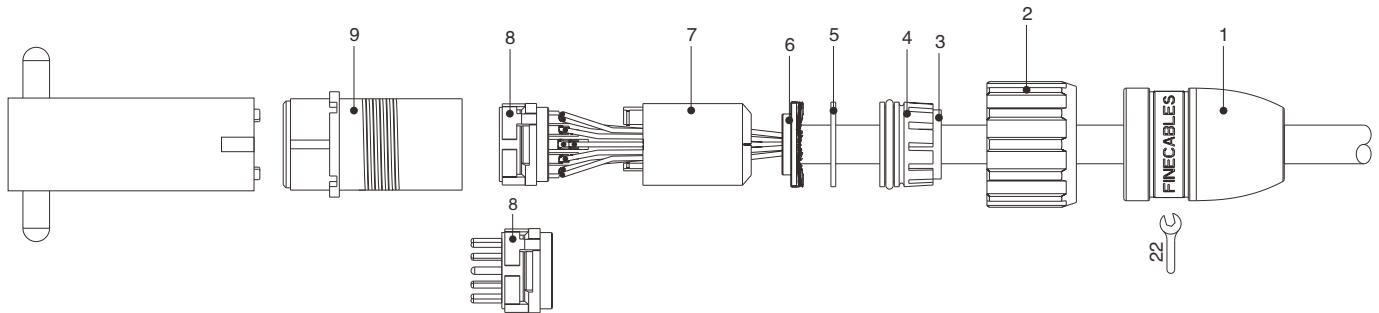


M23 Signal Connectors/Assembly Instructions

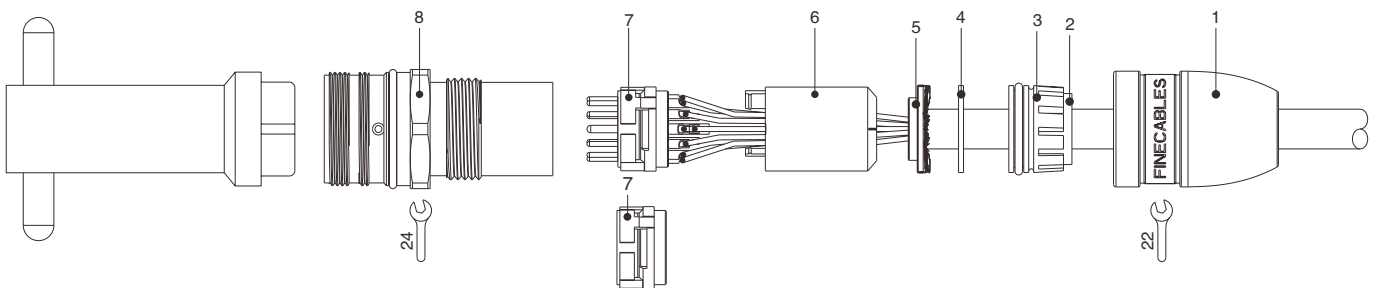
■ Straight Connector, Female Thread



Assembly instructions :

- Push the adapter 1 nut 2 and the sealing element 4 with gasket 3 and metallic gasket 5 over the cable sheath;
- Strip the external sheath to a length of 24mm;
- Push back the shielding screen such that it stands out at 90° and cut it flush with the outer diameter of the shield disc 6;
- Strip the wires to a length of 2.5mm, twist and tin plate;
- Solder the wires to the contacts;
- Insert the spacer sleeve 7;
- Guide the insert 8 and spacer sleeve 7 into the insert sleeve 9;
- Press in the cable with the shield and sealing unit;
- 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 and metallic gasket 4 over the cable sheath;
- Strip the external sheath to a length of 24mm;
- Push back the shielding screen such that it stands out at 90° and cut it flush with the outer diameter of the shield disc 5;
- Strip the wires to a length of 2.5mm, twist and tin plate;
- Solder the wires to the contacts;
- Insert the spacer sleeve 6;
- Guide the insert 7 and spacer sleeve 6 into the insert sleeve 8;
- Press in the cable with the shield and sealing unit;
- Screw the adapter 1 as tight as possible;