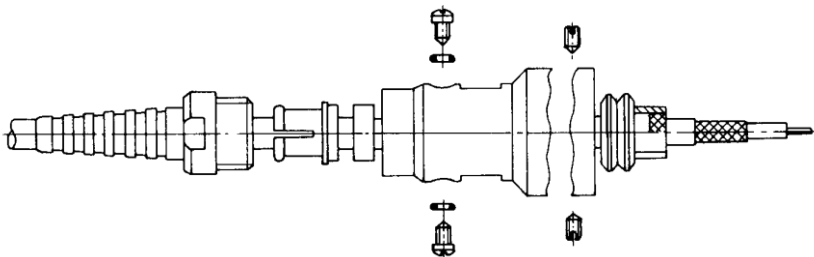
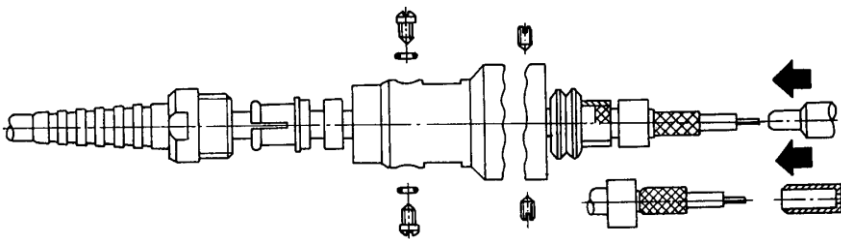


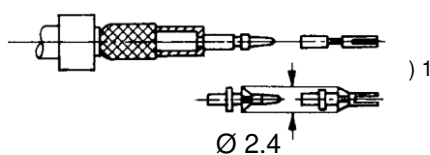
Strip the insulation from the cable as specified in the table.



Slide the cable clamp and fittings over the cable. Place the outer braiding around the tension relief ring, slide over the large clamping sleeve, and crimp using the crimping pliers.

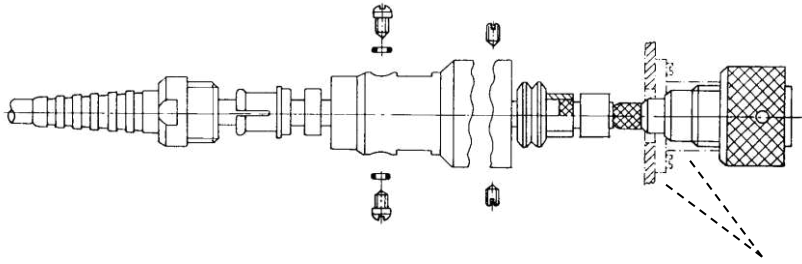


Slide the second clamping sleeve over the cable and use the expanding mandrel to widen the inner braiding. Finally slide the reinforcement sleeve on the dielectric.

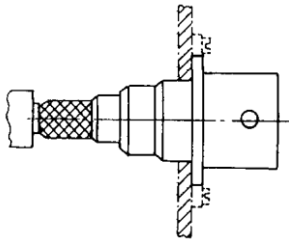


Slide the contact pin or contact socket as far as the reinforcement sleeve on the inner conductor and crimp using the crimping pliers.

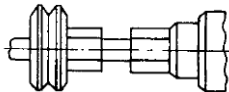
) 1 The release mandrel that has been inserted from the connector side can be used to remove changed contact pins and sockets again after they have been snapped in. If a contact pin or a contact socket has been removed, **check that the spring ring has a diameter of 2.4 before reinserting!** (Expand the spring ring if necessary.)



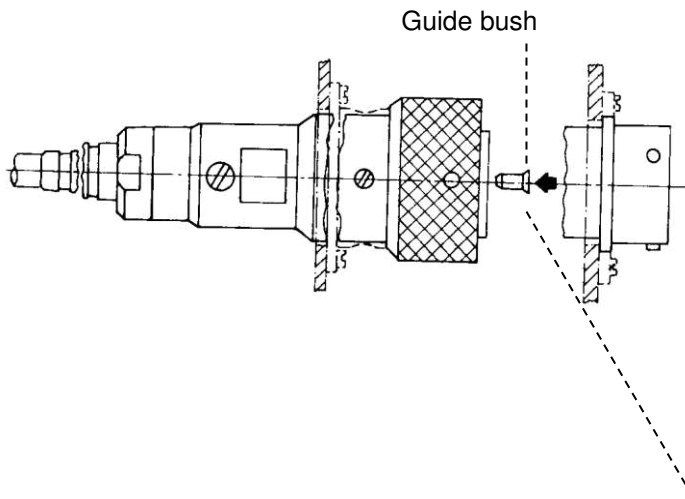
Applies only for panel cable sockets or panel cable plugs.



Insert the cable in the plug or socket connection until the contact pin or contact socket can be felt to engage. Then slide the clamping sleeve over the inner braiding.



Place the plug or socket with the cable in the crimping pliers so that the plug or socket body is positioned at the press-in indentation, then crimp.



Slide forward the outer sleeve, screw tight and fasten using two threaded pins. Use two cheese-head screws to attach the tension relief ring. Finally screw the pressure screw, clamping ring and gasket onto the outer sleeve. Slide the Strain Relief Sleeve on the pressure screw.

Applies only for bushes:
Impress guide bush using mandrel after the assembly has been completed correctly.

Assembly Instruction	a	b	c	d
114	42.0	23.0	13.0	5.0
115	44.5	23.0	13.0	5.0