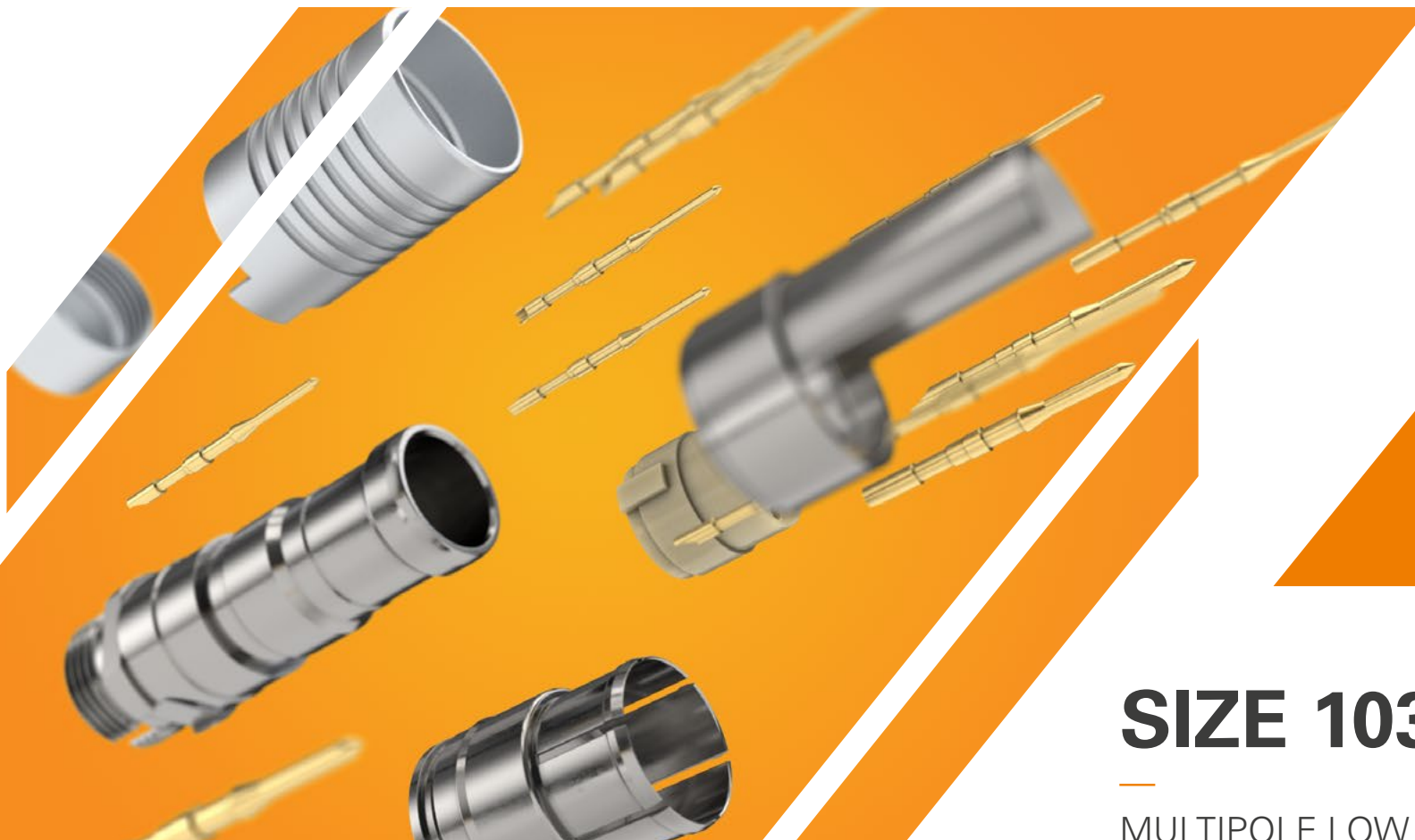




FISCHER CORE SERIES

CABLE ASSEMBLY INSTRUCTIONS

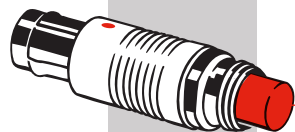


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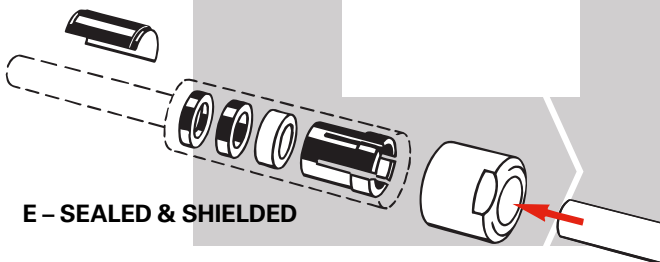
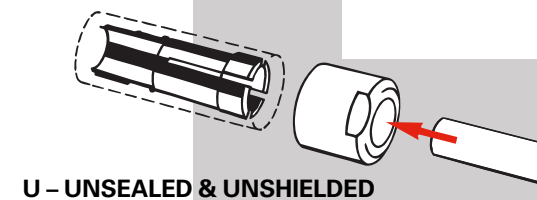
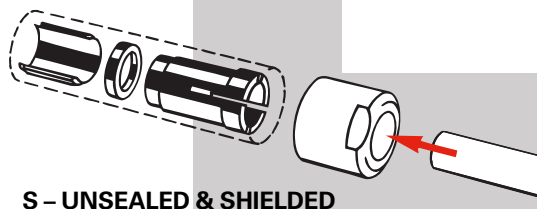
MULTIPOLE LOW VOLTAGE

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- 1 Remove shipping retainer and contact block



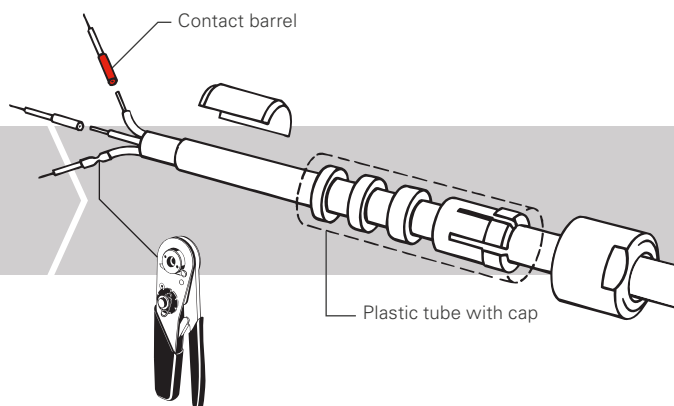
- 2 Slide piece parts over cable (possibly with parts in plastic tube)



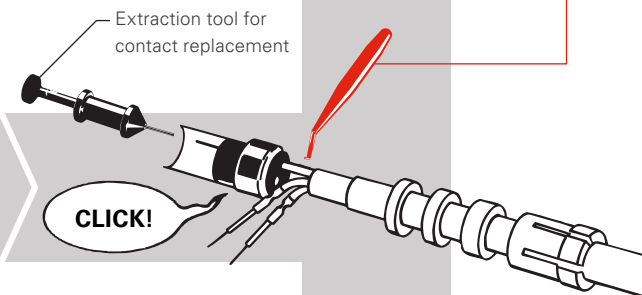
CRIMP CONTACTS

- 3 Strip cable and wires*

- 4 Fit wire into contact barrel and crimp*



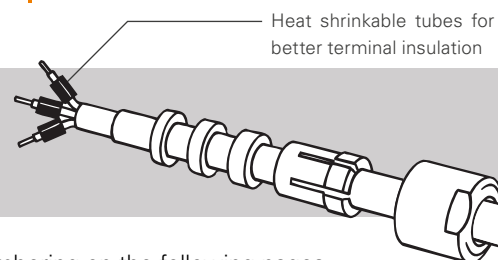
- 5 Insert contacts into insulator and push them home with insertion tool*



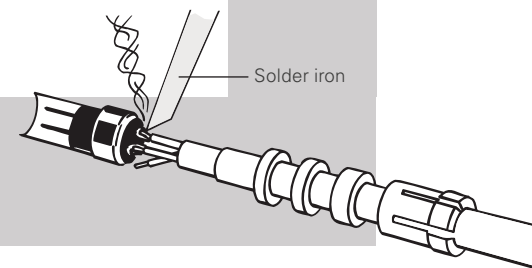
SOLDER CONTACTS

- 3' Strip cable and wires*

- 4' Tin strands (recommended)

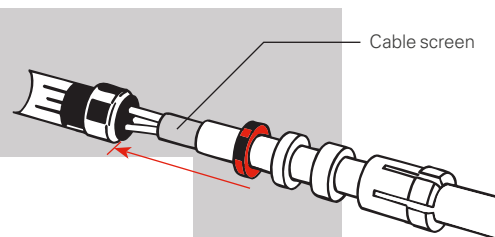


- 5' Solder each wire to the corresponding contact*, then pull heat shrinkable tubes over the contact terminals and shrink

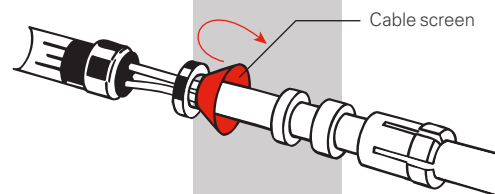


*For ideal cable and wire preparation, see the specific tools and contact numbering on the following pages.

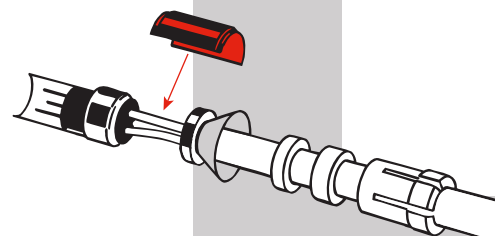
- 6** | Slide **ring** towards front end



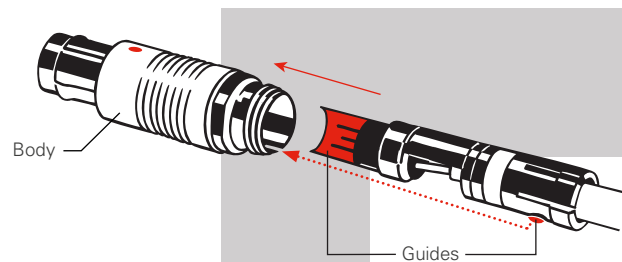
- 7** | Bend **cable screen** outwards



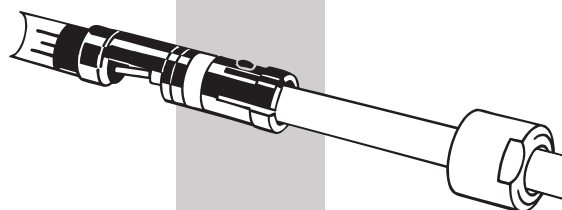
- 8** | Insert **half shell** and retain with the ring



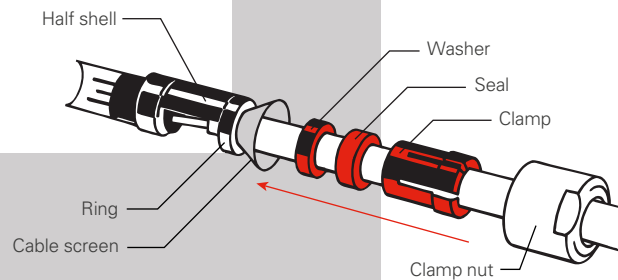
- 11** | Push cable assembly into the body, orienting the **guides** to the slots



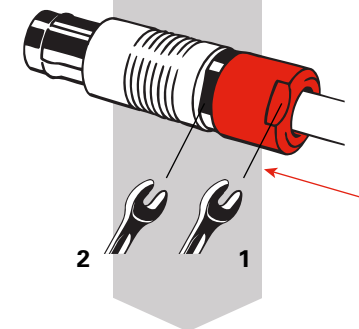
- 10** | Trim protruding screen strands



- 9** | Slide **washer, seal and clamp** against the ring and retain screen between ring and washer



- 12** | Screw **clamp nut** to body and tighten with wrenches*





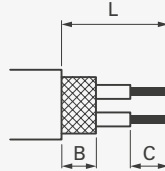


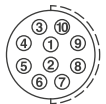

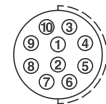
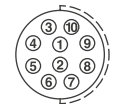






The assembly is now complete.

*For ideal cable and wire preparation, see the specific tools and contact numbering on the following pages.

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MULTIPOLE LOW VOLTAGE CABLE ASSEMBLY INSTRUCTIONS

Type					Cable clamp ¹⁾	Contact termination	Number of contacts						Crimping tool part number	Positioner part number	Insertion tool part number	Extraction tool part number	Wrench size  1	Wrench size  2	Torque [Nm]
	Plug	Receptacle	Plug	Receptacle															
	Type "A"		Type "Z"						L	B	C								
1031 ^A / _Z 010					S	Solder	10	8	11	2	2					11	12	1.5	
					2			9.5	2	2					11	12	1.5		
					10		8	11	–	2					11	12	1.5		
							2	9.5	–	2					11	12	1.5		
					10		8	9	2	2					11	12	1.5		
							2	7.5	2	2					11	12	1.5		
					S	Crimp	10	16	2	3	TX00.240	²⁾	TX00.210	TX00.200	11	12	1.5		
					U		10	16	–	3	TX00.240	²⁾	TX00.210	TX00.200	11	12	1.5		
					E		10	14	2	3	TX00.240	²⁾	TX00.210	TX00.200	11	12	1.5		
1031 ^A / _Z 012					S	Solder	12	9	11	2	2					11	12	1.5	
					3			9.5	2	2					11	12	1.5		
					12		9	11	–	2					11	12	1.5		
							3	9.5	–	2					11	12	1.5		
					12		9	11	2	2					11	12	1.5		
							3	7.5	2	2					11	12	1.5		
					S	Crimp	12	16	2	3	TX00.240	²⁾	TX00.210	TX00.200	11	12	1.5		
					U		12	16	–	3	TX00.240	²⁾	TX00.210	TX00.200	11	12	1.5		
					E		12	14	2	3	TX00.240	²⁾	TX00.210	TX00.200	11	12	1.5		

¹⁾ S - Shielded cable clamp
U - Unshielded cable clamp
E - Sealed cable clamp





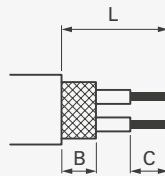


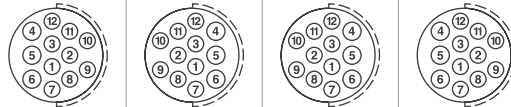

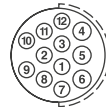
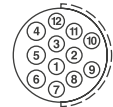
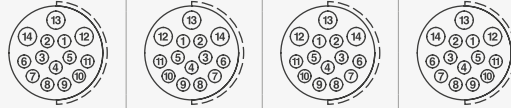



²⁾ See Online Crimping Instructions

All specifications are typical and have to be adjusted according to the cable construction and dimensions. Torque values [Nm] are recommended values that may be influenced by the characteristics of the cable jacket. Tests have to be made to evaluate the exact values. To secure the cable clamp nut, we recommend the use of thread locking adhesive.

All dimensions are in millimeters and are for reference only.

SIZE 1031

MULTIPOLE LOW VOLTAGE CABLE ASSEMBLY INSTRUCTIONS

Type					Cable clamp ¹⁾	Contact termination	Number of contacts			Crimping tool part number	Positioner part number	Insertion tool part number	Extraction tool part number	Wrench size  1	Wrench size  2	Torque [Nm]		
	Plug	Receptacle	Plug	Receptacle					L								B	C
	Type "A"		Type "Z"															
1031 ^A / _Z 029					S	Solder	12	3 ²⁾	9.5	2	2					11	12	1.5
								3 ³⁾	11	2	2					11	12	1.5
								6	11	2	2					11	12	1.5
					U		12	3 ²⁾	9.5	–	2					11	12	1.5
								3 ³⁾	11	–	2					11	12	1.5
								6	11	–	2					11	12	1.5
					E		12	3 ²⁾	7.5	2	2					11	12	1.5
								3 ³⁾	9	2	2					11	12	1.5
								6	9	2	2					11	12	1.5
1031 ^A / _Z 105					S	Solder	14	4 ⁴⁾	9.5	2	2					11	12	1.5
								1 ⁵⁾	10.5	2	2					11	12	1.5
								3 ⁶⁾	12	2	2					11	12	1.5
								6 ⁷⁾	11.5	2	2					11	12	1.5
					U		14	4 ⁴⁾	9.5	–	2					11	12	1.5
								1 ⁵⁾	10.5	–	2					11	12	1.5
								3 ⁶⁾	12	–	2					11	12	1.5
								6 ⁷⁾	11.5	–	2					11	12	1.5
					E		14	4 ⁴⁾	7.5	2	2					11	12	1.5
								1 ⁵⁾	8.5	2	2					11	12	1.5
								3 ⁶⁾	10	2	2					11	12	1.5
								6 ⁷⁾	9.5	2	2					11	12	1.5

¹⁾ S - Shielded cable clamp
U - Unshielded cable clamp
E - Sealed cable clamp

²⁾ Pin number: 1 to 3
³⁾ Pin number: 4 to 6





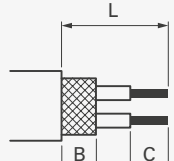


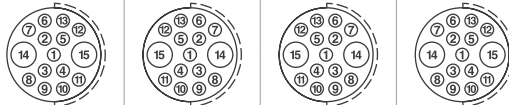
⁴⁾ Pin number: 2 to 5
⁵⁾ Pin number: 1
⁶⁾ Pin number: 12 to 14
⁷⁾ Pin number: 6 to 11

All specifications are typical and have to be adjusted according to the cable construction and dimensions. Torque values [Nm] are recommended values that may be influenced by the characteristics of the cable jacket. Tests have to be made to evaluate the exact values. To secure the cable clamp nut, we recommend the use of thread locking adhesive.

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SIZE 1031

MULTIPOLE LOW VOLTAGE CABLE ASSEMBLY INSTRUCTIONS

Type					Cable clamp ¹⁾	Contact termination	Number of contacts			Crimping tool part number	Positioner part number	Insertion tool part number	Extraction tool part number	 1 Wrench size	 2 Wrench size	Torque [Nm]		
	Plug	Receptacle	Plug	Receptacle					L								B	C
	Type "A"		Type "Z"															
1031 ^A ^Z 015					S	Solder	15	2	11.5	2	2.5					11	12	1.5
								1	8.5	2	2					11	12	1.5
								4	10	2	2					11	12	1.5
								8	12	2	2					11	12	1.5
					U		15	2	11.5	–	2.5					11	12	1.5
								1	8.5	–	2					11	12	1.5
								4	10	–	2					11	12	1.5
								8	12	–	2					11	12	1.5
					E		15	2	9.5	2	2.5					11	12	1.5
								1	6.5	2	2					11	12	1.5
								4	8	2	2					11	12	1.5
								8	10	2	2					11	12	1.5

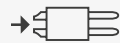


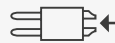
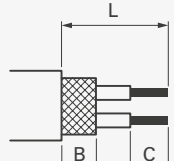






¹⁾ S - Shielded cable clamp
U - Unshielded cable clamp
E - Sealed cable clamp

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SIZE 1031

MULTIPOLE LOW VOLTAGE CABLE ASSEMBLY INSTRUCTIONS

Type					Cable clamp ¹⁾	Contact Termination	Number of contacts					Crimping tool part number	Positioner part number	Insertion tool part number	Extraction tool part number	 Wrench size 1	 Wrench size 2	Torque [Nm]
	Plug	Receptacle	Plug	Receptacle					L	B	C							
	Type "A"		Type "Z"															
1031 ^A / _Z 019					S	Solder	19	12	12	2	2					11	12	1.5
								6	10	2	2					11	12	1.5
								1	8.5	2	2					11	12	1.5
					U		19	12	12	–	2					11	12	1.5
								6	10	–	2					11	12	1.5
								1	8.5	2	2					11	12	1.5
					E		19	12	12	2	2					11	12	1.5
								6	10	2	2					11	12	1.5
								1	6.5	2	2					11	12	1.5
					S	Crimp	19	16	2	3	TX00.240	²⁾	TX00.214	TX00.213	11	12	1.5	
					U		19	16	–	3	TX00.240	²⁾	TX00.214	TX00.213	11	12	1.5	
					E		19	14	2	3	TX00.240	²⁾	TX00.214	TX00.213	11	12	1.5	

¹⁾ S - Shielded cable clamp
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²⁾ See Online Crimping Instructions

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