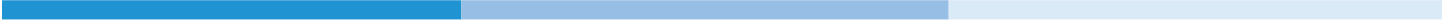


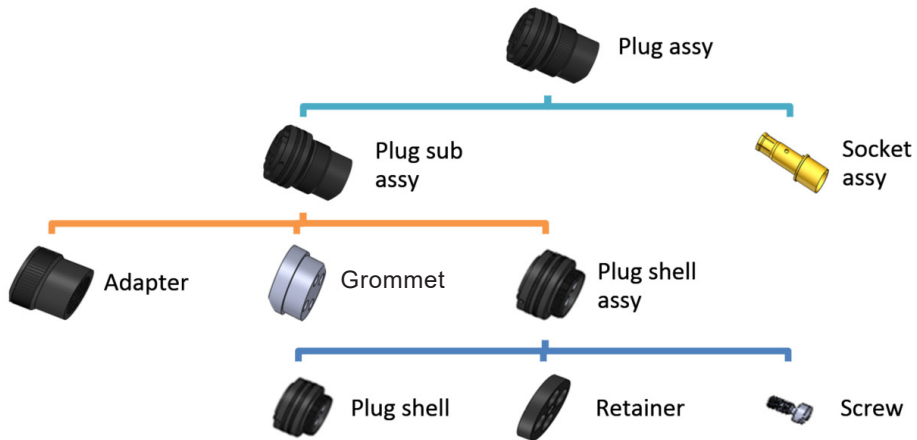
CABLE ASSEMBLY WORK INSTRUCTION

**GT Quadrax**

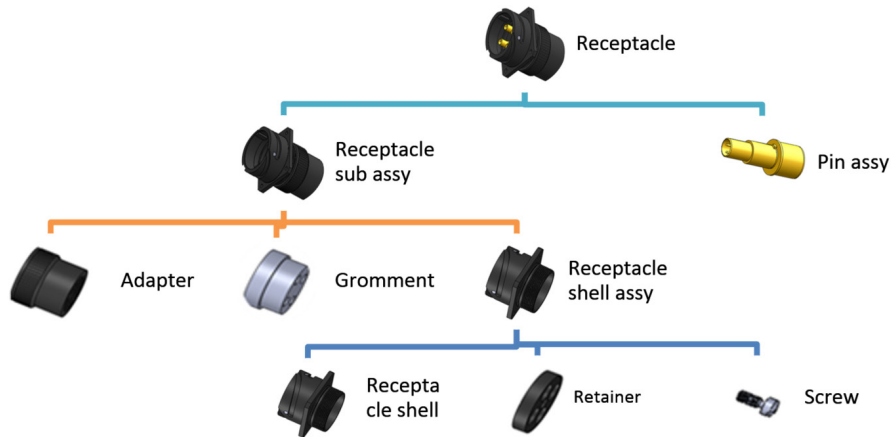


# Part 1: Product Structure

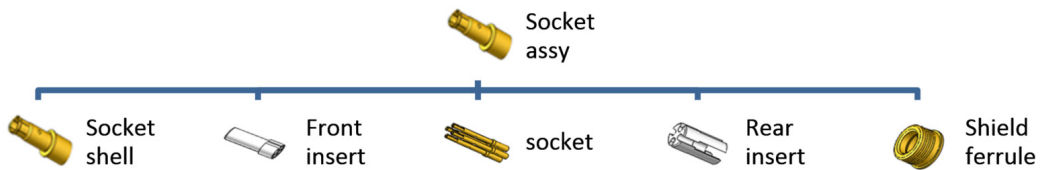
## 1. Plug



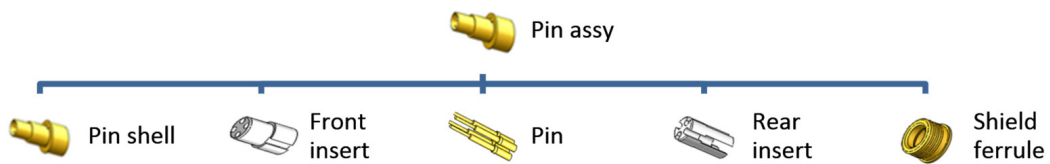
## 2. Receptacle



## 3. Socket Assembly



## 4. Pin Assembly



# Part 2: Assembly Instructions

## Step 1: Preparation

Before assembling the contacts, pass the wires through adapter, grommet and retainer successively. Check the direction of each component as shown in Figure 1.

Note: Lubricate the wire with isopropyl alcohol. Keep free of oil, grease and dirt.

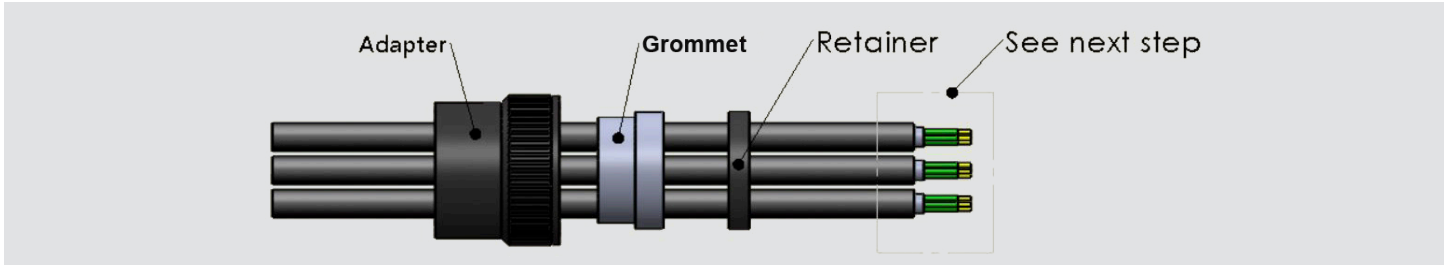


Figure 1

## Step 2: Contact Assembly

1. Strip the insulation by 17.5mm as shown in Figure 2

Note: The conductor shall be free from deformation, and the shielding layer shall not be damaged.

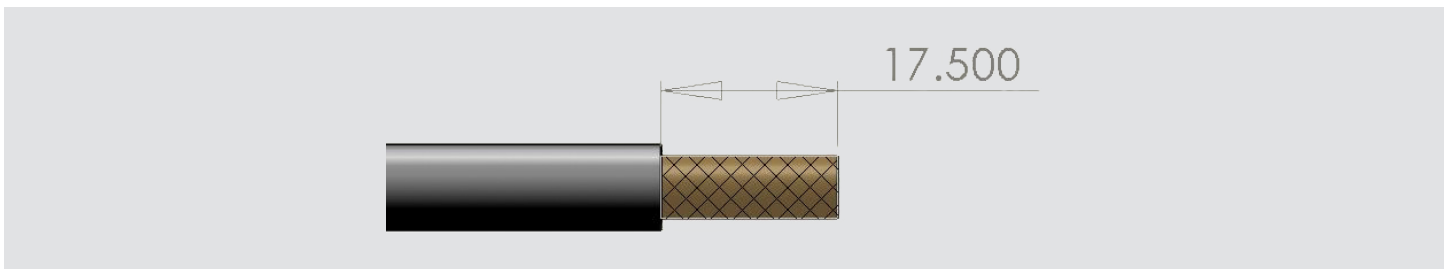


Figure 2

2. Pass the stripped wire through the shield ferrule, flip the shielding layer and trim the redundant shield layer as shown in Figure 3 and 4.



Figure 3

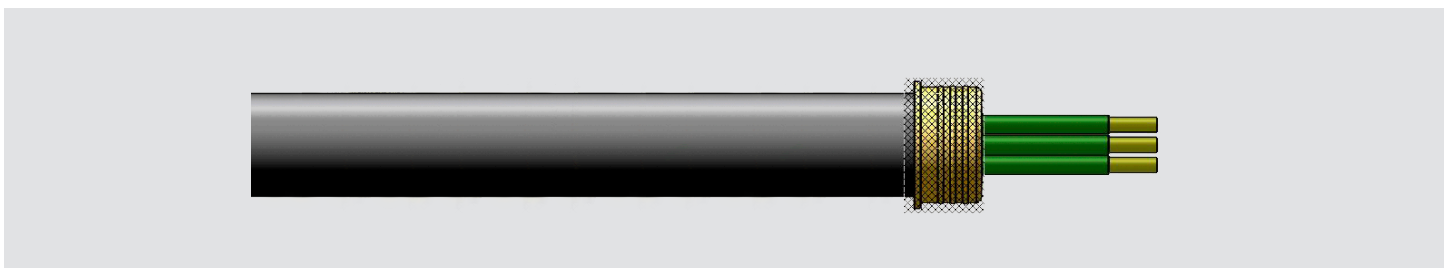


Figure 4

- Strip the insulation of the individual wire by 4mm as shown in Figure 5

Note: Make sure all the individual wires are the same length.

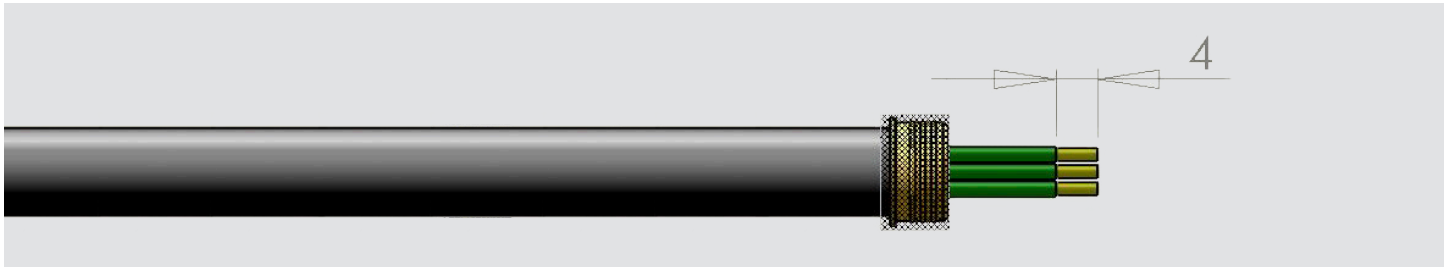


Figure 5

- Insert the conductor into crimp well, visually confirm seating through inspection hole on the contact. Then crimp the contact using recommended crimp tool or equivalent as shown in Figure 6 and 7.

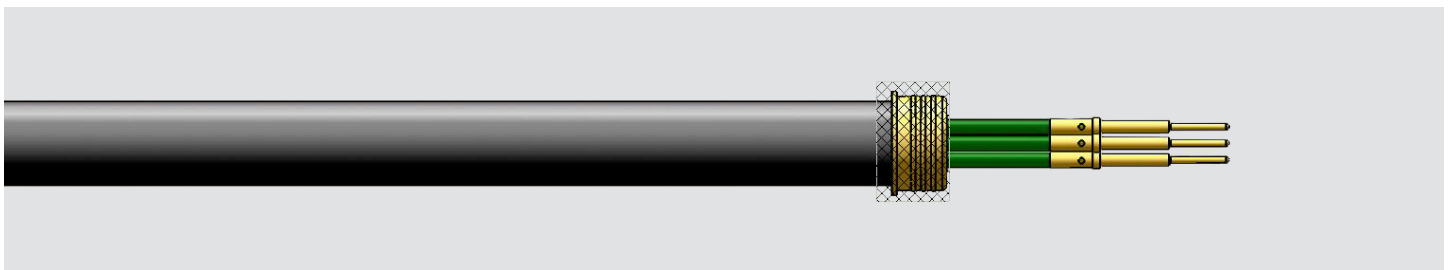


Figure 6

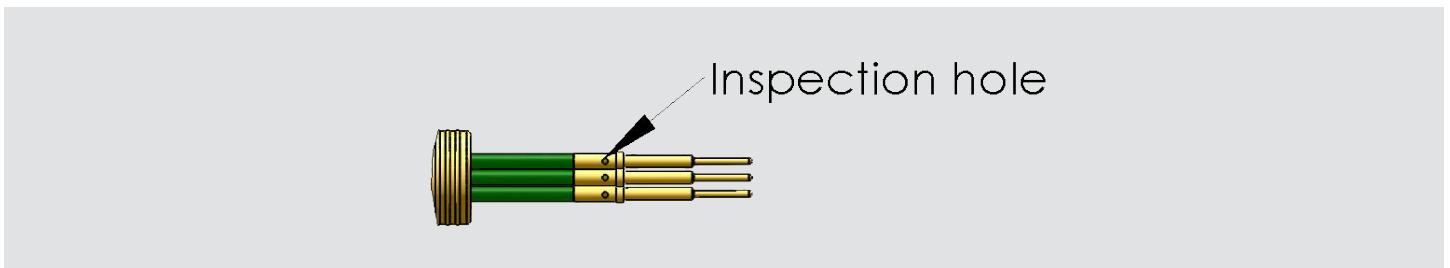


Figure 7

Table 1

Item	Part Number	Inner Contact		Outer Contact Shell	
		Crimp Tool	Locator	Crimp Tool	Locator
1	QX4-20-P-120	M22520/2-01	Daniels	M22520/5-01	Daniels
	QX4-20-S-120				
2	QX4-20-P-100	(-5)	K1625		Y144
	QX4-20-S-100				

5. Insert 4 contacts into the rear insert as shown in Figure 7. The two surfaces of the front rear insert and rear pin shoulder should now be touching as shown in Figure 8.

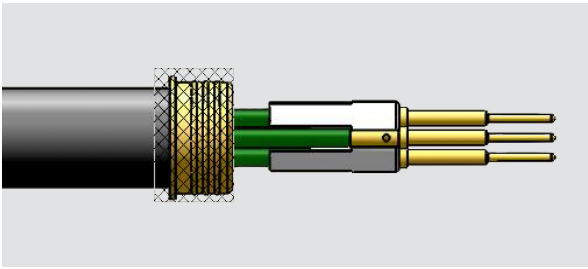


Figure 7

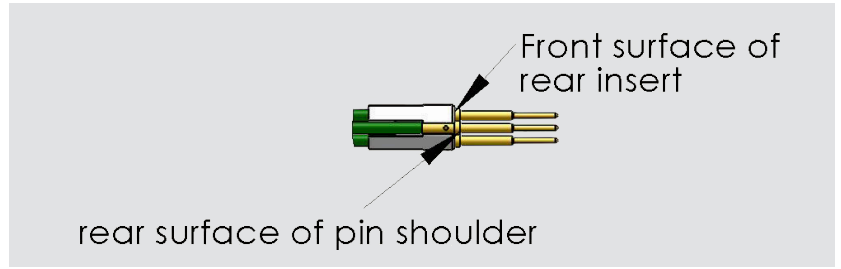


Figure 8

6. Install front insert until it touches the front face of the rear insert. See Figure 9.

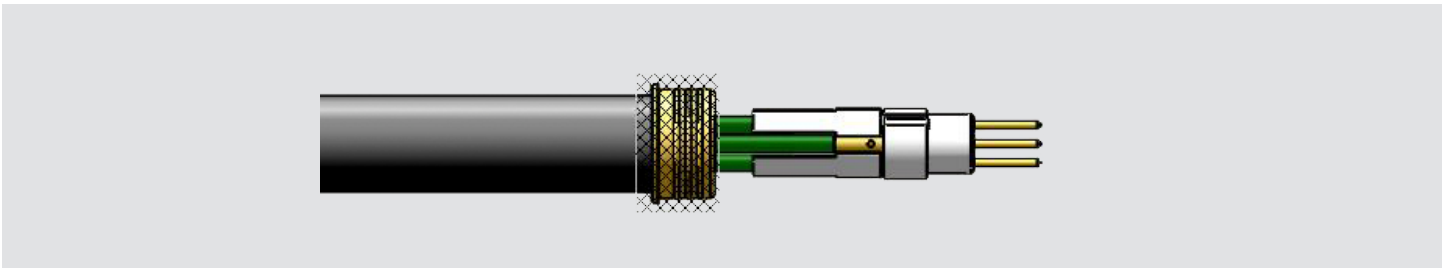


Figure 9

7. Insert the contacts into the shell (Figure 10) and crimp the shell in the 5mm area as shown in Figure 12.  
Note: Align the key to keyway while installing. See Figure 10.

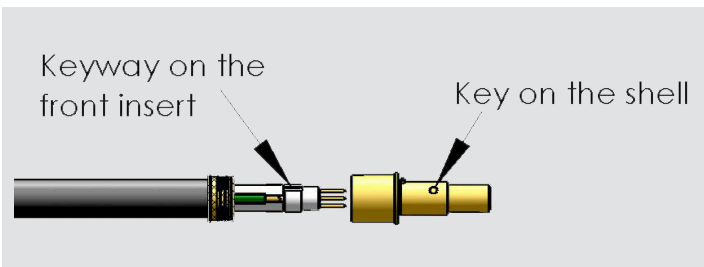


Figure 10

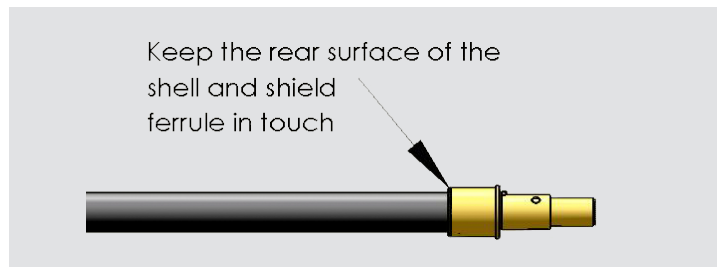


Figure 11

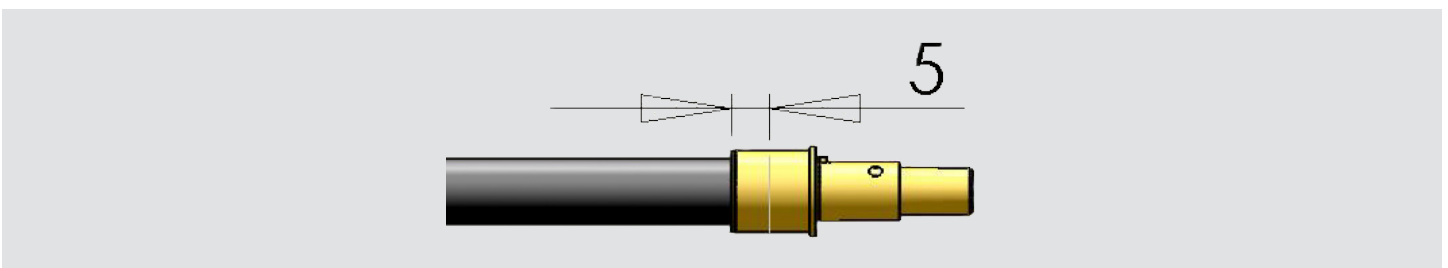


Figure 12

### Step 3: Socket Assembly

The same as pin assembly

**Step 4: Receptacle Assembly**

1. Insert the pin cable assembly into receptacle shell.

Note: Align the key on the pin assembly to keyway on the receptacle shell. See Figure 13 and 14.

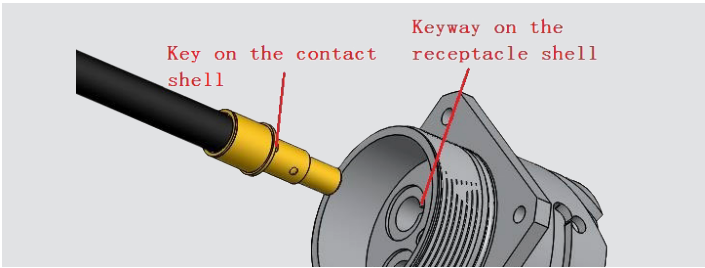


Figure 13

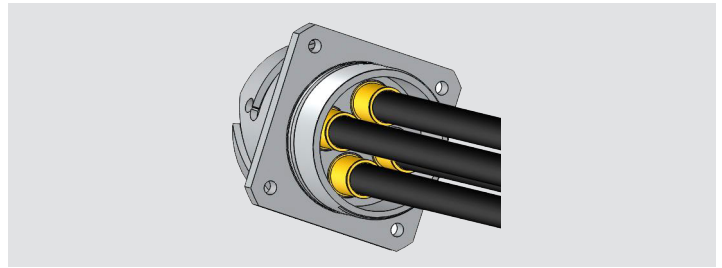


Figure 14

2. Slide the retainer into the receptacle shell and tighten it with screw. Figure 15.

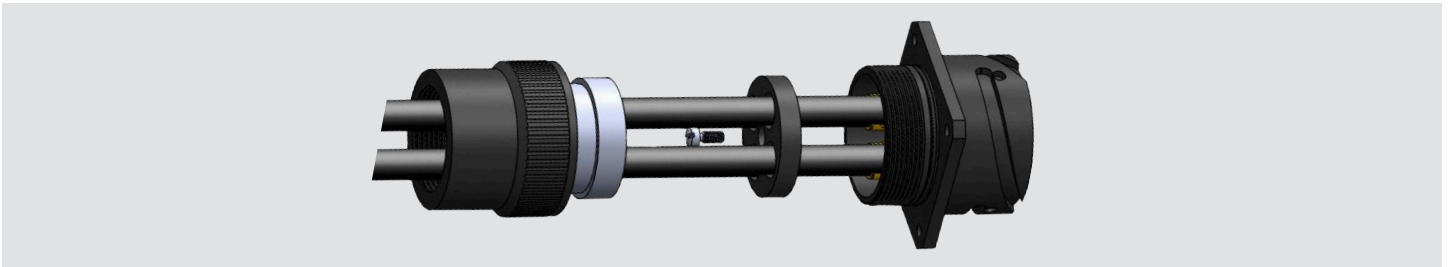


Figure 15

3. Slide the grommet into the receptacle assembly and tighten the adapter (Figure 16) with proper torque as shown in table 2. Then complete as shown in Figure 17.

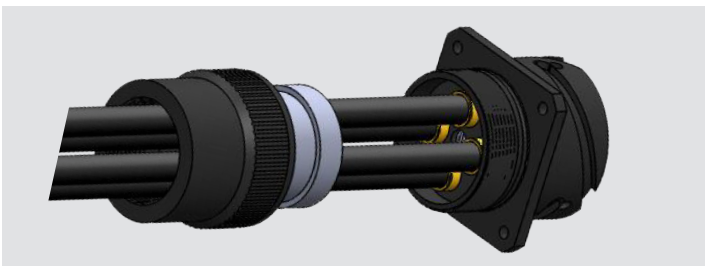


Figure 16



Figure 17

Table 2

Item	Part Number	Adapter torque N.m
1	GTC06AQX28-BLS(025)(M25)(LC)	39.5~42.3
	GTC030AQX28-BLP(025)(M25)(LC)	
2	GTC06AQX36-BVS(025)(M50)(LC)	50.8~53.6
	GTC030AQX36-BVP(025)(M50)(LC)	

**Step 5: Plug Assembly**

The same as receptacle assembly