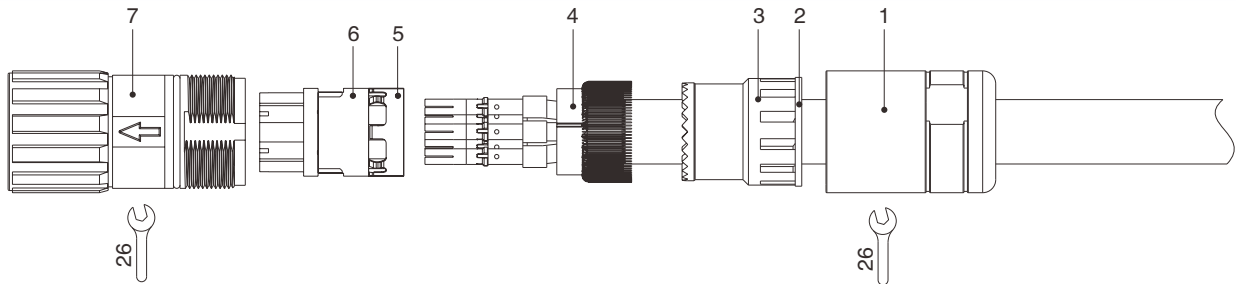


## M23 Power Connectors/Assembly Instructions

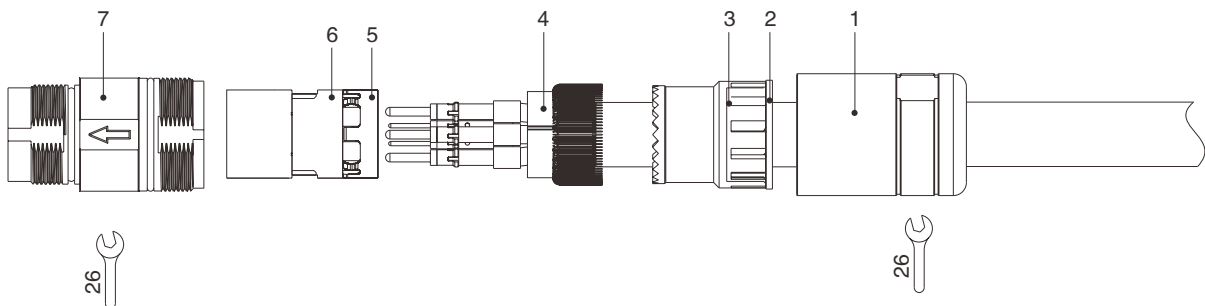
### ■ Straight Connector, Female Thread



#### Assembly instructions :

- Push the adapter 1 and the sealing element 3 with gasket 2 onto the cable;
- Strip the external sheath:30mm;
- Trim and remove the foil, wadding and inner insulation;
- Unbraid the braided screen and push it back;
- Strip the conductors insulation:9.0mm;
- Crimp the conductors to the contacts;
- Insert the contacts into contact carrier 6;
- Snap-fit earth spring 5 onto the contact carrier 6
- Open the spacer sleeve 4, fit it before the braided screen and clip them together;
- Guide the contact carrier 6 and the space sleeve 4 into the insert sleeve 7;
- Push up the braided screen and slide the sealing element 3 with the braided screen firmly against the space sleeve 4 until the teeth lock;
- Cut the shielding to length if necessary and twist the remaining shielding into the space provided 3;
- Screw the adapter 1 as tight as possible.

### ■ Straight Connector, Male Thread



#### Assembly instructions

- Push the adapter 1 and the sealing element 3 with gasket 2 onto the cable;
- Strip the external sheath:30mm;
- Trim and remove the foil, wadding and inner insulation;
- Unbraid the braided screen and push it back;
- Strip the conductors insulation:9.0mm;
- Crimp the conductors to the contacts;
- Insert the contacts into contact carrier 6;
- Snap-fit earth spring 5 onto the contact carrier 6
- Open the spacer sleeve 4, fit it before the braided screen and clip them together;
- Guide the contact carrier 6 and the space sleeve 4 into the insert sleeve 7;
- Push up the braided screen and slide the sealing element 3 with the braided screen firmly against the space sleeve 4 until the teeth lock;
- Cut the shielding to length if necessary and twist the remaining shielding into the space provided 3;
- Screw the adapter 1 as tight as possible.