**Tools required**

For all versions:
- Wire Cutter
- Stripping Tool
- Soldering Iron
- Flat Spanners according to connector size:
  - 7 mm + 8mm (102 size)  TX00.007 + TX00.008
  - 10 mm + 11mm (103, 1031 size)  TX00.010 + TX00.011
  - 12 mm + 13mm (104 size)  TX00.012 + TX00.013
  - 15 mm + 16mm (105 size)  TX00.015 + TX00.016
  - 18 mm + 19mm (1051 size)  n/a

Additional tools for Crimp Contact versions:
- Crimping Tool  TX00.240
- Positioner (1)

(1) Positioner is specific to contact and connector size. Refer to general catalogue or contact technical support.

---

**1 – Disassemble Connector**

1. **Connector Body (a)**
2. **Contact Block (b)**
3. **Nut (e)**
4. **Ring (d)**
5. **Spacer shells**

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**2 – Strip Cable**

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Contact blocks with solder contacts

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</table>

Contact blocks with crimp contacts

All dimensions in mm.
These values are given for reference. They must be adjusted to each specific cable construction and layout.

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**3 – Terminate Contacts**

1. **Contact Block (b)**
2. **Ring (d)**
3. **Nut (e)**

Solder or crimp

If required, slip heat shrink tube or boot onto cable before starting termination.
4 – Assemble Connector

4A Fit Spacer shells (c) onto Contact Block (b). Make sure cable shield overlaps the spacer.

4B Slip Ring (d) over cable shield. Cable jacket must be pushed close to the spacer. If needed trim excess length of shield.

4C Assemble into Connector Body (a). Tighten nut (e) firmly. Threadlocking adhesive is recommended to secure the nut.

4D Seal and secure the cable by overmolding for optimum performance. Section 5 provides dimensions for mold design.

In case of termination with heat shrink, use only adhesive lined types. Some recommended types are listed in the general catalogue; refer to specialized documentation of heat shrink suppliers for optimum material choice. Section 5 provides connector back-end dimensions.

5 – Back-end Dimensions

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All dimensions in mm

For overmolding it is recommended to use precision diameter «A» for die closing.

Groove «E» will accept retention lips of most common heat shrinks

Note 1: ØC = Cable max outer diameter