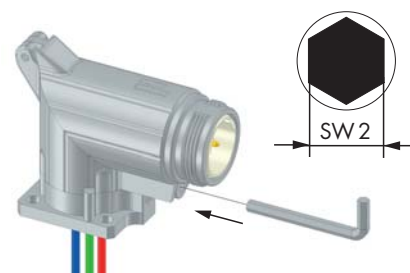
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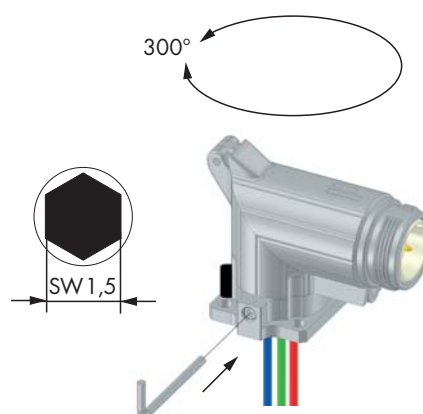
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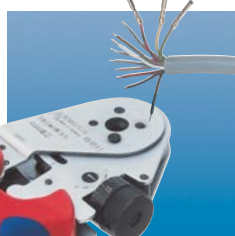


7.



Crimping, Assembly and Disassembly of Contacts

Crimping, Assembly and Disassembly of Contacts



Crimping

- Remove conductor insulation 4 mm (.16") max.
- Select appropriate Crimp tool setting (see page 31 - 32)
- Push crimp contact into opening of crimping tool
- Insert stripped wire into the funnel shaped end of the crimp contact
- Squeeze handles of crimping tool together connect contact to wire

Assembly

- Remove crimped assembly and pull on wire to test connection
- Push into desired position of insert

Disassembly of Contacts from Insert

A small screwdriver is needed to remove the contacts from the insert.

- Release the white ring by a screwdriver out of the insert
- Move the misplaced contacts out of the insert
- Enter the ring back into the insert
- Push the contacts back into insert

Shielding

- Assemble strain relief insert with insert
- Fold stranding of the shield back over the first O-Ring of the strain relief insert
- Cut back the overextending braid



The stranding of the shield is not allowed to touch the second O-Ring. Otherwise the assembly may not be proof.