

CABLE ASSEMBLY WORK INSTRUCTION

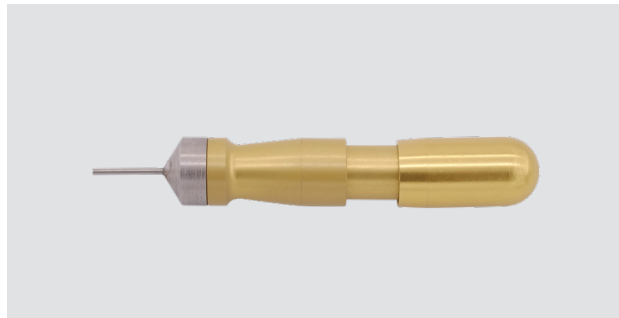
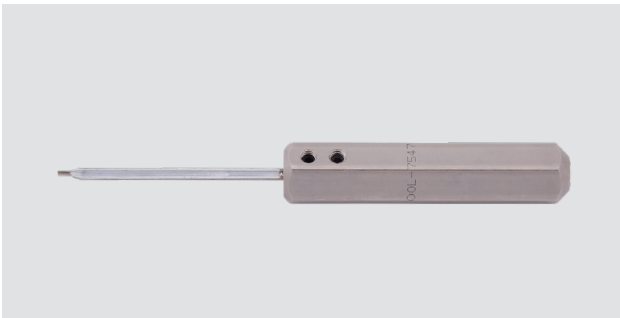
Max-M12



Part 1: Tools



Contact Crimping Tool:
DMC AF8 M22520/1-01



Install Tool:
TOOL-754720-020 for size 20 contact
TOOL-754721-024 for size 24 contact

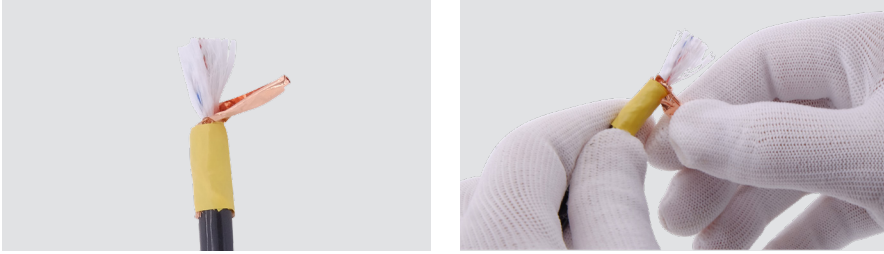
Contact Removal Tool:
TOOL-754593-020 for pin and socket contacts

Part 2: Cable Installation Instructions

Step 1: Strip the cable insulation, length is about 15mm.



Step 4: Tidy up the shielding net. Cut off the shielding net (the cut off length is 4-5mm). Then, use electrical tape to fix the shielding net to the cable. Finally cut the copper foil paper.

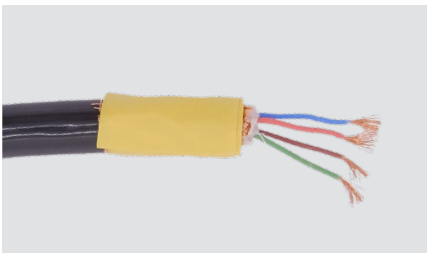


Step 5: Cut off the cable filler, and then cut 4 white wires.



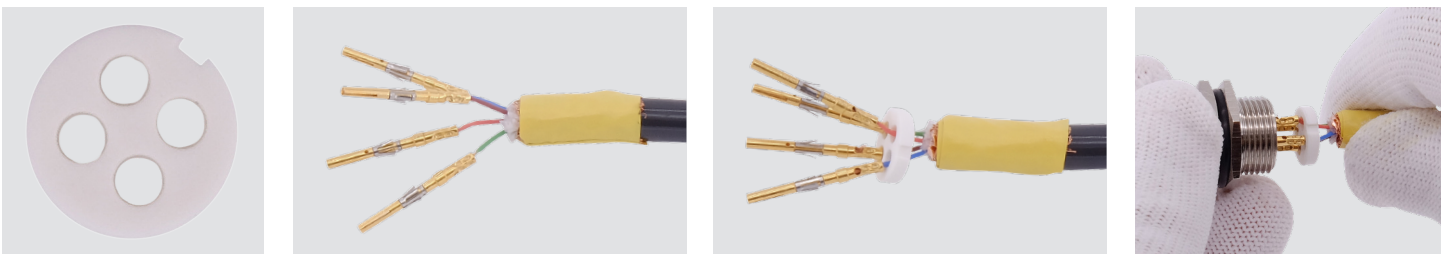
Step 6: Peel off the wire skin with stripper tool, and the length is 4.5mm.

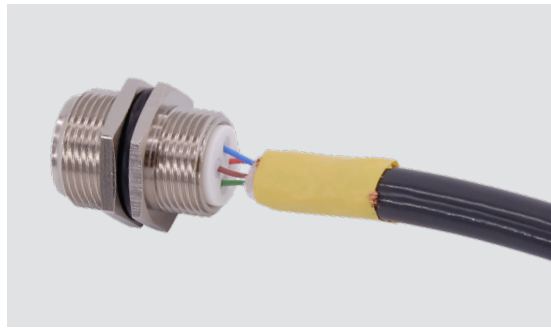
Attention: The shielding net can not touch the copper wire.



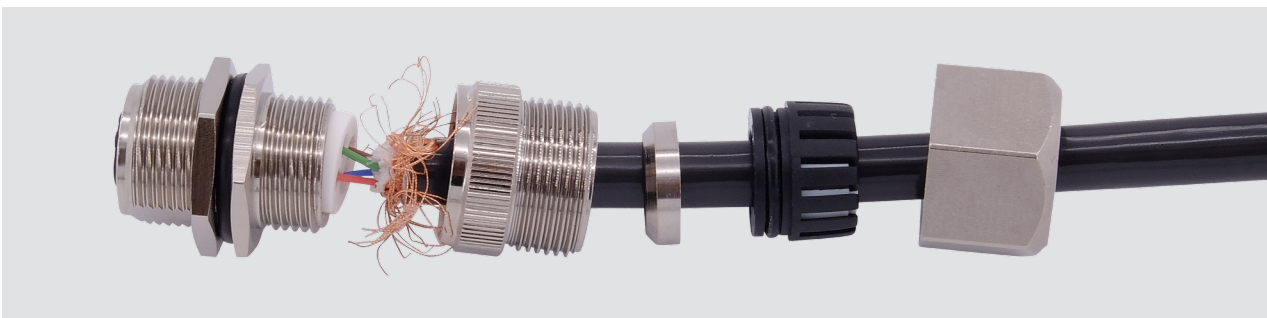
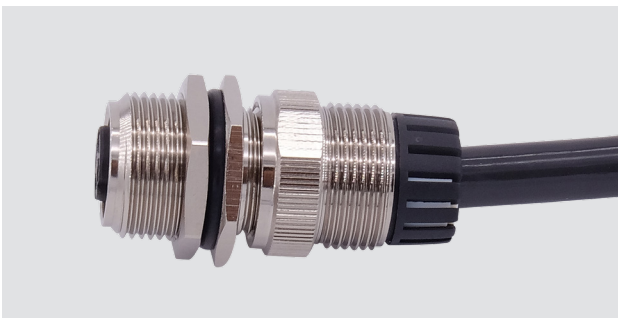
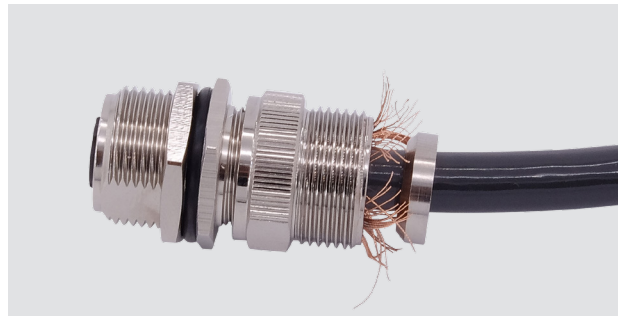
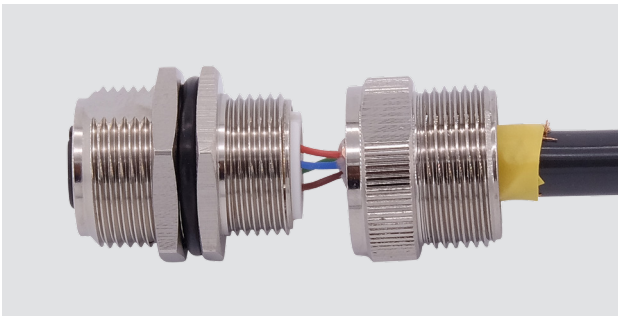
Step 7: Use the crimping tool to crimp the contacts to the wire, and let 4 contacts through the protective cap holes. Then, install the contacts into the connector at the same time, the protective cap should be closed the insert. Use the installing tool (Tool-754720-020 or Tool-754721-020) to help to install the contacts if install is difficult. When the contacts are inserted, the sound of clicking can be heard. The contacts can not pull out when pull the wire.

Attention: Can not insert one at a time.





Step 7: Install the adapter with a torque of 1.5Nm-2.0Nm, then push the EMI RING with shielding net to the adapter, and then install the sealed collet, Finally, install the cap nut to tighten the cable with a torque of 2.0Nm-2.5Nm.



Installation Diagram