

## 1. Cable Preparation and Stripping Process

The possible connectable wire gauge sizes are 4.0 mm<sup>2</sup>, 6.0 mm<sup>2</sup> (or AWG12, AWG10).

Use a strip tool to strip cable 7.0±0.5mm (0.27±0.02 inch) and be careful not to nick conductors. See Picture 1.



## 2. Crimping of the contacts

Zerun specified crimp tool should be used in this step.

Insert the contact into the corresponding crimping notch or locator (male or female) taking into account the cable size used. Press the pliers gently together until the crimp s are properly located within the crimping die. Insert the stripped cable end until the insulation comes up against the crimp insert. Completely close the crimping pliers. See Picture 2. See Picture 3 of crimp result.



**When you insert striped cable into contact barrel, always insure all conductor strands are captured in the contact barrel.**

The cable pull-out forces requirement will have to be the following:

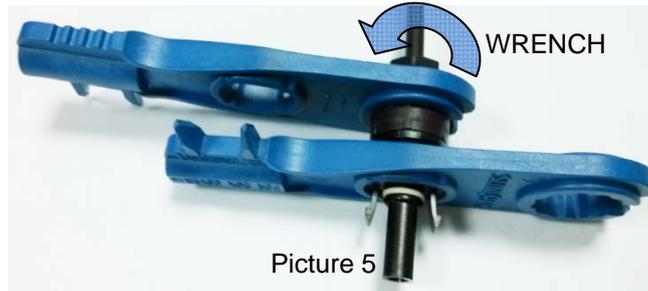
Cable size	Cable pull –out force requirement
4.0 mm <sup>2</sup> (or 12AWG)	Min.320N (~70 Lbs)
6.0 mm <sup>2</sup> (or 10AWG)	Min.360N (~80 Lbs)

## 3. Assembly Process

Insert contact cable assembly into back of male and female connector. A “click” should be heard or felt when the contact cable assembly is seated in correct position. Contacts cannot be removed once seated. See Picture 4.



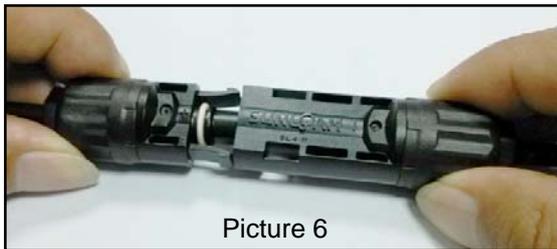
Back cap must be closed using a torque between 2.8 and 3.2Nm. Zerun wrench can be used in this step. See Picture 5.



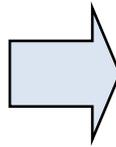
Picture 5

## 4. Connector Mating and Un-mating

For mating align the 2 half connectors and mate them together by hand until a “click” is heard and/or felt. Pulling female and male connector to make sure the connector is firmly engaged. The force is 20N max.

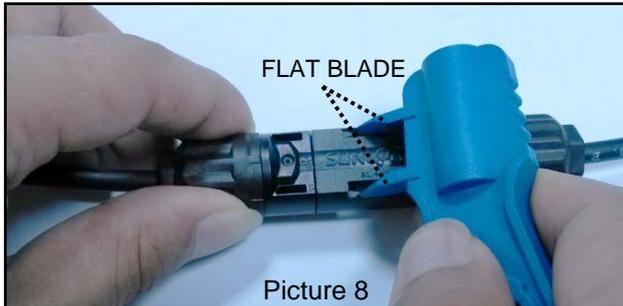


Picture 6

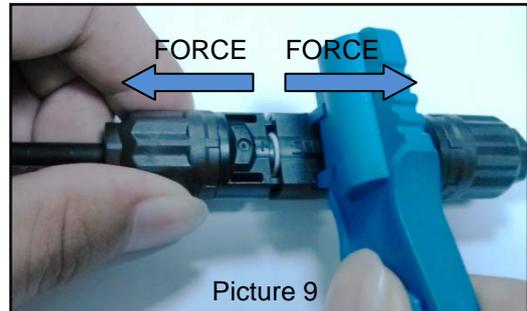


Picture 7

For un-mating, Zerun wrench should be used in this step. Insert the flat blade and then pull out the connector. See Picture 9.



Picture 8



Picture 9



***Do not disconnect the connector while it is under an electrical load. Components within the connector may be electrically charged and capable of inflicting severe injury or death. Extreme caution should be applied when disconnect the connector.***

## 5. Cable Routing

The cable must not be bent or crushed on the direct exiting. A minimum bending radius  $R \geq 5 \times \text{cable diameter}$  must be maintained. The cable must be routed in a way that tensile stress on the conductor or connections is prevented.



Picture 10