



Part of Conexivity Group

Assembly Instructions
for
UltiMate™

Size 15
UP02

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1 Introduction

This document shows how to assemble UltiMate™ Size 15 cable connectors.

It covers the following range of connector body styles:

- Cable Mounted Plugs: UP02

Please read these instructions thoroughly before starting assembly.

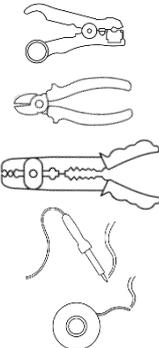
2 Document History

Date	Revision #	Description of the modification
*	*	*
*	*	*
*	*	*
*	*	*
*	*	*

3 Definitions and Acronyms

Text	Definition / Acronym
-	-
-	-
-	-

4 Tools Required

Tool Required					
For all versions: <ul style="list-style-type: none"> • Cable Stripper • Wire Cutter • Wire Stripper • Soldering Iron ¹⁾ • Solder Wire ²⁾ 		Fischer Part Number: - - - - -	For all versions: <ul style="list-style-type: none"> • Flat Spanner: <ul style="list-style-type: none"> • 19 mm • Epoxy ³⁾ 		Fischer Part Number: TX00.019 -

1) Recommended Soldering Iron setting: +380 °C (716 F)

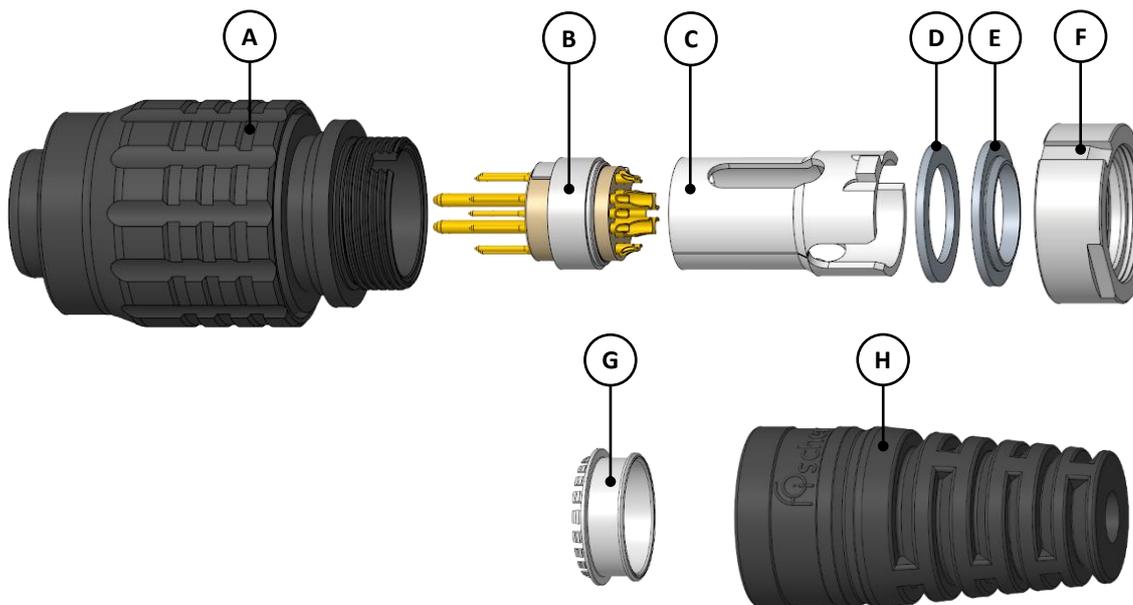
2) Recommendation: Use lead-free Solder Wire

3) Recommended epoxy type: RS ref. 851-044 black

5 Connector Parts

Designation of all Connector Parts

Plug: UP02



Part list :

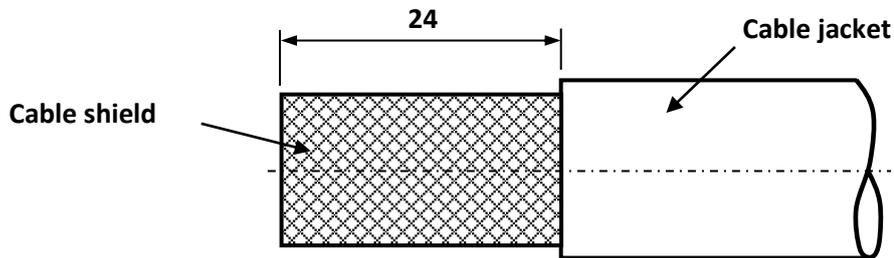
- A – Housing
- B – Contact Block
- C – Sleeve
- D – Washer
- E – Conical Washer
- F – Clamp Nut
- G – Clip Ring ⁴⁾
- H – Cable Bend Relief ⁴⁾

4) To be purchased separately.

6 Cable Preparation

Cable Stripping Dimensions

- Cut the cable jacket to length indicated in the diagram below.



- Fold the cable shield back over the cable jacket.
- Cut and strip the wires as described below.

L1 depends on the

contact row (A, B, C)

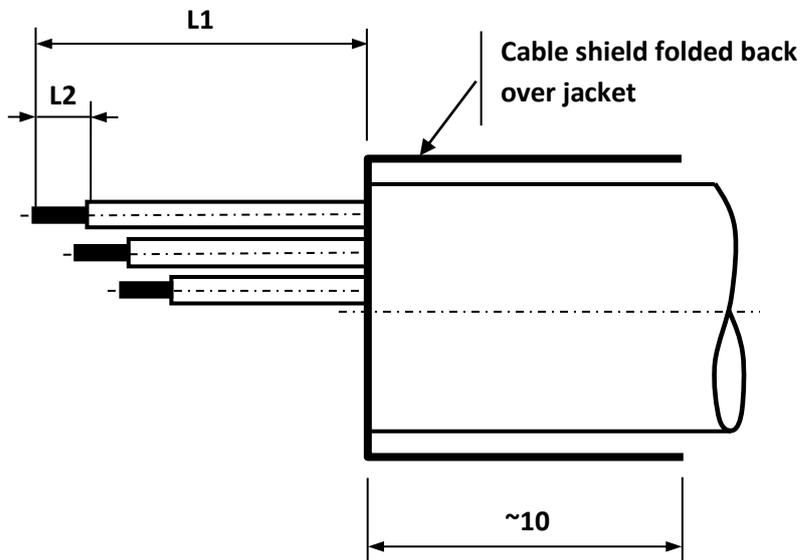
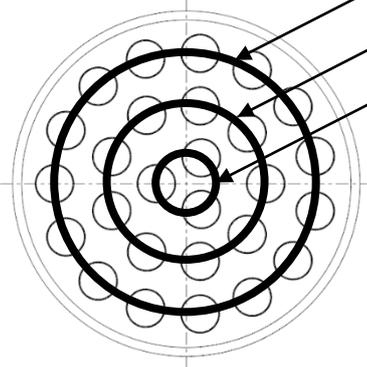
See Table 1

Row :

A

B

C



Layout Reference	L1 Wire Length			L2 Stripping Length
	A	B	C	
002	24	-	-	5
004	24	-	-	4
008	24	22.5	-	3
412	20	18	-	1.5
027	24	22.5	21	2
204H	See specific instructions			

Table 1

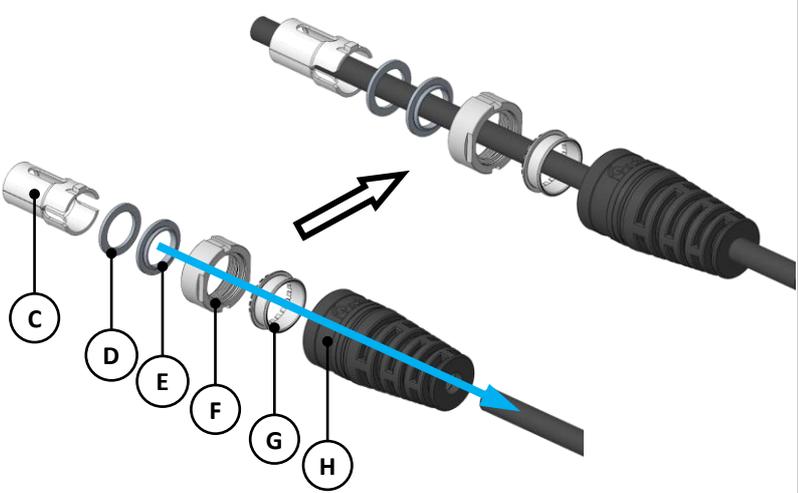
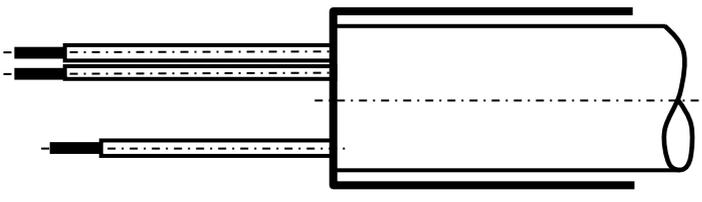
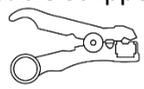
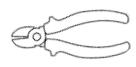
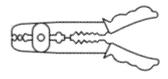
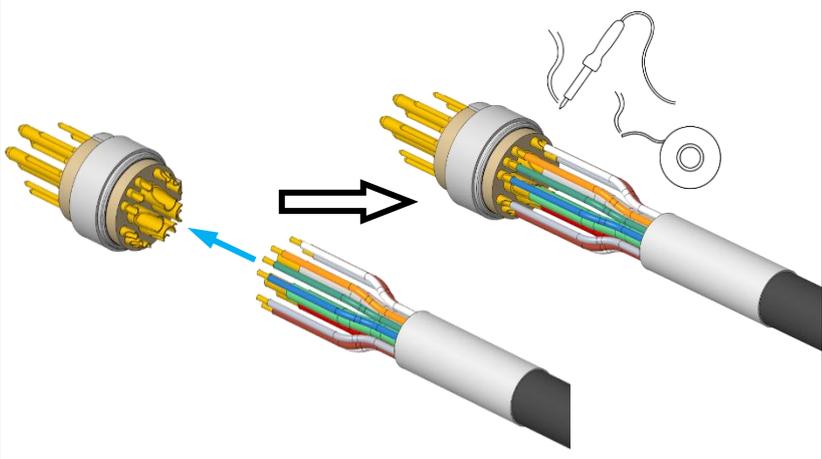
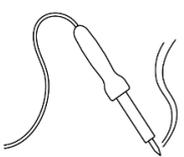
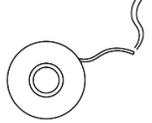


CAUTION

Wire conductors should not be scraped, nicked, cut, or otherwise damaged during the stripping operation.

All dimensions in mm.
These values are given for reference.

7 Assembly

Assembly Steps			
#	Diagram	Process	Tools Req'd
1		<p>Slide the following parts over the cable in order:</p> <ul style="list-style-type: none"> • Cable Bend Relief (H) ¹⁾ • Clip Ring (G) ¹⁾ • Clamp Nut (F) • Conical Washer (E) • Washer (D) • Sleeve (C) <p>1) To be purchased separately</p>	-
2		<p>Strip cable as described in §6.</p>	<p>Cable Stripper</p>  <p>Wire Cutter</p>  <p>Wire Stripper</p> 
3		<p>Solder each wire to the corresponding contact.</p> <p>Recommendations:</p> <ul style="list-style-type: none"> - Use lead-free Solder Wire. - Soldering Iron setting: +380 °C (716 F) 	<p>Soldering Iron</p>  <p>Solder Wire</p> 

#	Diagram	Process	Tools Req'd
4		<p>Align Nose and Groove.</p> <p>Place the Sleeve (C) around the back of the Contact Block (B).</p>	-
5		<p>Align the Nose of the Sleeve with the Notch.</p> <p>Insert the Sleeve and Contact Block into the Housing (A) until they stop. The Sleeve should be approximately 0.5 mm below the rear surface of the Housing.</p>	-

#	Diagram	Process	Tools Req'd
6		<p>Pour epoxy (in blue) into the Housing until it is slightly below the top of the Sleeve. It should not reach the level of the bearing surface for the Washer.</p> <p>Recommended epoxy type: Ref. RS 851-044 black</p>	<p>Epoxy</p>
7		<p>Slide the Washer (D) against the Housing.</p> <p>Fold back the cable shield evenly over the Washer.</p> <p>Trim the excess shield. The shield should completely cover the Washer and not go beyond.</p>	<p>Wire Cutter</p>
8		<p>Slide the Conical Washer (E) over the cable shield (conical profile on rear side).</p>	<p>-</p>
9		<p>Screw the Clamp Nut (F) on to the back of the Housing (A) and tighten with a flat spanner. Use a receptacle as a counterpart for this operation.</p> <p>Recommended torque: 4.0 Nm</p> <p>The use of a "Breaking" Torque Handle is recommended.</p>	<p>Flat Spanner</p> <p>TX00.019</p>

#	Diagram	Process	Tools Req'd
10		<p>Please also refer to specific assembly instructions for optional Cable (Boot) Bend Relief (F and G).</p> <p>Slide the Clip Ring (G) against the Clamp Nut (F) and snap it into place.</p> <p>Apply more epoxy around the cable termination.</p>	<p>Epoxy</p>
11		<p>Allow the epoxy to cure according to its specified process.</p> <p>Once the epoxy has cured according to the specified process, you are ready to install the Cable Bend Relief (H).</p>	-
12		<p>Align the Nose and Groove.</p> <p>Slide the Cable Bend Relief (H) onto the rear of the Housing until it snaps into place (in blue).</p>	-

