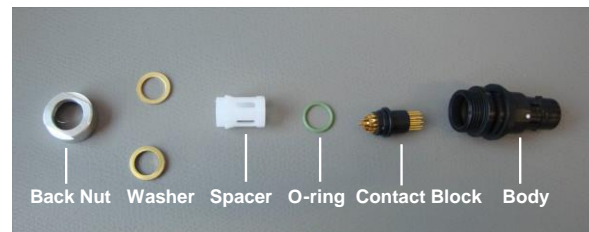


**Pictures show the Ultimate UP01 Size 11.
 Exceptions are indicated in this document.**

Connector parts

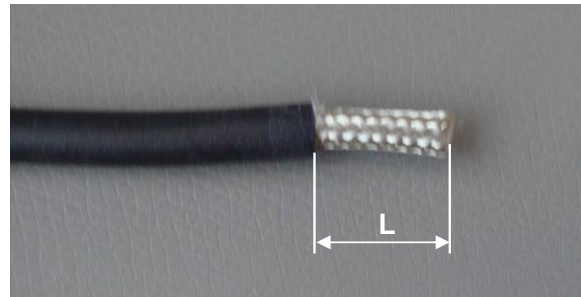


**Slide Back Nut, Washers (2x) and
 the O-ring on to the cable.**



Strip cable jacket to dimension L below:

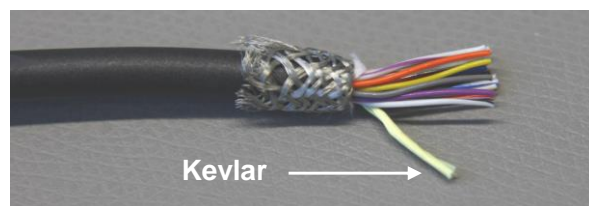
Size	Pin Layout (Number of Contacts)	Termination	L [mm]
08	2 / 3	Solder	12
	4 / 5 / 7 / 9		14
	All	Crimp	18
11	All	Solder	14
	All	Crimp	18
13	2+3	Solder	20
	3+3		22
	27	Crimp	26
18	All	Crimp	28



Pull back the shield over the jacket.



**Trim the paper tape.
 Separate the Kevlar from the conductors.**



**Pull back the Kevlar.
 Secure the shield and the Kevlar with tape.**



Trim back conductors acc. to table below:

Size	Pin Layout (Number of Contacts)	Central [mm]	Intermediate [mm]
08	7	1.5	
	9	1.5	
11	12	2	
	16	3	1.5
	19	3	1.5
13	2+3	1	
	3+3	1	
	27	3	1.5

Strip all conductors to 1.5mm.



SOLDER

CRIMP

**Strip all conductors (L1) and crimp the contacts.
 For stripping length L1, crimp tool, setting and
 positioner, please refer to
 online Crimping Instructions.**



CRIMP

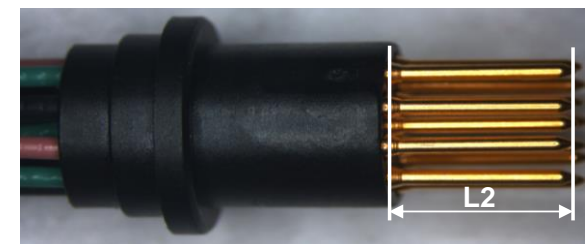
**Insert contacts into the insulator
 with insertion tool.
 Ensure that the contact is in position
 by slightly pulling on the wire.
 For insertion tool please refer to
 online Crimping Instructions.**



CRIMP

Check contact position L2 in insulator:

- Size 08 and 11: L2 = 6.0 mm
- Size 13 and 18: L2 = 5.5 mm



**Without lubricating the O-ring,
 slide it down on to the Contact Block.**

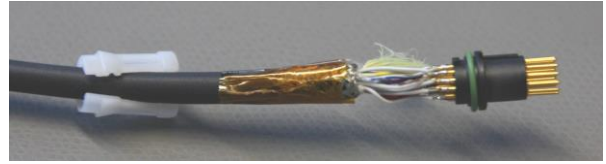
**Warning: DO NOT lubricate the O-ring because
 this will hinder proper adhesion of the potting
 material and prevent sealing.**



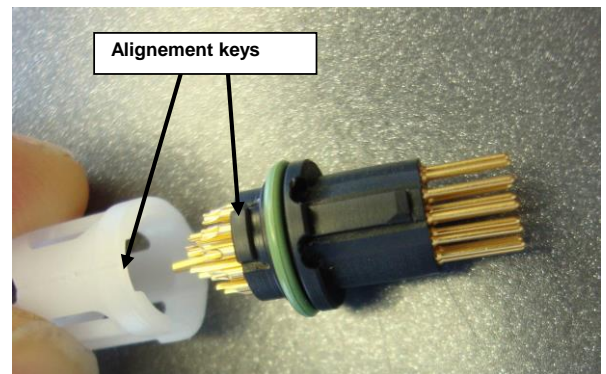
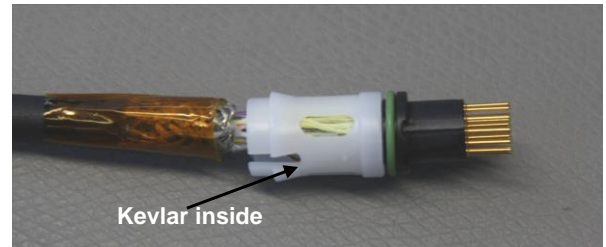
Pull out the Kevlar from the tape.



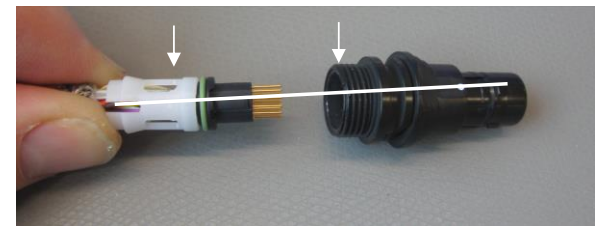
Open the Spacer and place it on to the cable.



**Slide it down onto the Contact Block.
 Ensure that the Spacer mates
 with the key on the Contact Block.**



**Hold the Spacer with the Contact Block and
 align the grooves of the Spacer and of the Body.**



**Insert the Contact Block with the Spacer
 into the Body.
 Push the Spacer until it clips inside the Body.
 Ensure that the Spacer is fully engaged by
 pulling slightly on the cable.**



Install the assembly into your potting fixture.

**Heat up the epoxy:
 Recommended epoxy type: RS 851-044 ⁽¹⁾**



1) Or equivalent.

Slowly dispense potting material into the connector.

The potting material should cover the Spacer but should not reach the level of the Washer support seat.

Allow the potting material to cure according to its specifications.



Slide down one Washer and fit it into the seat of the Body.



Fold the shield evenly over the Washer slightly on the cable.



Trim the excess shield. The shield should completely cover the Washer and not go beyond in the Washer.



Slide down the second Washer.



Pull down the Back Nut and tighten it by hand.



Tighten and secure the Back Nut with the following torques to have an optimal shield continuity. Use a receptacle as counterpart for this operation.

Size	Torque [Nm]	Spanner Sizes [mm]	DO NOT SCREW BEYOND [Nm]
08	2.5	10	3
11	3.0	14	4
13	3.5	17	5
18	6.0	22	8

The use of a "Breaking" Torque Handle is recommended for all sizes.

Install the assembly back into your potting fixture.

Fill up the Back Nut with following recommended epoxy material:

- For straight plug: RS 851-044 ⁽¹⁾
- For angled plug: RT 125 ⁽¹⁾

Put a small amount of epoxy around the cable and let it cure.

1) Or equivalent.

