



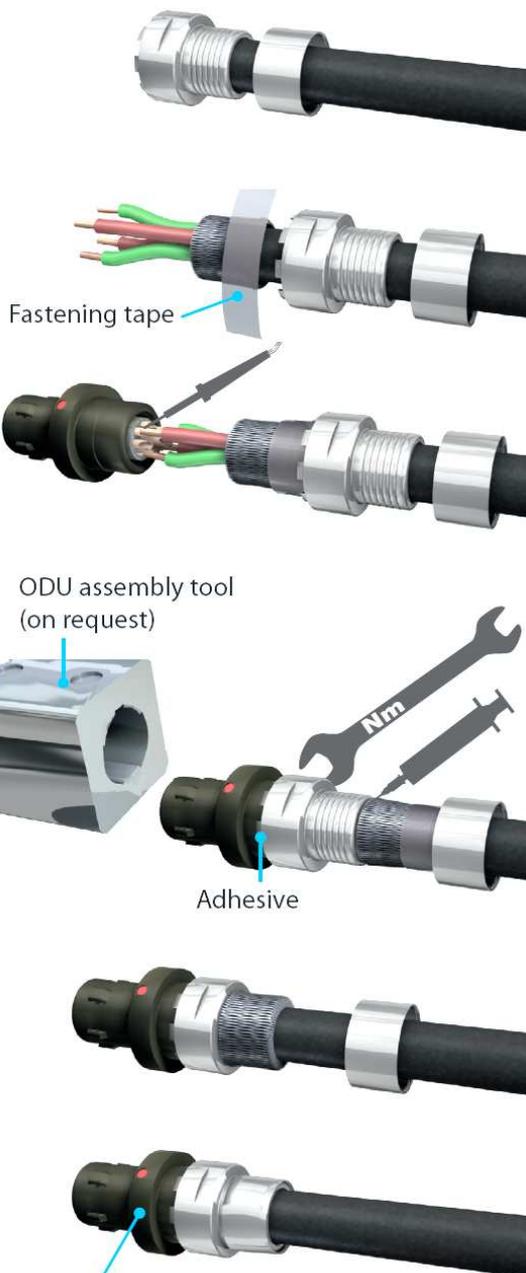
Assembly Instruction



Break-Away and Easy Clean plug



Size	max. cable Ø mm
0	5.5
1	6.5
1.5 (A)	8.0
2	10.0
3	11.5



- Slide crimp sleeve and crimp adapter over the cable. The crimp sleeve is not needed if a metal band is used for fastening the shield to the crimp adapter.
- Strip the cable and conductors. Fold back the shield and use fastening tape to fasten it to the cable jacket. Tin-plate this wires if needed.
- Solder the wires, noting the placement of each wire according to your wiring chart.
- Screw the crimp adapter on so that it is flush, observing torque values. Secure the screw thread with adhesive. Encapsulate the interior of the crimp adapter to secure the soldered points.
- Remove the fastening tape and lay the shield braid on to the crimp adapter. Fasten the shield braid to the crimp adapter by means of crimping or by using a metal band.
- Bend relief: This can be implemented by means of overmolding or by using shrink tube.

Sealing surface for cable overmolding



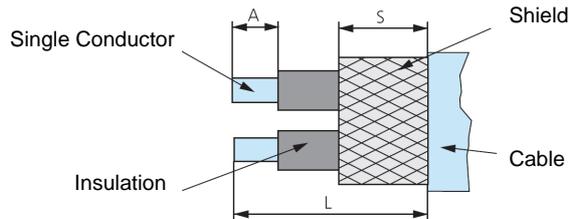
Assembly Instruction



Break-Away and Easy Clean plug

2 Cable Preparation

The following table provides recommended guidelines for cable preparation. The according stripping measures have to be checked before assembly!



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

Size	Contact \varnothing	L	A	S
0	0.5	8	2	8
	0.6	8	2	8
	0.7	8	2	8
	0.9	8	2	8
1	0.5	9	2	8
	0.6	9	2	8
	0.7	9	2	8
	0.9	9	2	8
1.5 (A)	0.5	11	2	8
	0.6	11	2	8
	0.7	11	2	8
2	0.5	11	2	8
	0.7	11	2	8
	1.3	11	2	8
3	0.5	13	2	8
	0.7	13	2	8
	0.9	13	2	8
	2.0	13	2	8

All dimensions in mm
 Tolerance: +10 %

Exceptions are noted on special instructions.
 Right-angle plugs have special instructions.

Notes for data-rate-connectors

Before soldering, twist the strands back slightly in the original direction. If a shield is available for the separately pairs of wires (e.g. STP-Cables), wrap it around the pairs so as far as possible.



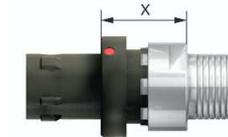
Assembly Instruction



Break-Away and Easy Clean plug

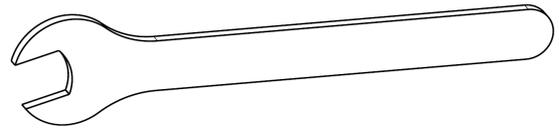
4 Assembly Crimp Adapter

Size	Torque Nm	Reference Dimension x mm
0	0.5	8.7
1	1.0	12.2
1.5 (A)	1.5	12.2
2	2.0	12.6
3	2.5	13.3



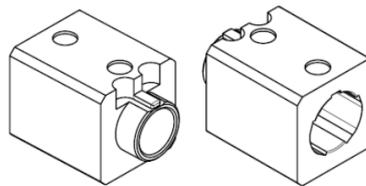
4.1 Spann wrench

Size	Part number	Wrench size
0	598.700.001.022.000	9
1	598.700.001.012.000	11
1.5 (A)	598.700.001.003.000	12
2	598.700.001.005.000	14
3	598.700.001.023.000	18



4.2 Assembly tool

Size	Part number
0	700.645.900.320.000
1	701.645.900.320.000
1.5 (A)	715.645.900.320.000
2	702.645.900.320.000
3	703.645.900.320.000



4.3 Adhesive

Secure the crimp adapter on housing with adhesive (ODU reference Loctite 2701)

4.4 Potting the interior of the crimp adapter

Encapsulate the interior of the crimp adapter to secure the soldered points with 2K casting resin PU. (ODU reference WEVO-2K-casting resin PU552FL)



Assembly Instruction



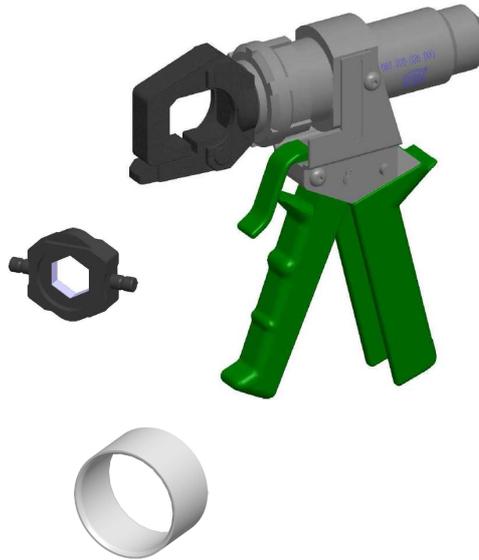
Break-Away and Easy Clean plug

5 Assembly crimp sleeve

5.1 Crimp tool ODU

Hand-crimptong	
Size	Part number
all	080.000.026.000.000

Crimp dies	
Size	Part number
0	080.000.026.700.000
1	080.000.026.701.000
1.5 (A)	080.000.026.715.000
2	080.000.026.702.000
3	080.000.026.703.000



To connect the shielding with the crimp

5.2 Band-It Bands

Hand-crimptong	
Size	Part number
all	080.000.058.000.000

Tie-Dex Micro Bands	
Size	Part number
0-3	921.000.004.000.248
4,5 (E)	921.000.004.000.249



To connect the shielding with the crimp adapter, using a Tie-Dex Micro Band.



Assembly Instruction



Break-Away and Easy Clean plug

6 Cable interface

6.1 ODU overmolding

We provide complete solution with straight and right-angle overmolding on request



6.2 Heatshrinkable straight solution

Size	Part number	
	ODU	Hellermann
0-3	921.000.010.008.084	401-52880



6.3 Heatshrinkable right-angle solutions

Size	Part number	
	ODU	Hellermann
0	921.000.010.008.086	411-08480
1-3	921.000.010.008.087	411-52480



To a better adhesion of the heatshrink boots on housing and cable, we recommend to work with an epoxyd-adhesion. (z.B. Hellermann V9500, Raychem S1125)