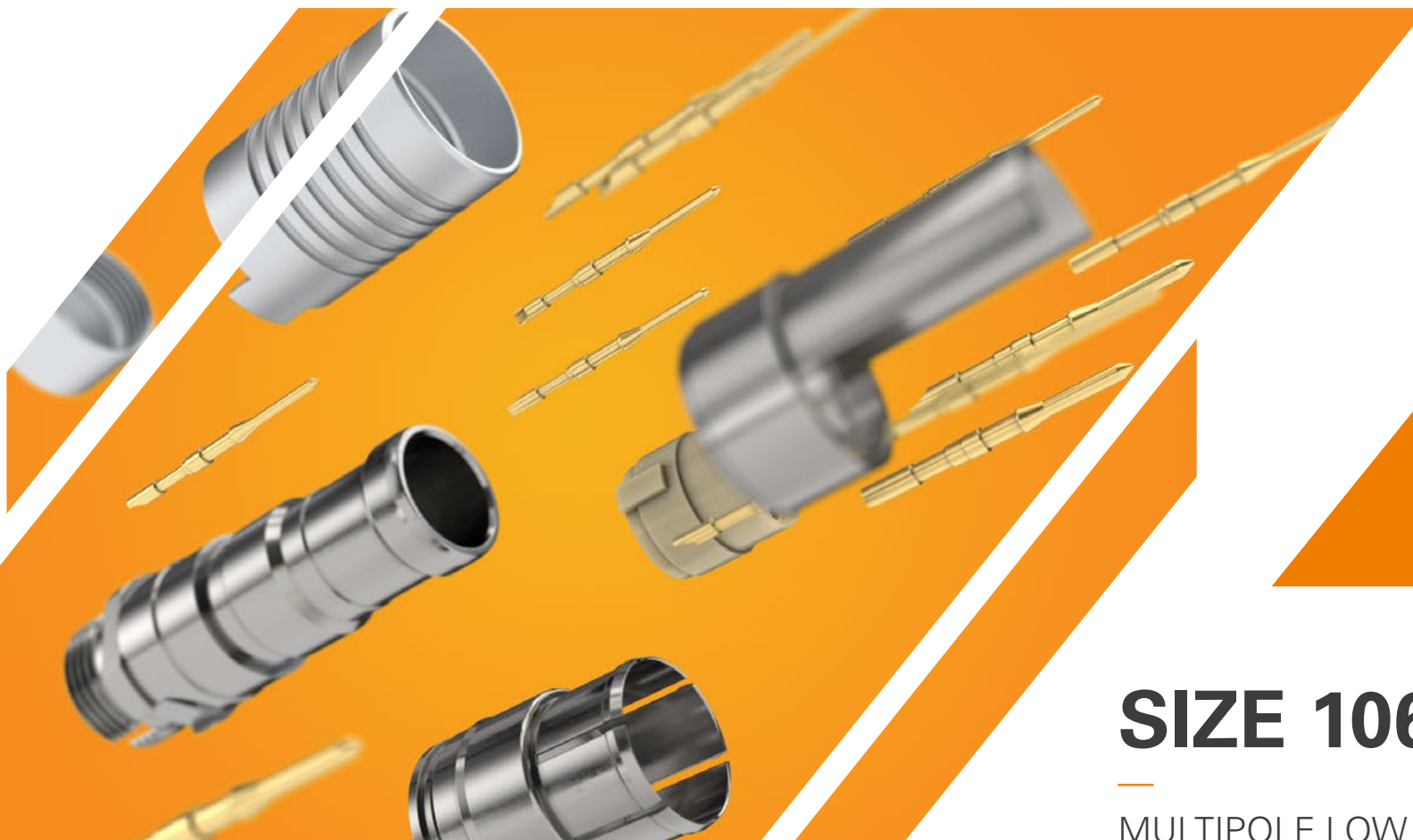




# FISCHER CORE SERIES

## CABLE ASSEMBLY INSTRUCTIONS

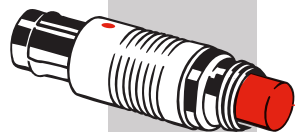


### SIZE 106

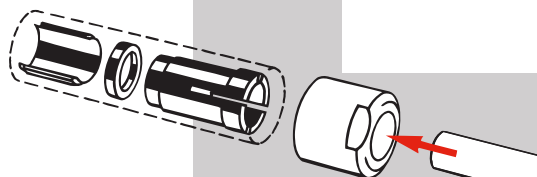
MULTIPOLE LOW VOLTAGE

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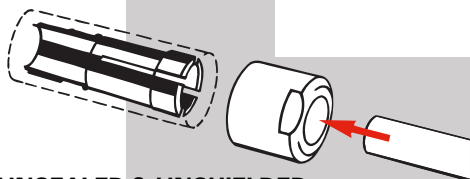
- 1 Remove shipping retainer and contact block



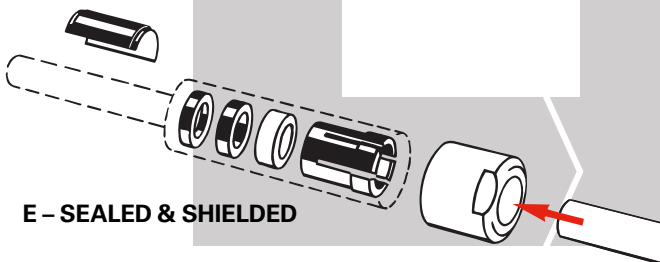
- 2 Slide piece parts over cable (possibly with parts in plastic tube)



S - UNSEALED & SHIELDED



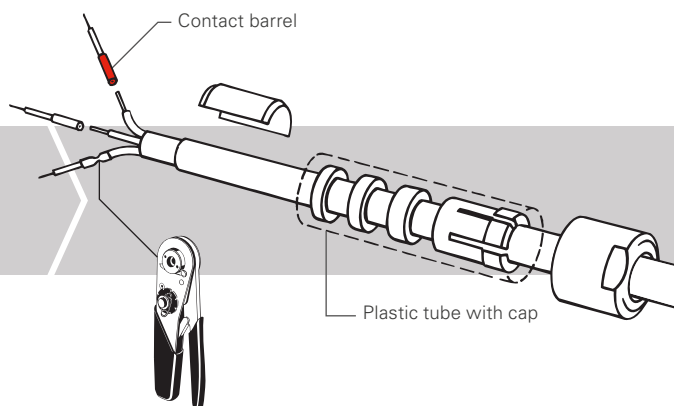
U - UNSEALED & UNSHIELDED



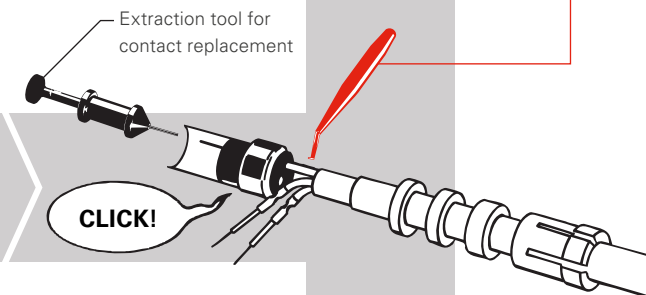
E - SEALED & SHIELDED

## CRIMP CONTACTS

- 3 Strip cable and wires\*
- 4 Fit wire into contact barrel and crimp\*

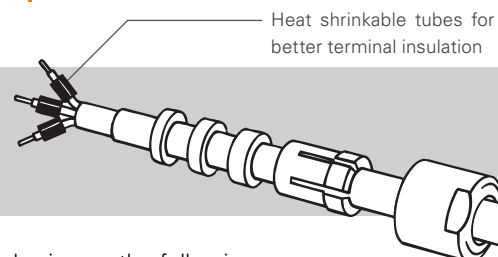


- 5 Insert contacts into insulator and push them home with insertion tool\*

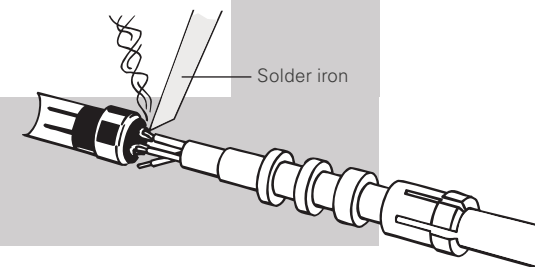


## SOLDER CONTACTS

- 3' Strip cable and wires\*
- 4' Tin strands (recommended)

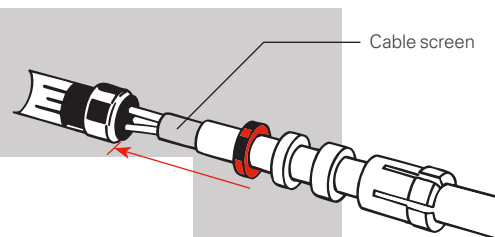


- 5' Solder each wire to the corresponding contact\*, then pull heat shrinkable tubes over the contact terminals and shrink

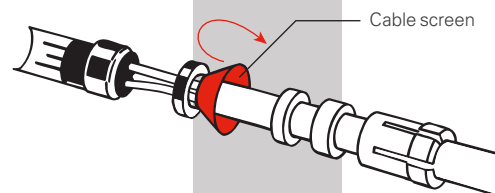


\*For ideal cable and wire preparation, see the specific tools and contact numbering on the following pages.

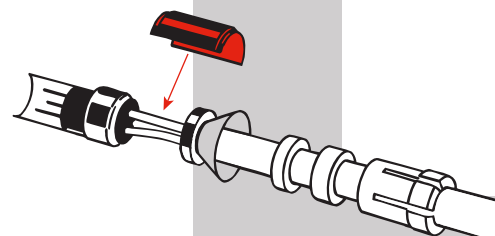
**6** | Slide **ring** towards front end



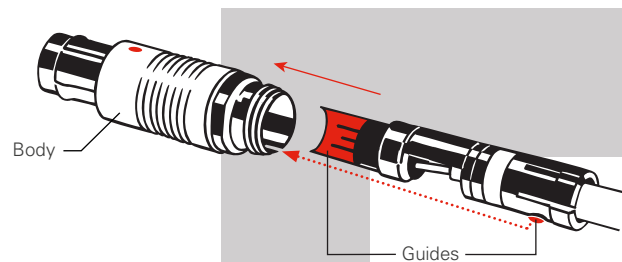
**7** | Bend **cable screen** outwards



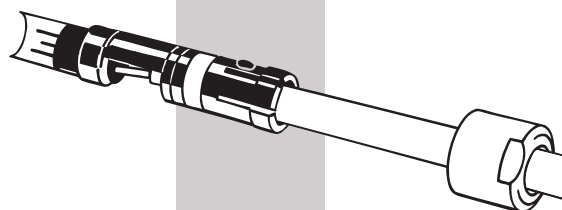
**8** | Insert **half shell** and retain with the ring



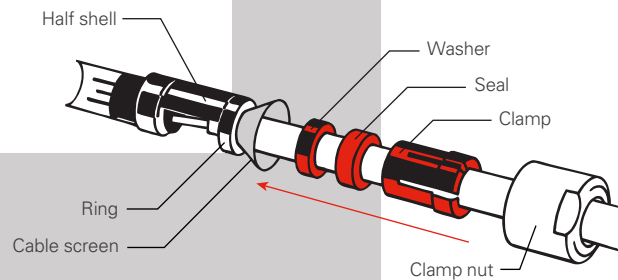
**11** | Push cable assembly into the body, orienting the **guides** to the slots



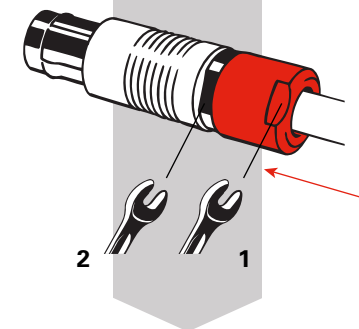
**10** | Trim protruding screen strands



**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\*

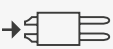

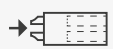
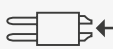
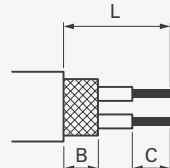


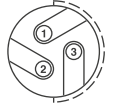


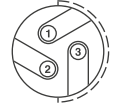




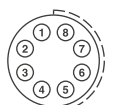
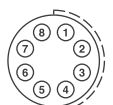
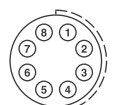







**The assembly is now complete.**

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

# SIZE 106

# MULTIPOLE LOW VOLTAGE CABLE ASSEMBLY INSTRUCTIONS

| Type                                |   |   |   |   | Cable clamp <sup>1)</sup> | 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 <sup>2)</sup> | Torque [Nm] |   |
|-------------------------------------|--|--|--|--|---------------------------|---------------------|--------------------|---|----|---|---------------------------|------------------------|----------------------------|-----------------------------|---|---|-------------|---|
|                                     | Plug   | Receptacle   | Plug   | Receptacle   |                           |                     |                    | L   | B  | C |                           |                        |                            |                             |   |   |             |   |
|                                     | Type "A"   |  | Type "Z"   |  |                           |                     |                    |   |    |   |                           |                        |                            |                             |   |   |             |   |
| 106 <sup>A</sup> / <sub>Z</sub> 003 |   |   |   |   | S                         | Solder              | 3                  | 25  | 5  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
|                                     |  |  |  |  | U                         |                     | 3                  | 25  | –  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
|                                     |  |  |  |  | E                         |                     | 3                  | 18  | 5  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
| 106 <sup>A</sup> / <sub>Z</sub> 007 |   |   |   |   | S                         | Solder              | 7                  | 1   | 18 | 5 | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  | 6                         |                     |                    | 25  | 5  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
|                                     |  |  |  |  | U                         |                     | 7                  | 1   | 18 | – | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  |                           |                     |                    | 6   | 25 | – | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  | E                         |                     | 7                  | 1   | 13 | 5 | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  |                           |                     |                    | 6   | 20 | 5 | 4                         |                        |                            |                             |   | 22  |             | 8 |
| 106 <sup>A</sup> / <sub>Z</sub> 019 |   |   |   |   | S                         | Solder              | 8                  | 20  | 5  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
|                                     |  |  |  |  | U                         |                     | 8                  | 20  | –  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
|                                     |  |  |  |  | E                         |                     | 8                  | 15  | 5  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
| 106 <sup>A</sup> / <sub>Z</sub> 015 |  |  |  |  | S                         | Solder              | 12                 | 4   | 20 | 5 | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  | 8                         |                     |                    | 22  | 5  | 4 |                           |                        |                            |                             | 22  |   | 8           |   |
|                                     |  |  |  |  | U                         |                     | 12                 | 4   | 20 | – | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  |                           |                     |                    | 8   | 22 | – | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  | E                         |                     | 12                 | 4   | 13 | 5 | 4                         |                        |                            |                             |   | 22  |             | 8 |
|                                     |  |  |  |  |                           |                     |                    | 8   | 15 | 5 | 4                         |                        |                            |                             |   | 22  |             | 8 |

<sup>1)</sup> S - Shielded cable clamp  
 U - Unshielded cable clamp  
 E - Sealed cable clamp

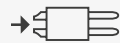



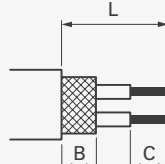


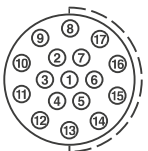
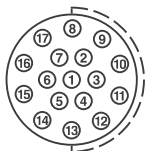
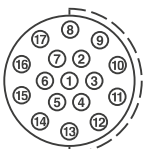
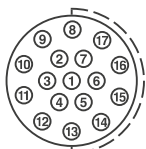




<sup>2)</sup> Except for all cable receptacles (K/KE; DKBE; DK/DKE) : Wrench size = 25

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 106

# MULTIPOLE LOW VOLTAGE CABLE ASSEMBLY INSTRUCTIONS

| Type                                |  |    |  |    | Cable clamp <sup>1)</sup> | 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 <sup>2)</sup> | Torque [Nm] |   |   |
|-------------------------------------|---|---|---|---|---------------------------|---------------------|--------------------|----|---|---------------------------|------------------------|----------------------------|-----------------------------|---|---|-------------|---|---|
|                                     | Plug  | Receptacle  | Plug  | Receptacle  |                           |                     |                    |    | L   |                           |                        |                            |                             |   |   |             | B | C |
|                                     | Type "A"  |   | Type "Z"  |   |                           |                     |                    |    |   |                           |                        |                            |                             |   |   |             |   |   |
| 106 <sup>A</sup> / <sub>Z</sub> 018 | Plug  |    | Plug  |    | S                         | Solder              | 17                 | 1  | 13  | 5                         | 3                      |                            |                             |   | 22  |             | 8 |   |
|                                     |   |   |   |   | 6                         |                     |                    | 15 | 5   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     |   |   |   |   | 10                        |                     |                    | 17 | 5   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     | Receptacle  |    | Receptacle  |    | U                         |                     | 17                 | 1  | 13  | –                         | 3                      |                            |                             |   | 22  |             | 8 |   |
|                                     |   |   |   |   | 6                         |                     |                    | 15 | –   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     |   |   |   |   | 10                        |                     |                    | 17 | –   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     |   |   |   |   | E                         |                     | 17                 | 1  | 8   | 5                         | 3                      |                            |                             |   | 22  |             | 8 |   |
|                                     |   |   |   |   | 6                         |                     |                    | 10 | 5   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     |   |   |   |   | 10                        |                     |                    | 12 | 5   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
| 106 <sup>A</sup> / <sub>Z</sub> 017 | Plug  |    | Plug  |    | S                         |                     | Solder             | 24 | 2   | 13                        | 5                      | 3                          |                             |   |   | 22          |   | 8 |
|                                     |   |   |   |   | 8                         |                     |                    |    | 15  | 5                         | 3                      |                            |                             |   | 22  |             | 8 |   |
|                                     |   |   |   |   | 14                        |                     |                    |    | 17  | 5                         | 3                      |                            |                             |   | 22  |             | 8 |   |
|                                     | Receptacle  |  | Receptacle  |  | U                         | 24                  |                    | 2  | 13  | –                         | 3                      |                            |                             |   | 22  |             | 8 |   |
|                                     |   |   |   |   | 8                         |                     |                    | 15 | –   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     |   |   |   |   | 14                        |                     |                    | 17 | –   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     |   |   |   |   | E                         | 24                  |                    | 2  | 8   | 5                         | 3                      |                            |                             |   | 22  |             | 8 |   |
|                                     |   |   |   |   | 8                         |                     |                    | 10 | 5   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |
|                                     |   |   |   |   | 14                        |                     |                    | 12 | 5   | 3                         |                        |                            |                             | 22  |   | 8           |   |   |

<sup>1)</sup> S - Shielded cable clamp  
U - Unshielded cable clamp  
E - Sealed cable clamp

<sup>2)</sup> Except for all cable receptacles (K/KE; DKBE; DK/DKE) : Wrench size = 25

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.