

Assembly Instructions

M23 Elite Series 12,16,17 Position Plug Assembly Instructions



Step 1 - Slide the components over the cable



Step 2 - Remove the cable jacket 28mm



Step 3 - Cut the shield back 13mm



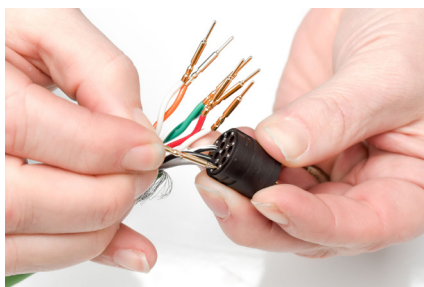
Step 4 - Fold the shield back over the cable jacket



Step 5 - Strip the wires 4.5mm



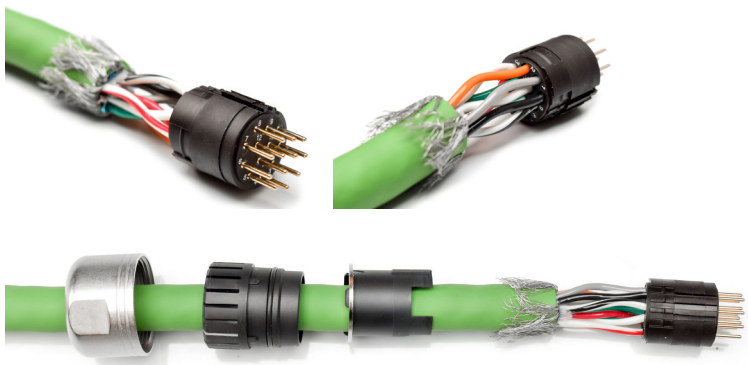
Step 6 - Crimp a contact onto each wire



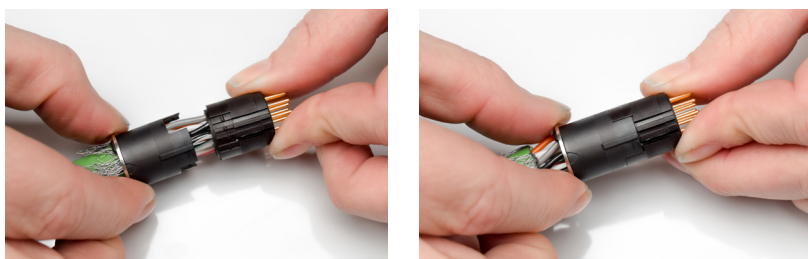
Step 7 - Push the contacts into the insert as required

Assembly Instructions

M23 Elite Series 12,16,17 Position Plug Assembly Instructions (cont)



Step 8 - Pushed contacts



Step 9 - Push the Collar onto the insert



Step 10 - Position the shield as shown

Assembly Instructions

M23 Elite Series 12,16,17 Position Plug Assembly Instructions (cont)



Step 11 - Slide the cord grip up to the collar



Step 12 - Trim the shield



Step 13 - Grip the sub-assembly as shown



Step 14 - Push the sub- assembly into the shell

Assembly Instructions

M23 Elite Series 12,16,17 Position Plug Assembly Instructions (cont)



Step 15 - Thread the top nut onto the shell



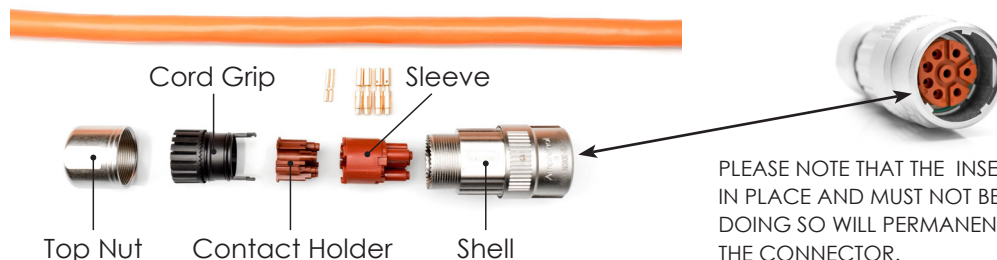
Step 16 - Tighten to 5-7 N/M using 25mm wrench



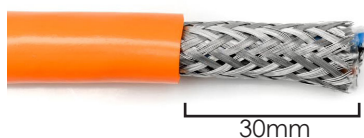
Step 17 - Finished Assembly

Assembly Instructions

M23 Elite Series 6,8,9 Position Plug Assembly Instructions



PLEASE NOTE THAT THE INSERT IS FIXED IN PLACE AND MUST NOT BE REMOVED. DOING SO WILL PERMANENTLY DAMAGE THE CONNECTOR.



Step 1 - Remove the cable jacket 30mm



Step 2 - Cut the shield back 19mm



Step 3 - Fold shield back over cable



Step 4 - Cut power & PE wires to 28mm

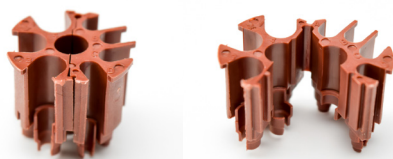
Step 5a - Strip power & PE wires 7mm



Step 5b - Strip signal wire 4.5mm



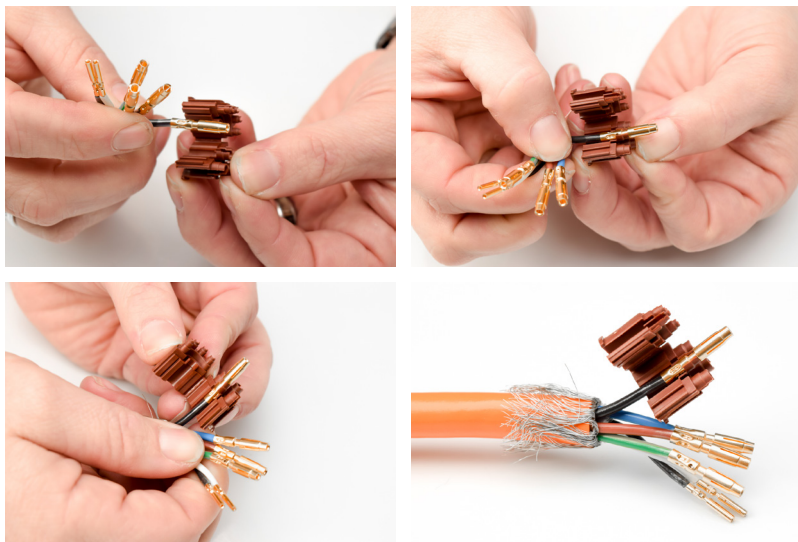
Step 6 - Crimp contacts



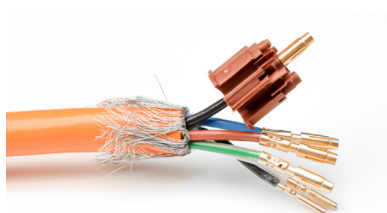
Step 7 - Open contact holder

Assembly Instructions

M23 Elite Series 6,8,9 Position Plug Assembly Instructions (con't)



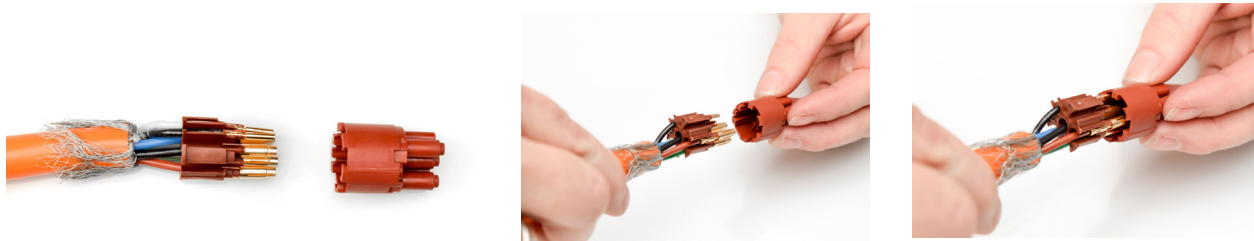
Step 8 - Insert contacts while the contact holder is open



Step 9 - Close the contact holder



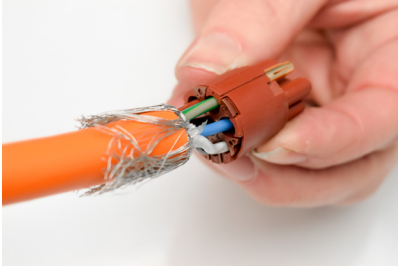
Step 10 - Insert the rest of the contacts



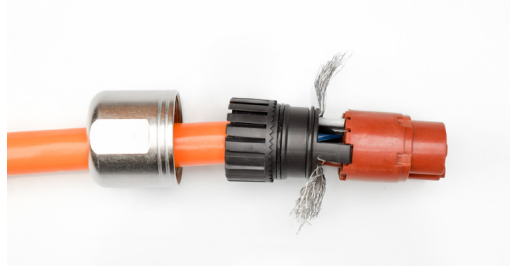
Step 11 - Push the contact holder into the sleeve

Assembly Instructions

M23 Elite Series 6,8,9 Position Plug Assembly Instructions (con't)



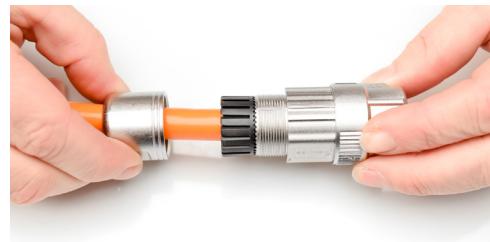
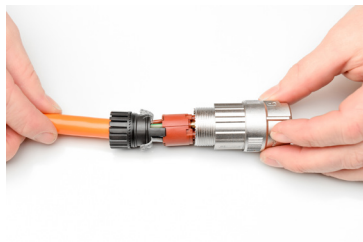
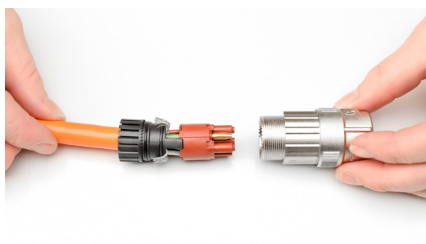
Step 12 - Position shield as shown back over the cable



Step 13 - Clip the cord grip as shown with the shield sticking out around it



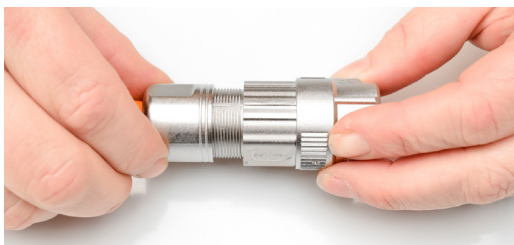
Step 14 - Trim shield as shown



Step 15 - Push sub-assembly into shell

Assembly Instructions

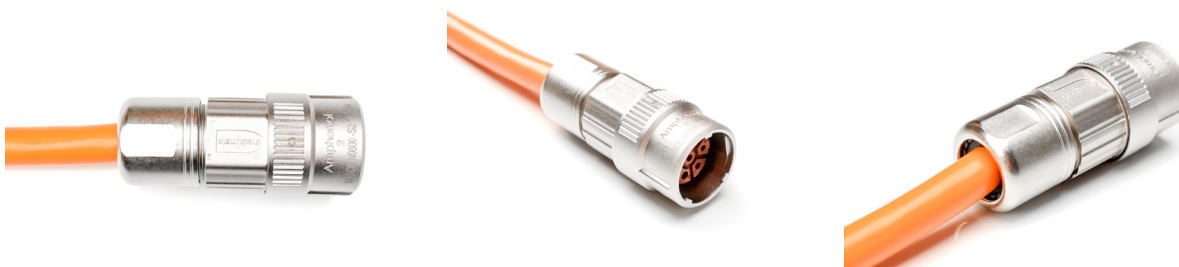
M23 Elite Series 6,8,9 Position Plug Assembly Instructions (con't)



Step 16 - Thread the top nut on



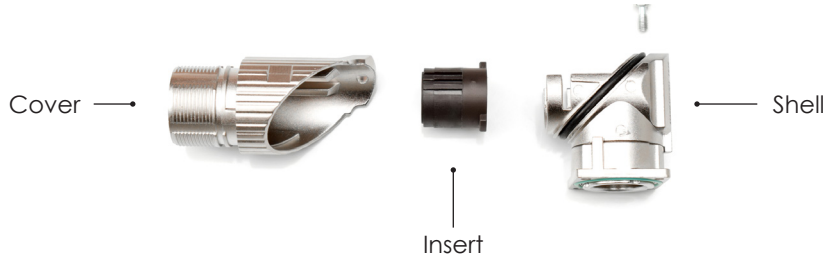
Step 17 - Tighten to 5-7 N/M
using 25mm wrench



Step 18 - Finished Assembly

Assembly Instructions

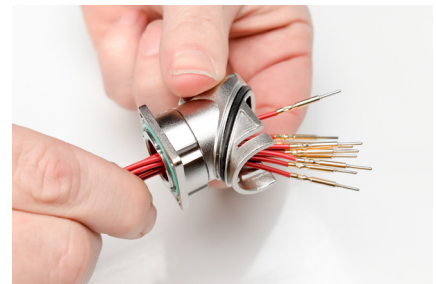
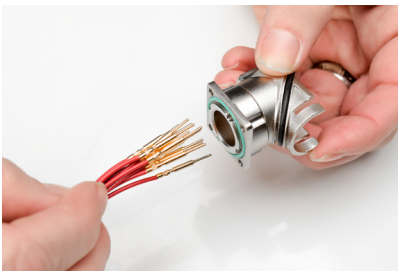
M23 Elite Series 12,16,17 Position 90° Receptacle Assembly Instructions



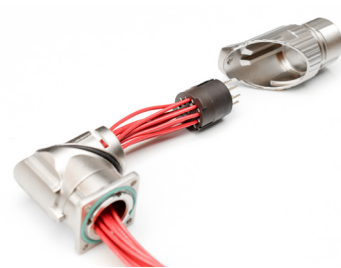
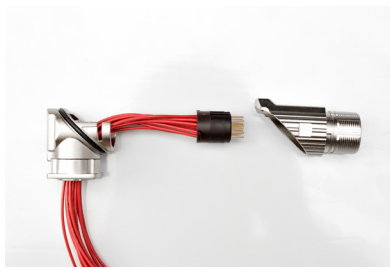
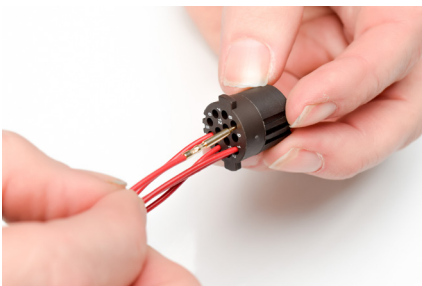
Step 1 - Strip wire 4.5mm



Step 4 - Crimp contacts onto wire



Step 3 - Slide wires through shell



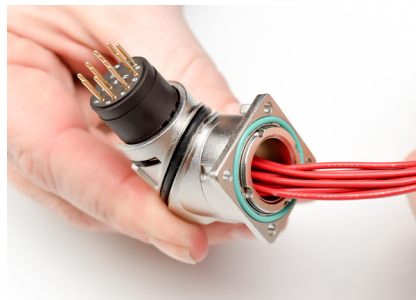
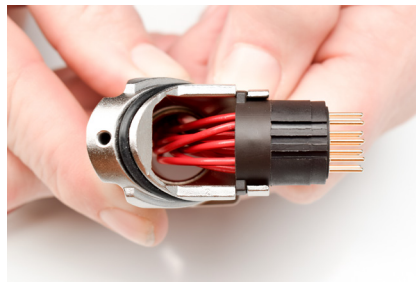
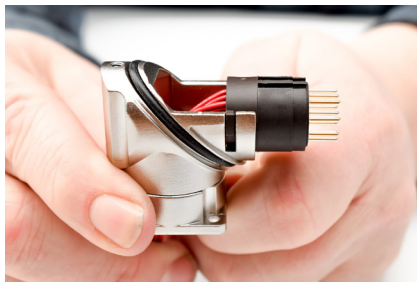
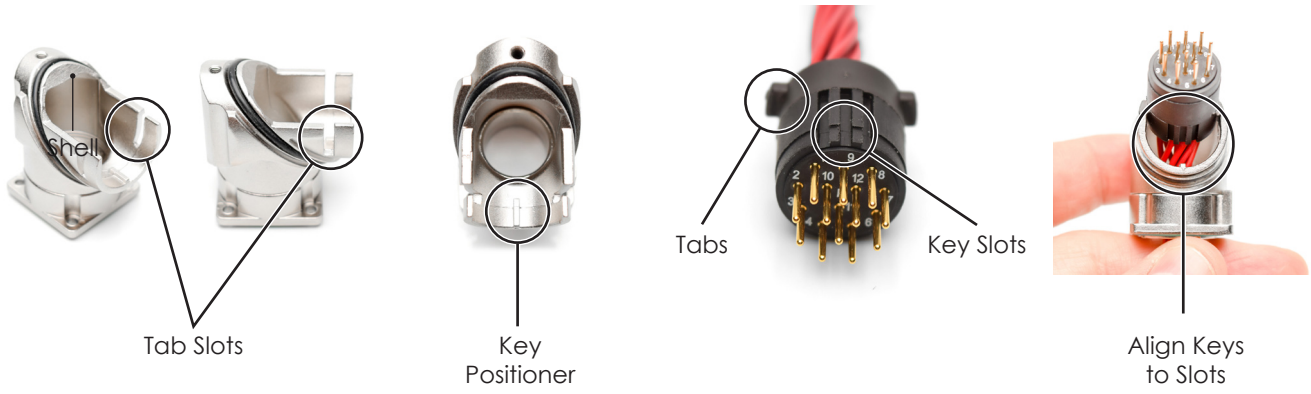
Step 4 - Push wire into insert



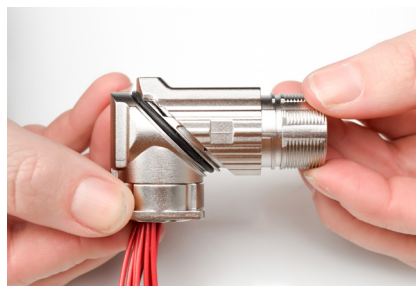
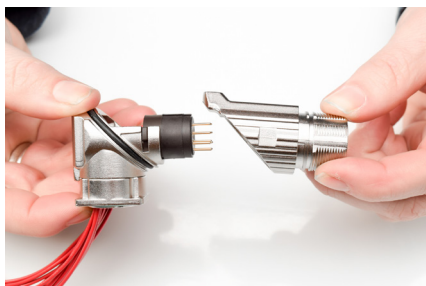
Step 5 - Locate keys on sides of insert

Assembly Instructions

M23 Elite Series 12,16,17 Position 90° Receptacle Assembly Instructions (con't)



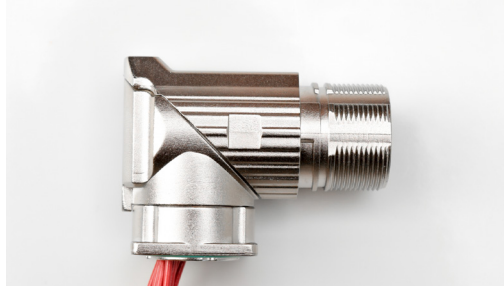
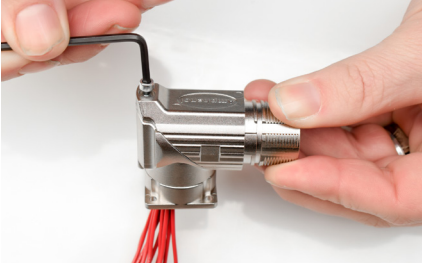
Step 6 - Insert tabs into slots and align the key slots accordingly to their respective key position.



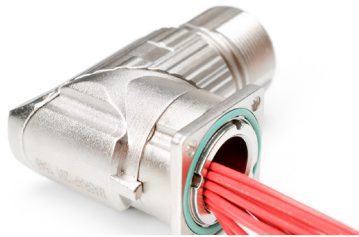
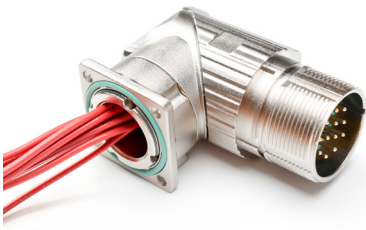
Step 7 - Assemble cover

Assembly Instructions

M23 Elite Series 12,16,17 Position 90° Receptacle Assembly Instructions (con't)



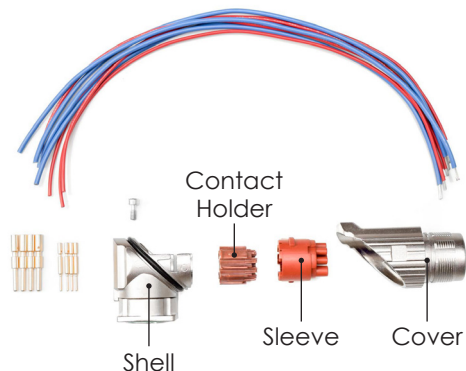
Step 8 - Screw the cover down using 2.5mm Allen Wrench



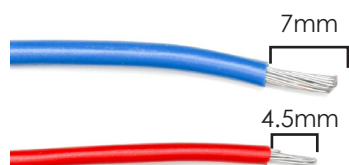
Step 9 - Finished product

Assembly Instructions

M23 Elite Series 6,8,9 Position 90° Receptacle Assembly Instructions



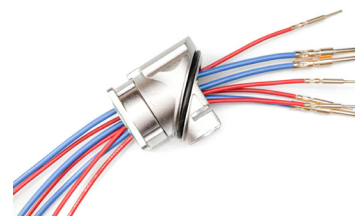
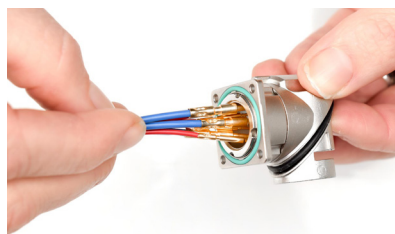
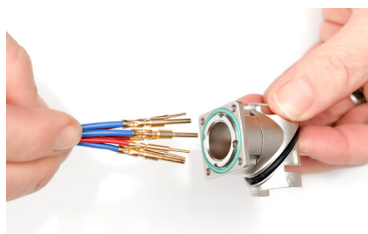
Step 1A - Strip wire 7mm
(this uses 2.0mm contacts)



Step 1B - Strip wire 4.5mm
(this uses 1.0mm contacts)



Step 2 - Crimp wire to contact



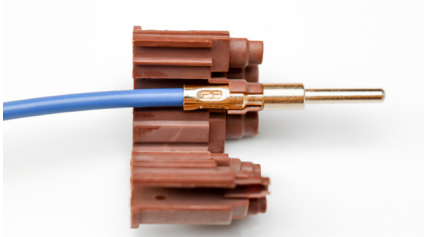
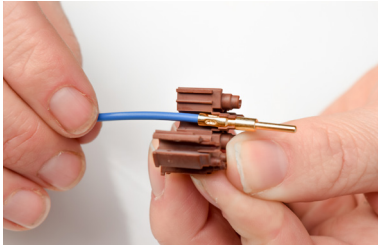
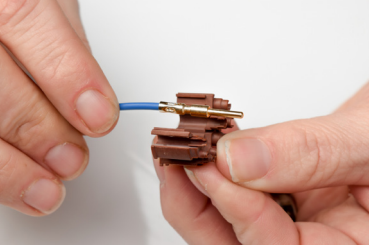
Step 3 - Insert wires through shell



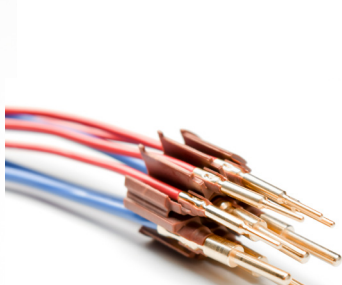
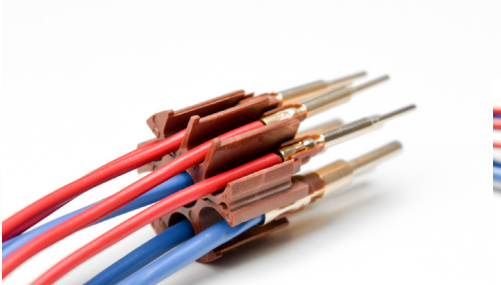
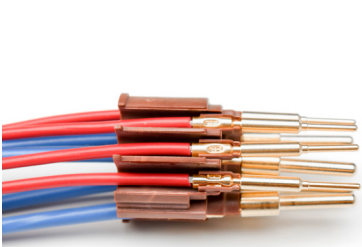
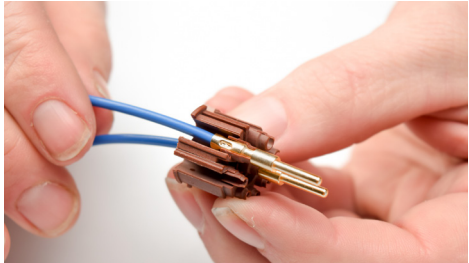
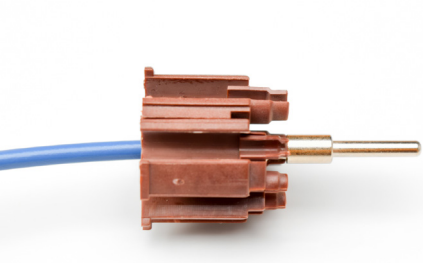
Step 4 - Open Contact holder

Assembly Instructions

M23 Elite Series 6,8,9 Position 90° Receptacle Assembly Instructions (con't)



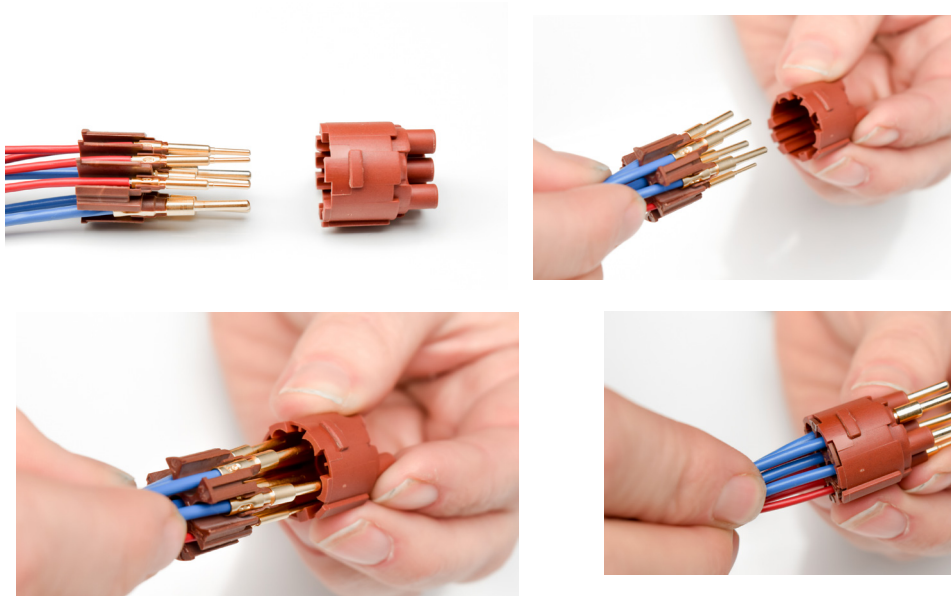
Step 5 - Insert wire into the contact holder while its open



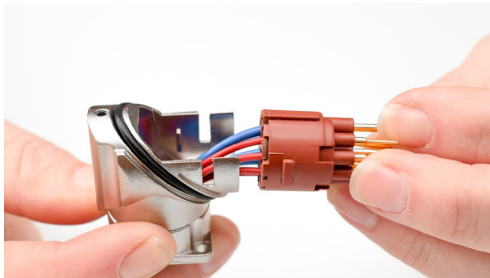
Step 6 - Close and insert the rest of the wires into the contact holder

Assembly Instructions

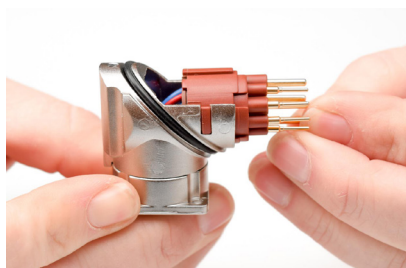
M23 Elite Series 6,8,9 Position 90° Receptacle Assembly Instructions (con't)



Step 7 - Push the contact holder into the sleeve



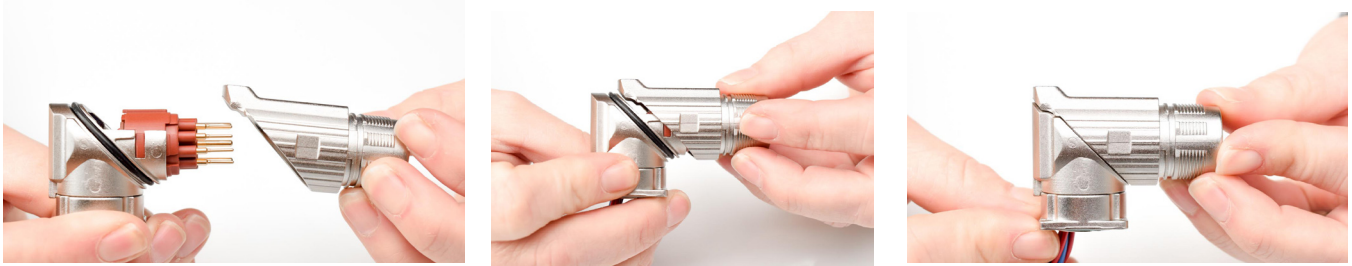
Step 8 - Align the key on the sleeve with the key on the shell



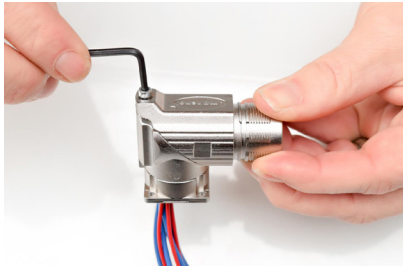
Step 9 - Place sub-assembly into shell

Assembly Instructions

M23 Elite Series 6,8,9 Position 90° Receptacle Assembly Instructions (con't)



Step 10 - Assemble cover



Step 11 - Tighten screw down using 2.5mm Allen Wrench



Step 12 - Finsihed Product

Assembly Instructions

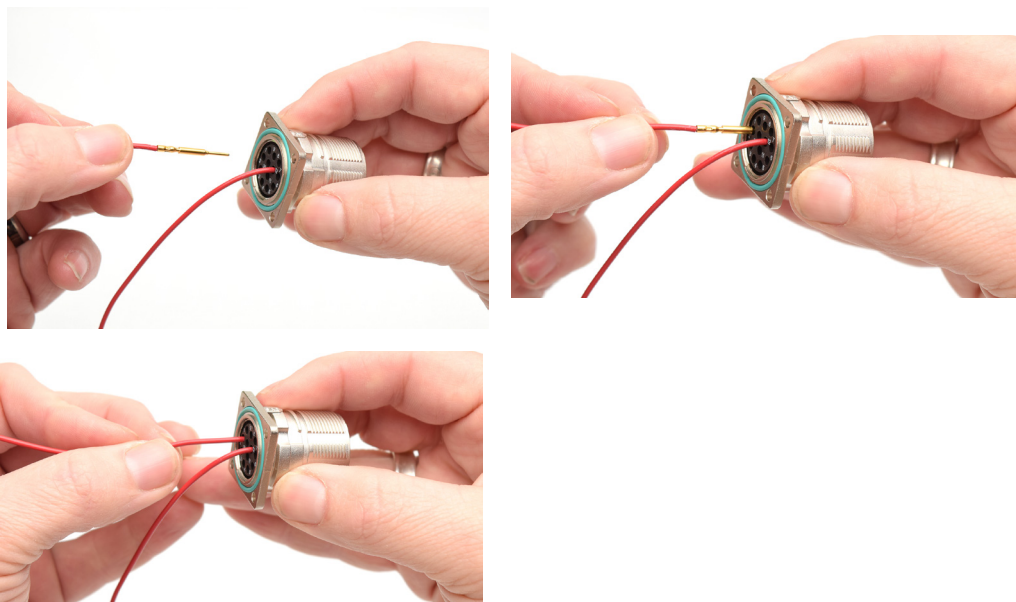
M23 Standard Series Straight Receptacle Assembly Instructions



Step 1 - Strip wire 4.5mm



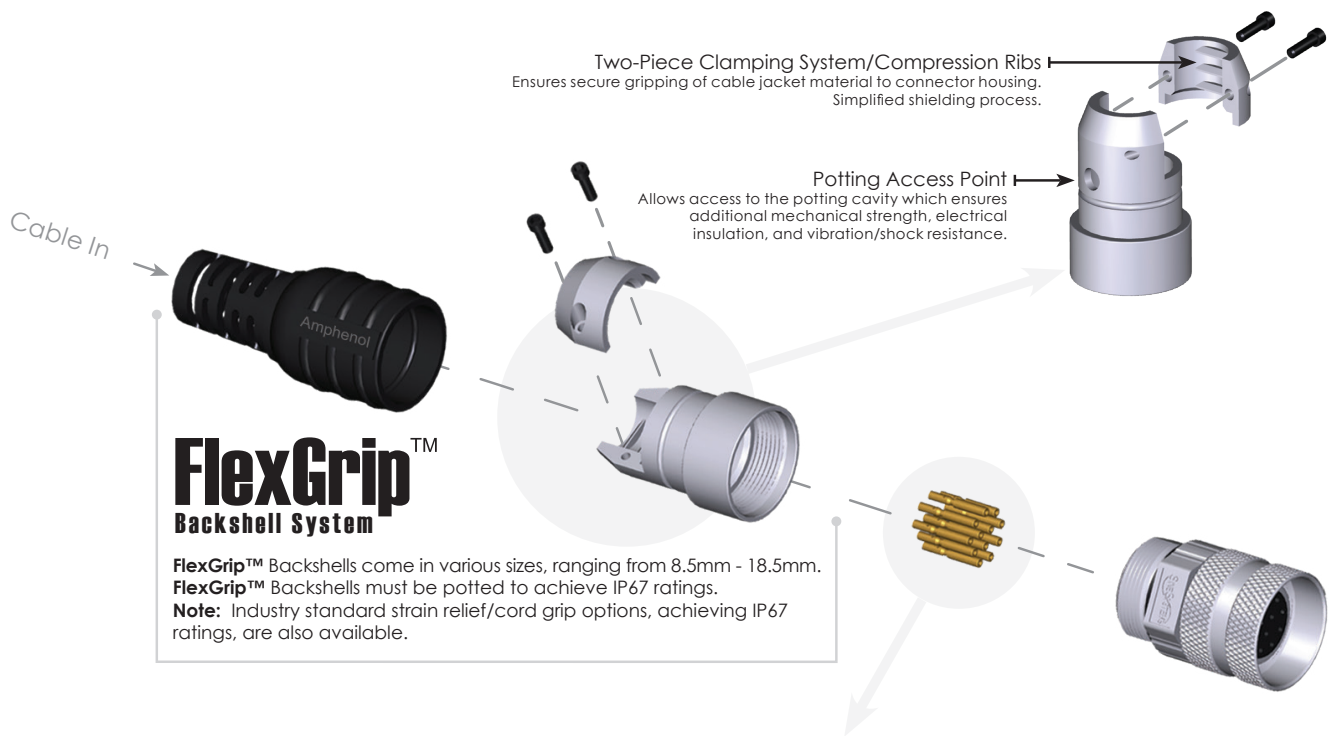
Step 2 - Crimp contact to wire



Step 3 - Push contact into place

Assembly Instructions

FlexGrip™ Backshell System



Assembly Instructions

Standard Series Plug and Cable Prep and Assembly featuring the FlexGrip™ Backshell

FlexGrip™ Prep Details: During cable prep specific to using the FlexGrip backshell, be sure excess shielding material is pulled back over the cable jacket and taped down. This allows for ease of sliding FlexGrip™ parts into place.

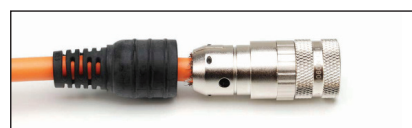
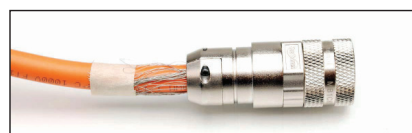
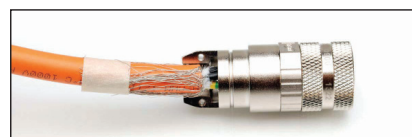
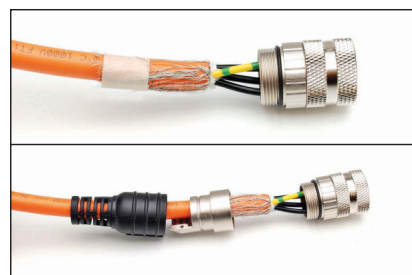
Note: ** Cable prep is same for P1 (Male) connectors using FlexGrip™ backshells as P2 (Female).

Step 7B: (FlexGrip™ Only) Thread into position the bottom part of the Two-Piece Clamp onto the backend of the connector body tightly, ensuring excess shielding material is still exposed underneath the Two-Piece Clamp.

Step 8B: (FlexGrip™ Only) Place the top portion of the Two-Piece Clamp into position and use the enclosed screws to tighten into place.

Step 9B: (FlexGrip™ Only) Cut off excess shielding material behind Two-Piece Clamp.

Step 10: (FlexGrip™ Only) Slide FlexGrip™ Shell over top the backend portion of the Two-Piece Clamp hardware.



Assembly Instructions

M23 Shielded Backshell Assembly Instructions

1. Slide seal-nut (A), cable grommet (B), and backshell (C) onto cable as shown in Figure 1.
2. Remove outer cable jacket per dimension (42mm) shown in Figure 1. Make sure exposed shielding is not nicked or cut.
3. Accurately locate and tighten tie wrap (D) 8mm from cable jacket (Figure 1).
4. Trim excess tie wrap as close as possible to ratchet body. Refer to Reference View A, shown below.
5. Trim the braided shield flush to the edge of the tie wrap (D), exposing the individual wires as shown in Figure 2.
6. Strip individual wire leads to expose 5mm of bare conductor as shown in Figure 2.
7. Crimp contacts (E) onto stripped wire leads (Figure 3).
8. Insert crimped contacts (E) into connector cavities (F), as shown in Figure 3. Verify contacts are properly sealed once installed.

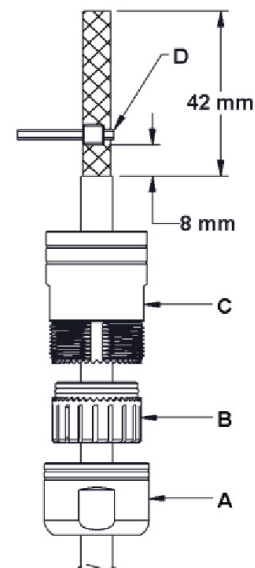


Figure 1

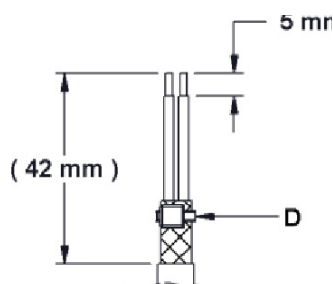


Figure 2

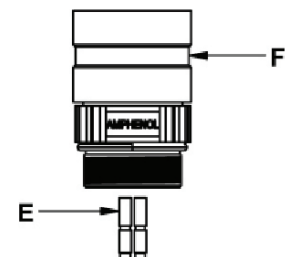
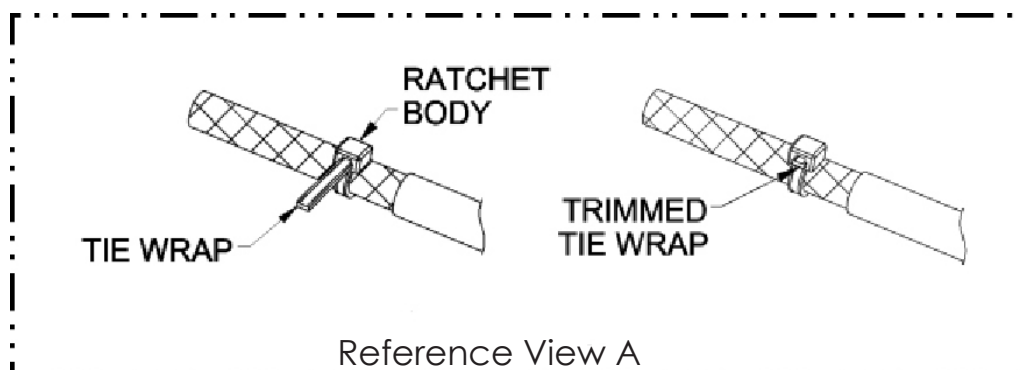


Figure 3



Reference View A

Assembly Instructions

M23 Shielded Backshell Assembly Instructions (con't)

9. Tighten "backshell" (C) to connector (F) as shown in Figure 4. Use a 24mm open ended wrench for the backshell, and a 25mm open ended wrench for the connector. Tighten to a recommended torque of 10Nm.
10. Slide shielding clip (G) over cable jacket as shown in Figure 4.
11. Push shielding clip (G) into backshell (C) until it stops against inside wall as shown in Reference View-B. Clip must be seated over exposed shielding and not over cable jacket.

Note: Clip must be slightly compressed to allow it to enter into the backshell.

12. Push cable grommet (B) into backshell (C) as shown Figure 5.
13. Thread and tighten seal-nut (A) onto backshell (C) as shown in Figure 6. Use a 24mm open ended wrench for the backshell, and a 25mm open ended wrench for the seal-nut.

Figure 6(A)

Note: Seal nut torque required to properly retain and seal cable may vary depending on cable construction. Recommendation to start with a torque value at 2-3Nm and adjust from there depending on your application

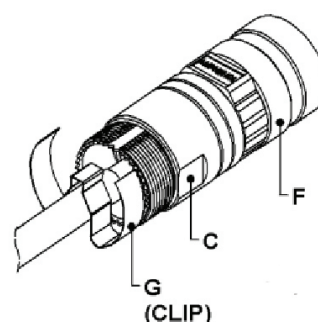


Figure 4

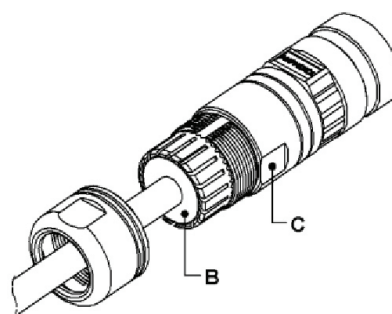


Figure 5

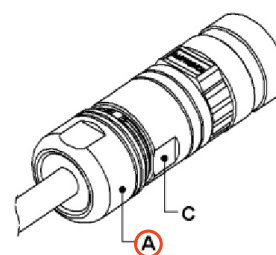
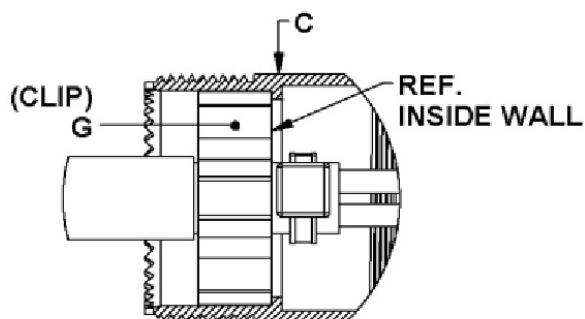


Figure 6



Reference View B