Assembly Instruction

Connector: WSO 103
with sealed or unsealed cable clamp

Tool Required

<table>
<thead>
<tr>
<th>For all versions:</th>
<th>Fischer Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flat Spanners:</td>
<td>TX00.010 TX00.011</td>
</tr>
<tr>
<td>Wire Cutter</td>
<td></td>
</tr>
<tr>
<td>Stripping Tool</td>
<td></td>
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<tr>
<td>Soldering Iron</td>
<td></td>
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</tbody>
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<table>
<thead>
<tr>
<th>Additional tools for Crimp Contact versions:</th>
<th>Fischer Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Crimping Tool:</td>
<td>TX00.240</td>
</tr>
<tr>
<td>Positioner:</td>
<td>TX00.304 TX00.305</td>
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<tr>
<td></td>
<td>TX00.307 TX00.309</td>
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</tbody>
</table>

1 - Disassemble Connector

1. Connector Body (a)
2. Contact Block (b)
3. Right Angle Body (c)
4. Spacer (d)
5. O-ring (e)
6. Back Nut (f)
7. Ring (g)
8. Seal (h)
9. Cable Clamp (i)
10. Cap Nut (j)

2 - Strip Cable

- A = 20-22 mm (1)
- B = 2 mm (1)
- C = (5 – 1/2 cable Ø) mm (1) (2)

(1) These values are given for reference and must be adjusted to each specific cable construction. It is recommended to strip “B” after step 3.

(2) Or trim shield after step 3 if possible

3 - Assemble Clamp Set

Sealed Clamp Version

- See step 4: with large cables, insert spacer before
- Right Angle Body (c)
- Jacket position for non-shielded cables

Unsealed Clamp Version

- See note (2) in step 2

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4 - Terminate Contacts

- Solder or crimp

- Pull Spacer (d) over Cable and through Right Angle Body (c)

5 - Assemble Connector

5A Fit Spacer (d) onto Contact Block (b), bending wires smoothly and being careful not to damage wires.

**Caution with crimp contacts:**
Crimp contacts need extra space in the insulator, therefore they can move. **Never twist the cable and wires during the cable assembly;** this can apply too much force on the contacts.

5B Insert Block (b) into Connector Body (a).

5C Apply threadlocking adhesive on inner thread of Back Nut (f). Fit O-ring (e) into Back Nut (f) and close connector.

5D Ensure that Right Angle Body (c) is centred in Outer Sleeve of Connector Body (a) (gap on both sides) before tightening Back Nut (f).

5E Tighten Back Nut (f). Torque ≈ 1.3 Nm **Do not squeeze Connector Body in a vice to tighten Back Nut!**

5F Confirm that Outer Sleeve of Connector Body (a) can move freely. If not, it can be released by holding Right Angle Body (c) and turning slightly Back Nut (f) counter-clockwise.

5G After the threadlocking adhesive has cured, check locking mechanism by mating connector with counterpart and pulling on Right Angle Body (c) in unmating direction. The connector should stay mated. Pull on Outer Sleeve of connector. It should unlock and disconnect.