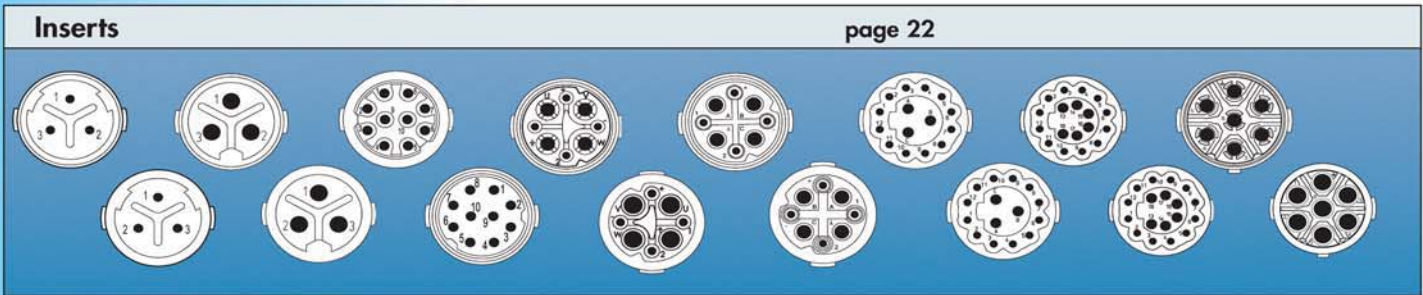
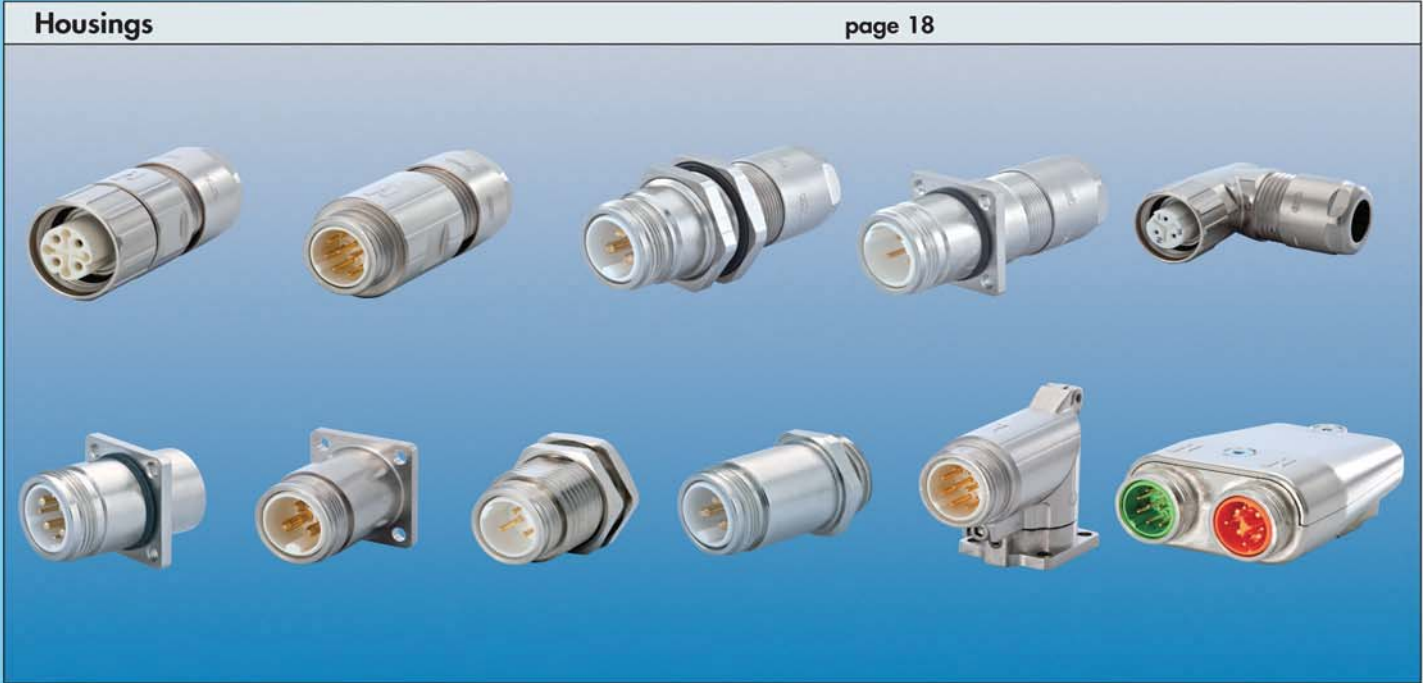


Connectors M 16

TWINTUS
inclusive




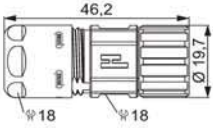



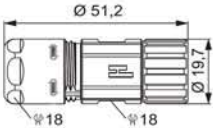
M 16 Control Signal Connectors


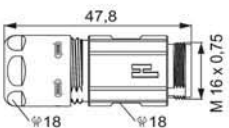
Mechanical Data	Materials and Technical Data
Housing	Copper-Zinc alloy Die Cast
Housing surface	Nickel plated other surface upon request
Inserts (for contacts)	Thermoplastic Polyamid PA 6 (Nylon 6/6), PBT Fire protection class V-0
Contacts	Brass Alloy
Contact surface at point of contact	Nickel and gold 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 60529 (connected), NEMA 4x
Cable diameter range	2 – 11 mm (.08 – .43")


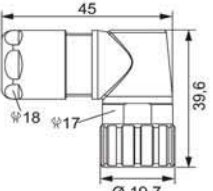
Electrical Data						
Number of positions	3 (3 x 1 mm)	3 (3 x 2 mm)	4 + 3 + PE / 320 V		4 + 3 + PE / 630 V	
Number of contacts	3	3	4	4	4	4
Contact-Ø [mm]	1	2	0,8	1,6	0,8	1,25
AWG [mm ²]	0,14 – 1	0,5 – 2,5	0,08 – 0,34	0,34 – 1,5	0,08 – 0,34	0,34 – 1,5
Nominal current ¹⁾ [A]	8	20	5	16	5	16
Nominal voltage ²⁾ [V~] degree of protection 2 ⁴⁾	630	630	320	630	300	800
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			10	12 + 3		18
Number of contacts			10	12	3	18
Contact-Ø [mm]			1	0,8	1,25	0,8
AWG [mm ²]			0,14 – 0,75	0,08 – 0,34	0,5 – 1,5	0,08 – 0,34
Nominal current ¹⁾ [A]			8	3	10	3
Nominal voltage ²⁾ [V~] degree of protection 2 ⁴⁾			230	60	160	60
Nominal voltage ²⁾ [V~] degree of protection 3 ⁴⁾			160	24	60	24
Test voltage (Breakdown voltage) ³⁾ [V~]			1500	1500	2500	1500
Insulation resistance [MΩ]			> 10 ⁶	> 10 ¹⁰		> 10 ¹⁰
Max. contact resistance [mΩ]			3	3	3	3

^{1), 2), 3), 4)} See Technical Information page 14

Straight Connector, Female Thread		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").....	7.810.5000.00
		Contacts and inserts page 22 • Assembly instructions page 35 / 36	

Straight Connector, Female Thread, elongated		Cable-Ø	Part Number
 		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, 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	
		Assembly tool 7.010.900.125 is required	

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


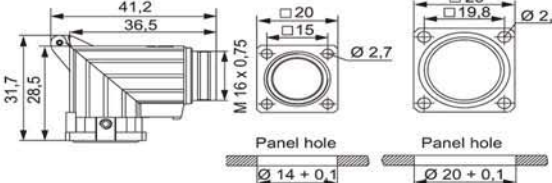
Cable-Ø	Part Number	Panel Connector with built in Cable Strain Relief	
Rear mounting, single hole mounted			
2 – 7 mm (.08 – .28")	7.852.300.000		
5 – 9 mm (.20 – .35")	7.852.400.000		
Including jam nut PG 11			
Contacts and inserts page 22 • Assembly instructions page 35 / 36			


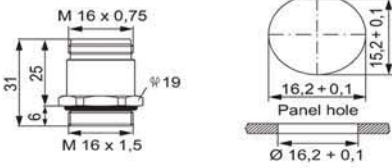
Cable-Ø	Part Number	Panel Connector with built in Cable Strain Relief	
Rear mounting, M 2,5 x 4 single hole mounted			
2 – 7 mm (.08 – .28")	7.847.300.000		
5 – 9 mm (.20 – .35")	7.847.400.000		
Contacts and inserts page 22 • Assembly instructions page 35 / 36			


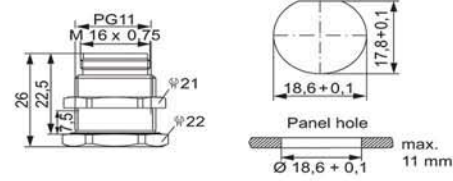
Type	Part Number	Panel Connector, Male Thread, Front Mounting	
4 x holes Ø 2,7 mm (.11")	7.840.000.000		
Flange 20 x 20 mm			
4 x holes Ø 2,7 mm	7.840.100.000		
Flange 25 x 25 mm			
Contacts and inserts page 22 • Assembly instructions page 38			


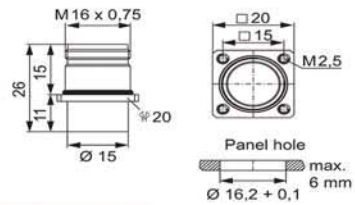
Type	Part Number	Panel Connector, Male Thread, Front Mounting	
Short version			
4 x holes Ø 2,7 mm (.11")	7.840.200.000		
Flange 20 x 20 mm			
Contacts and inserts page 22 • Assembly instructions page 38			

Connectors M 16 / Housing

Right Angle Panel Connector, Male Thread, rotating		Type	Part Number
		300° rotating, locking screw at flange 4 x holes \varnothing 2,7 mm (.11") ..7.843.000.000 Flange 20 x 20 mm	
		4 x holes \varnothing 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 nut.....7.850.000.000	
		Contacts and inserts page 22 • Assembly instructions page 38	

Panel Connector, Male Thread		Type	Part Number
		Rear mounting, 4 x thread M2,5 Flange 20 x 20 mm7.845.000.000	
		Contacts and inserts page 22 • Assembly instructions page 38	

Connectors M 16 / Housing



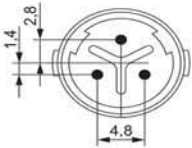
Type	Part Number			TWINTUS
Flange 20 x 20 mm				
Uncoated	7.848.000.000			
Surface nickel plated	7.848.000.001			
Surface black conductive.....	7.848.000.00B			
Contacts and inserts page 22 • Accessories page 29 • Assembly instructions page 33				



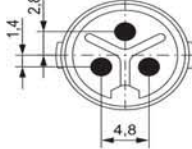
Type	Part Number			TWINTUS
Flange 25 x 25 mm				
Uncoated	7.848.100.000			
Surface nickel plated	7.848.100.001			
Surface black conductive.....	7.848.100.00B			
Contacts and inserts page 22 • Accessories page 29 • Assembly instructions page 33				

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				



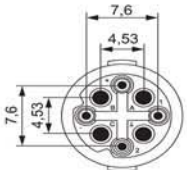
Type	Part Number			TWINTUS M 16 / M 12
Flange 25 x 25 mm				
Uncoated	7.848.300.000			
Surface nickel plated	7.848.300.001			
Surface black conductive.....	7.848.300.00B			
Contacts and inserts page 22 • Accessories page 29 • Assembly instructions page 34				


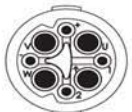
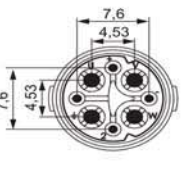
Connectors M 16 / Inserts / Pinouts

Inserts 3-pole (3 x 1 mm)	Type	Part Number	
		Pins	Sockets
 <p>Insert pin mating view</p>	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 Length 17 mm	7.001.903.137	7.001.903.118
 <p>Insert socket mating view</p>	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	
		Pins	Sockets
 <p>Insert pin mating view</p>	Insert 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
 <p>Insert socket mating view</p>	Required Contacts		
	3 x 2 mm	7.010.982.001	7.010.982.002
	Contacts page 27-28		



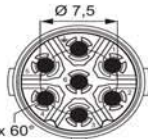
Connectors M 16 / Inserts / Pinouts

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 socket mating view
Insert with dip solder contacts Length 17 mm	7.001.943.137	7.001.943.118	
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			

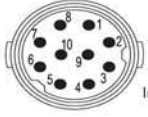

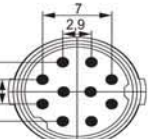
Type	Part Number	Part Number	Inserts 4+3+PE 630V
	Pins	Sockets	
Insert without contacts	7.003.908.101	7.003.908.102	 Insert pin mating view
Insert RAL 2003 (DESINA orange) without contacts	7.053.908.101	7.053.908.102	
Insert with dip solder contacts Length 10 mm ¹⁾	7.001.908.127	7.001.908.108	 Insert socket mating view
Insert with dip solder contacts Length 17 mm ¹⁾	7.001.908.137	7.001.908.118	
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	Part Number
		Pins	Sockets
 <p>Insert pin mating view</p>	Insert		
	without contacts	7.003.961.101	7.003.961.102
	Insert RAL 2003 (DESINA orange)		
 <p>Insert socket mating view</p>	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
 <p>6 x 60</p>	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

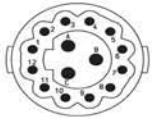
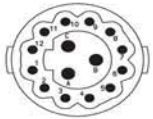
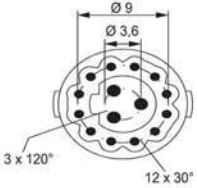
Contacts page 27-28


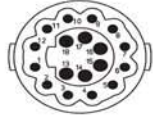
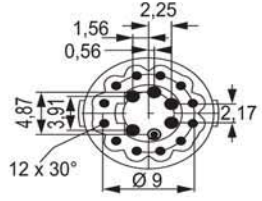
Inserts 10-pole	Type	Part Number	Part Number
		Pins	Sockets
 <p>Insert pin mating view</p>	Insert		
	without contacts	7.003.910.101	7.003.910.102
	Insert RAL 6018 (DESINA green)		
 <p>Insert socket mating view</p>	without contacts	7.053.910.101	7.053.910.102
	Insert with dip solder contacts		
	Length 10 mm	7.001.910.127	7.001.910.108
 <p>7 2.9</p>	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	 <p>Insert pin mating view</p>
Insert with dip solder contacts Length 10 mm	7.001.985.127	7.001.985.108	
Insert with dip solder contacts Length 17 mm	7.001.985.137	7.001.985.118	
Required Contacts			 <p>Insert socket mating view</p>
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	 <p>Insert pin mating view</p>
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	 <p>Insert socket mating view</p>
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
 <p data-bbox="305 667 467 688">insert pin mating view</p>	<p data-bbox="976 554 1274 575">Insert with solder contacts</p>	<p data-bbox="1292 554 1333 575">Pins</p> <p data-bbox="1292 575 1507 596">A712-7001908103</p>









Inserts M 12 for TWINTUS M 16 / M 12 12-pole	Type	Part Number
 <p data-bbox="305 963 467 984">insert pin mating view</p>	<p data-bbox="976 850 1274 871">Insert with solder contacts</p>	<p data-bbox="1292 850 1333 871">Pins</p> <p data-bbox="1292 871 1507 892">A712-7001912103</p>

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	






Please see assembly instructions on page 40

Connectors M 16 / Contacts



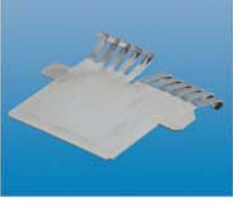

Contacts	Type	Crimp Range	Part Number
	Crimp pin 1,25 mm, machined.....	0,5 – 1,5 mm ² (AWG 20 – 16).....	7.010.981.201
	Crimp socket 1,25 mm, machined.....	0,5 – 1,5 mm ² (AWG 20 – 16).....	7.010.981.202
	Crimp pin 1,25 mm, machined.....	0,34 – 1,5 mm ² (AWG 20 – 16)....	7.010.981.211
	Crimp socket 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 thread7.000.980.161 for connectors with female thread7.000.980.162		
Brass protective cap for connectors with female thread7.010.900.163		
Brass protective cap for connectors with male thread7.010.900.162		
Brass protective cap with chain for connectors with female threadLength 70 mm7.010.9S0.705		
Brass protective cap with chain for connectors with male threadLength 70 mm7.010.9S0.704		

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 for TWINTUS Flange 25 x 25	7.040.848.101 7.040.848.102
	Plastic protective cap for TWINTUS TWINTUS M 16 TWINTUS M 16 / M 12	7.000.848.101 7.000.848.102

Please see assembly instructions on page 34

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)

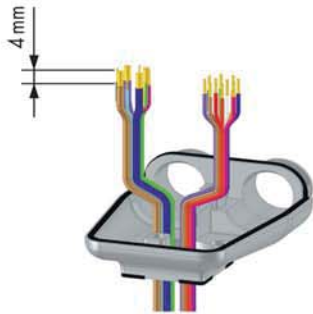
Part Number	Crimp Contact	Cross Section (mm ²)	AWG	Crimp Tool Setting mm	Locator Setting
7.010.901.002	Crimp socket 1 mm (0,34 – 1 mm ²)	0,34	AWG 22	0,77	2
		0,56	AWG 20	0,82	
		0,75	AWG 18	0,88	
		1,0	AWG 17	0,95	
7.010.981.201	Crimp pin 1,25 mm	0,5	AWG 20	0,70	2
		0,75	AWG 18	0,73	
		1,0	AWG 17	0,79	
		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	
7.010.982.002	Crimp socket 2 mm	1,0	AWG 17	1,35	4
		1,5	AWG 16	1,45	
		2,5	AWG 14	1,60	
7.010.982.001	Crimp pin 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

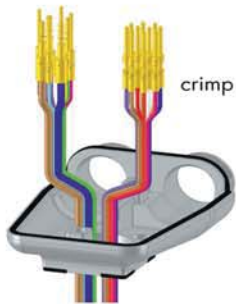
Connectors M 16 / Assembly Instructions

TWINTUS

1.



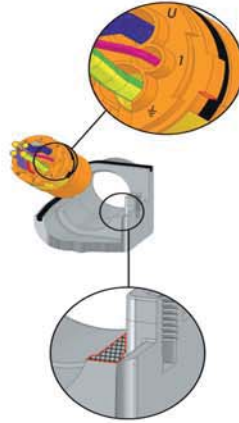
2.



3.



4.



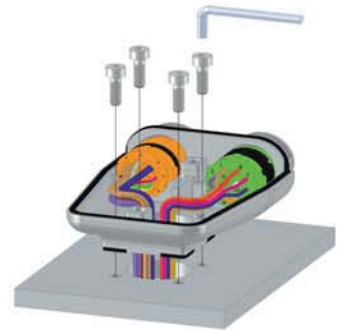
5.



6.



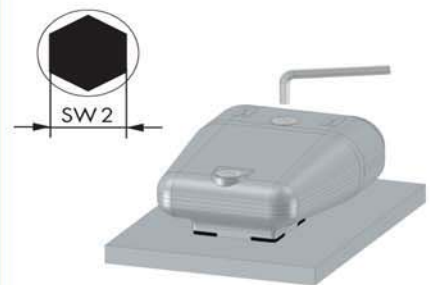
7.



8.



9.



Connectors M 16 / Assembly Instructions

TWINTUS M16 / M12

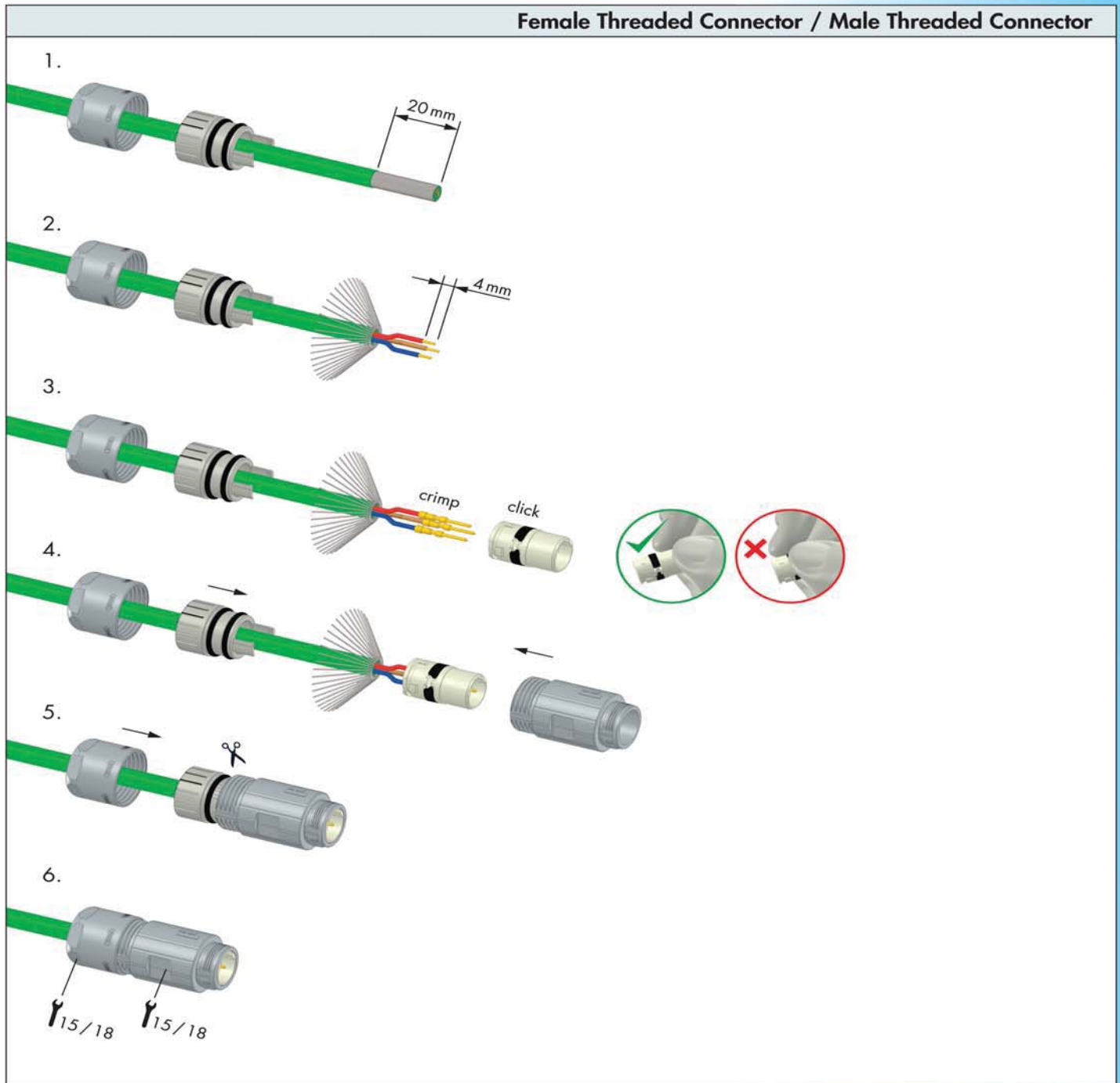
- 4 mm
- crimp
- 4 mm

solder

45°

click
-
-
-
-
-
- SW 2

Connectors M 16 / Assembly Instructions



Connectors M 16 / Assembly Instructions

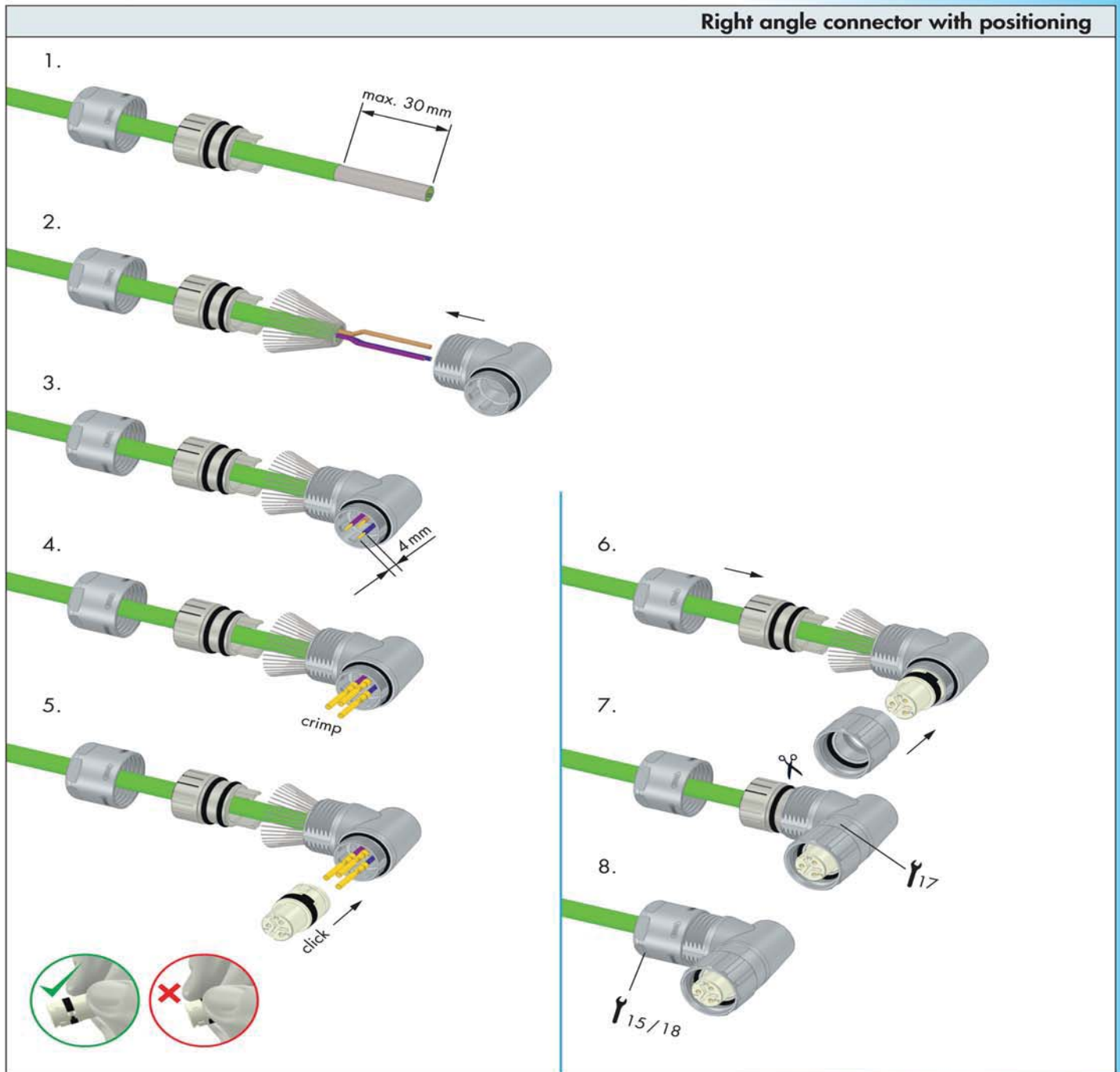
Female Threaded Connector / Male Threaded Connector 12+3

- max. 25 mm
- 4 mm
-
- crimp
- click
-
-
- 15/18 15/18

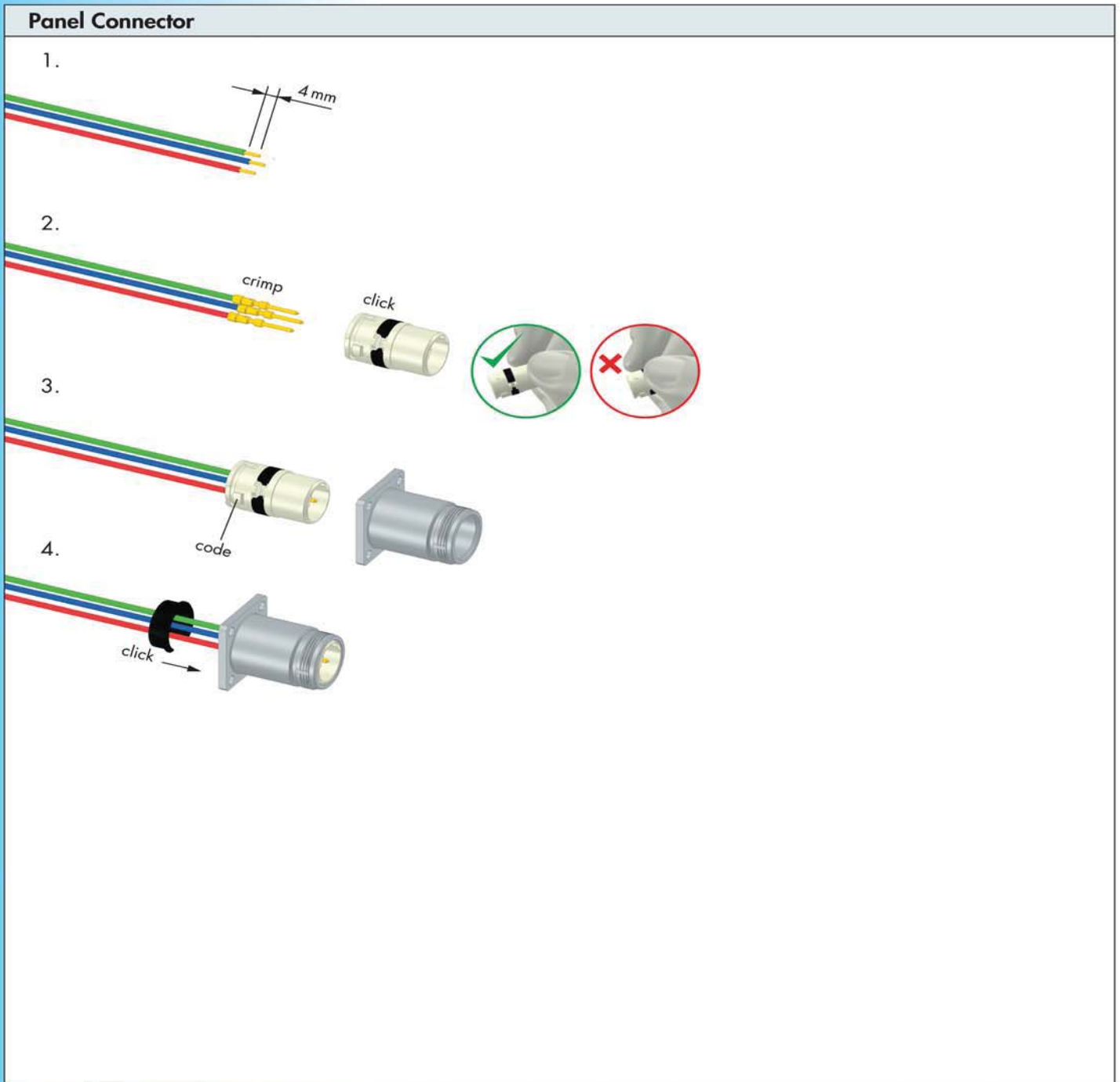
Assembly Details:

- Click:** A circular inset shows a yellow crimp sleeve being inserted into a white connector housing, with the word "click" indicating the correct fit.
- Correct/Incorrect:** Two circular insets show the correct (green checkmark) and incorrect (red X) ways to insert the crimp sleeve into the housing.

Connectors M 16 / Assembly Instructions

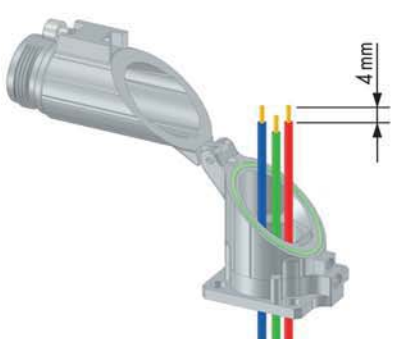
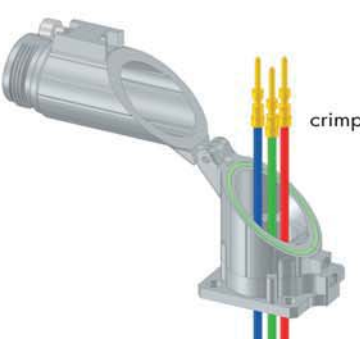
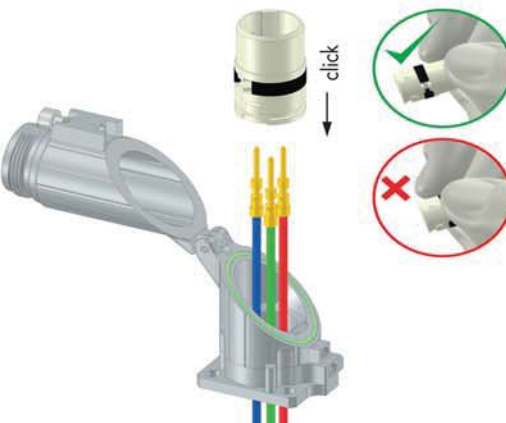
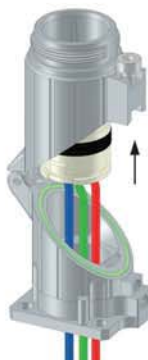
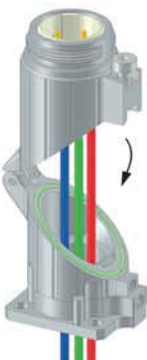

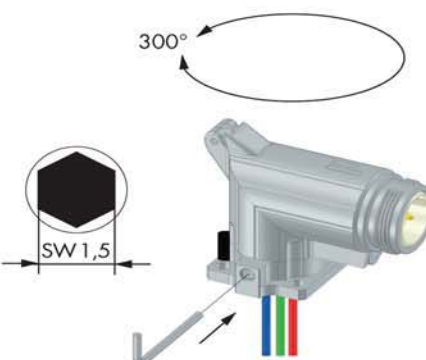


Connectors M 16 / Assembly Instructions



Connectors M 16 / Assembly Instructions

Right Angle Panel Connector

1. 
2. 
3. 
4. 
5. 
6. 
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.

