
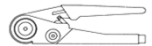

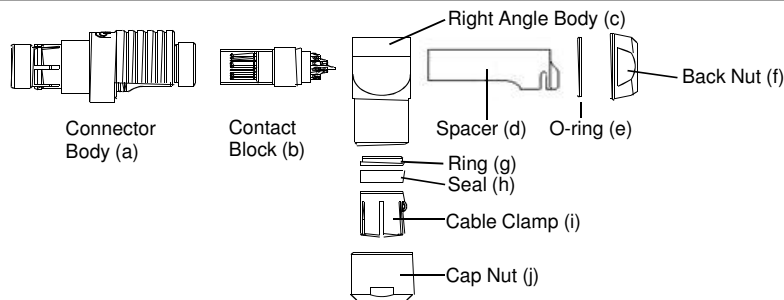


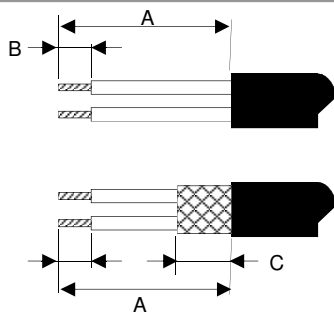
### Tool Required

For all versions:	Fischer Part Number	Additional tools for Crimp Contact versions:	Fischer Part Number
<ul style="list-style-type: none"> <li>Flat Spanners:               <ul style="list-style-type: none"> <li>7 mm</li> <li>8 mm</li> </ul> </li> <li>Wire Cutter</li> <li>Stripping Tool</li> <li>Soldering Iron</li> </ul>	TX00.007 TX00.008 	<ul style="list-style-type: none"> <li>Crimping Tool for:               <ul style="list-style-type: none"> <li>0.5 to 1.3mm contacts</li> </ul> </li> <li>Positioner for:               <ul style="list-style-type: none"> <li>0.5mm male contacts</li> <li>0.5mm female contacts</li> <li>0.7mm male contacts</li> <li>0.7mm female contacts</li> </ul> </li> </ul>	TX00.240   TX00.300 TX00.302 TX00.304 TX00.305 

### 1 - Disassemble Connector



### 2 - Strip Cable

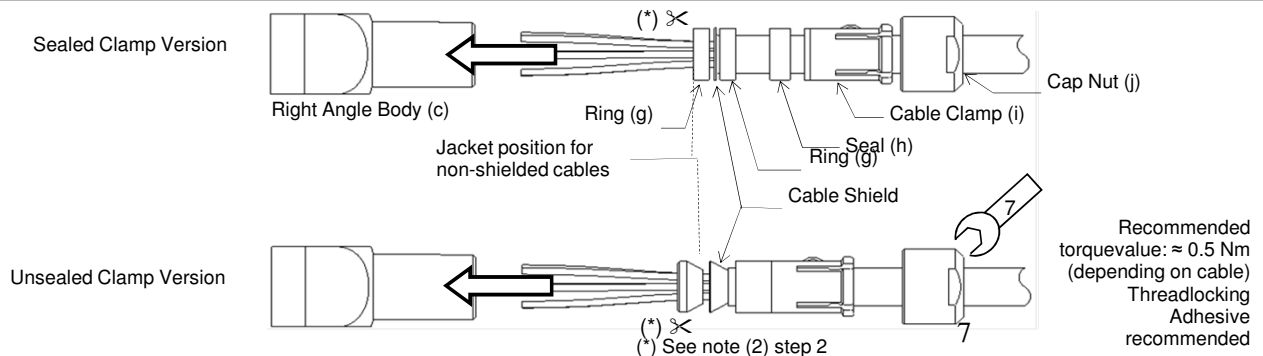


A ≈ 18-20 mm <sup>(1)</sup>  
 B ≈ 2 mm <sup>(1)</sup>  
 C ≈ (4 - 1/2 Ø) mm <sup>(1) (2)</sup>

<sup>(1)</sup> These values are given for reference and must be adjusted to each specific cable construction. It is recommended to strip "B" after step 3.

<sup>(2)</sup> Or trim shield after step 3 if possible

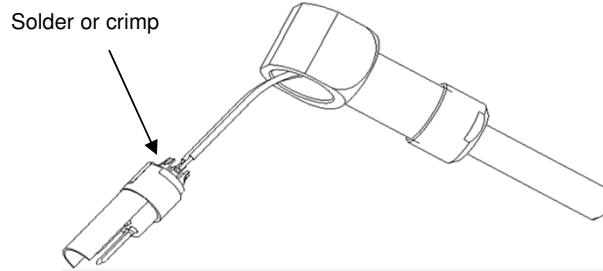
### 3 - Assemble Clamp Set



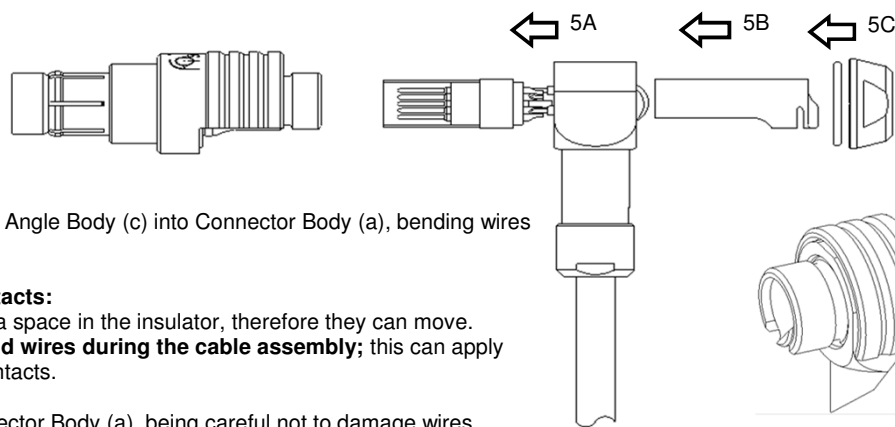
Recommended torque value: ≈ 0.5 Nm (depending on cable)  
 Threadlocking Adhesive recommended

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### 4 - Terminate Contacts



### 5 - Assemble Connector



5A Insert Block (b) and Right Angle Body (c) into Connector Body (a), bending wires smoothly.

**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 Slip Spacer (d) into Connector Body (a), being careful not to damage wires.

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  $\approx 1.0$  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.

5B Correct fit of Spacer (d)

