

Pictures show the Ultimate UP01 Size 07.

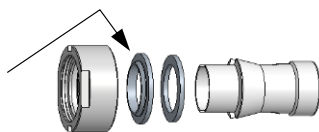
Connector parts



Slide Back Nut, Washers (2x) and the Spacer

For Size 15:

Washer with conical profile
 on rear side of connector

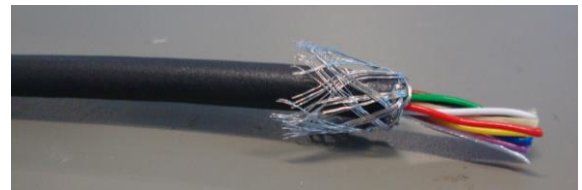


Strip cable jacket to dimension L below:

Size	Pin Layout (Number of Contacts)	Termination	L [mm]
07	All	Solder	10
15	All	Solder	20



Pull back the shield over the jacket.



**Separate the Kevlar from the conductors.
 Pull back the Kevlar.
 Secure the shield and the Kevlar with tape.**

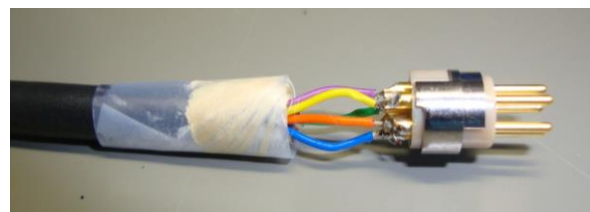


Trim back conductors acc. to table below:

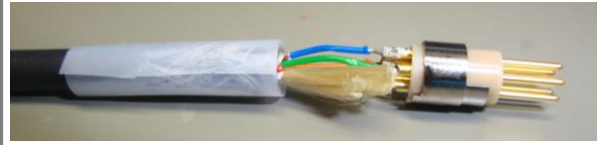
Size	Pin Layout (Number of Contacts)	Central [mm]	Intermediate [mm]
07	007	1.5	1.5
	009	1.5	1.5
15	002	N/A	N/A
	004	N/A	N/A
	008	2	N/A
	027	4	2
	412	2	N/A
	204H	See specific instructions	

Strip all conductors to 1.5mm.

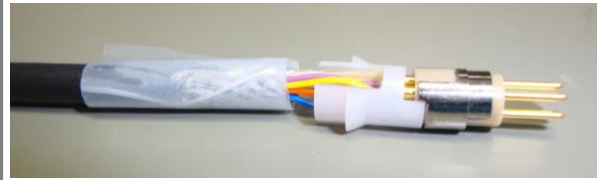
SOLDER



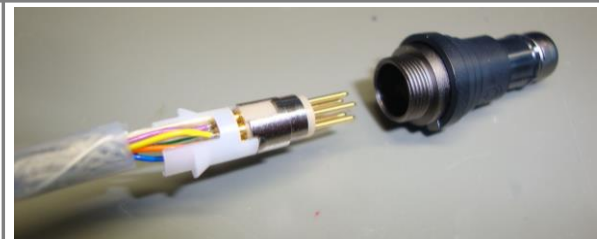
Pull out the Kevlar from the tape.



Slide the Spacer down onto the Contact Block.
Ensure that the Spacer mates with the key on the Contact Block.



Insert the Contact Block with the Spacer into the Body.
Push the Spacer until it clips inside the Body.
Ensure that the Spacer is fully engaged by pulling slightly on the cable.



Install the assembly into your potting fixture⁽¹⁾

1) It is strongly recommended to use a Fischer counterpart (or equivalent) as a potting fixture in order to guarantee the contact block alignment.

Heat up the epoxy:

Recommended epoxy type: RS 851-044⁽²⁾

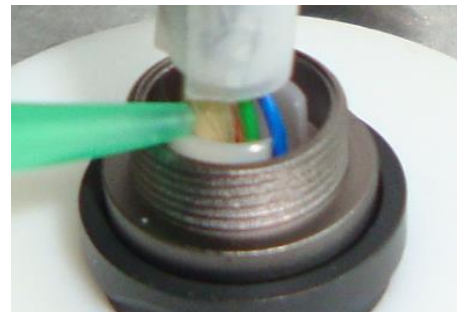
2) Or equivalent. Viscosity is important. If the epoxy has a too low viscosity it will flow through the connector and create irreversible damages.



Slowly dispense potting material into the connector.

The potting material should cover the Spacer but should not reach the level of the Washer support seat.

Allow the potting material to cure according to its specifications.



Slide down one Washer and fit it into the seat of the Body.



Fold the shield evenly over the Washer slightly on the cable.
 Trim the excess shield.
 The shield should completely cover the Washer and not go beyond in the Washer.



Slide down the second Washer.



Pull down the Back Nut and tighten it by hand



Tighten and secure the Back Nut with the following torque to have an optimal shield continuity. Use a receptacle as counterpart for this operation.

Size	Torque [Nm]	Spanner Sizes [mm]	DO NOT SCREW BEYOND [Nm]
07	1.5	8	1.5
15	4.0	8	5.0

The use of a "Breaking" Torque Handle is recommended.

Install the assembly back into your potting fixture.

Fill up the Back Nut with following recommended epoxy material:

- For straight plug: RS 851-044 ⁽¹⁾
- For angled plug: RT 125 ⁽¹⁾

Put a small amount of epoxy around the cable and let it cure.

1) Or equivalent.

