

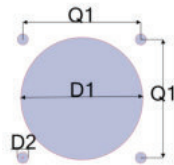
Assembly Instructions Series M (receptacle, panel mount)

1.



Part as supplied.

2.



Panel cut out

Connector size	Q1 mm [inch]	D1 mm [inch]	D2 mm [inch]
M3	34.90 [1.374"]	35.90 [1.413"]	3.75 [.148"]
M5	39.65 [1.561"]	42.20 [1.661"]	3.75 [.148"]
M7	44.45 [1.750"]	49.30 [1.941"]	4.40 [.173"]
M9	49.25 [1.939"]	54.90 [2.161"]	4.40 [.173"]

3.



Carefully remove cable jacket (L1 = min. 65mm).
⚠ Do not damage metal shield braid.

4.



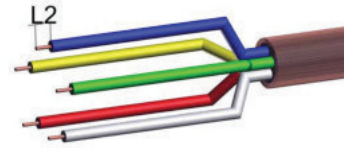
Fold back shield braid.

5.



Remove any filling elements from cable.

6.



Remove dielectric insulation of single wires (L2 = 5 mm [.197"]).
⚠ Do not damage conductors

7.



Slide one shrinking tube on each single wire.

8.



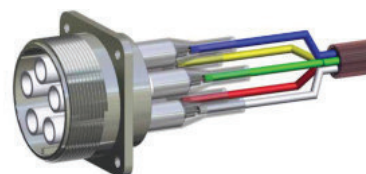
Solder one conductor on each female contact.

9.



Slide shrinking tubes on insulation parts and shrink tubes - shrinking temperature 100°C

10.



Assembly finished.

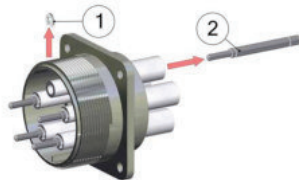
Assembly Instructions Series M (plug, panel mount)

1.



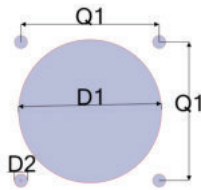
Part as supplied.

2.



Remove snap rings (1) and take out male contacts (2).

3.



Panel cut out

Connector size	Q1 mm [inch]	D1 mm [inch]	D2 mm [inch]
M3	34.90 [1.374"]	35.90 [1.413"]	3.75 [.148"]
M5	39.65 [1.561"]	42.20 [1.661"]	3.75 [.148"]
M7	44.45 [1.750"]	49.30 [1.941"]	4.40 [.173"]
M9	49.25 [1.939"]	54.90 [2.161"]	4.40 [.173"]

4.



Carefully remove cable jacket (L1 = min. 65 mm).
⚠ Do not damage metal shield braid.

5.



Fold back shield braid.

6.



Remove any filling elements from cable.

7.



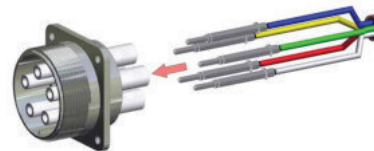
Remove dielectric insulation of single wires (L2 = 5 mm [.197"]).
⚠ Do not damage conductors.

8.



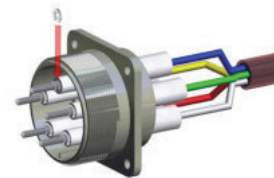
Solder one male contact (2) on each conductor.

9.



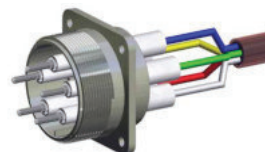
Slide single wires completely into insulation tubes.

10.



Fix male contacts (2) with snap rings (1).

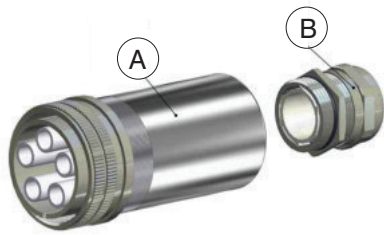
11.



Assembly finished.

Assembly Instructions Series M (receptacle, cable mount)

1.



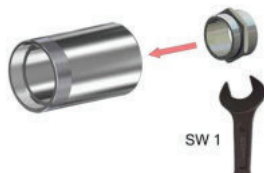
Part as supplied.
Connector housing (A)
Optional: Screwed cable gland (B)

2.



Components
Screwed cable gland (B): cap (1), sealing insert (2), cable gland basis (3)
Connector housing (A): housing adapter (4), shrinking tubes (5), housing basis (6)

3.



Screw cable gland basis (3) to housing adapter (4).

Screwed cable gland size	Wrench size (SW 1)	Tightening torque [Nm]
M16	20	6
M20	24	10
M25	30	14
M32	40	24

4.



Place cap (1), sealing insert (2) and housing adapter (4) on cable.
⚠ Respect correct order of parts (see picture)

5.



Remove cable jacket.
⚠ Do not damage shield braid.

Connector size	L1 mm [inch]
M3 / M5 / M7	45 [1.772"]
M9	60 [2.362"]

6.



Fold back shield braid over jacket.

7.



Fix shield braid with tape.

8.



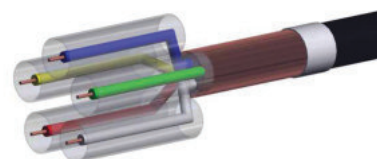
Remove any filling elements from cable.

9.



Remove dielectric insulation (L2 = min. 5 mm [.197"]).

10.



Place shrinking tubes on single wires.

11.



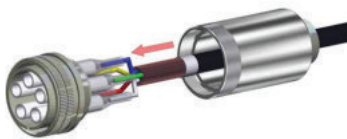
Solder one conductor each on a female contact.
 ⚠ Tin-solder should not remain on contact surface.
 Do not damage shrinking tubes.

12.



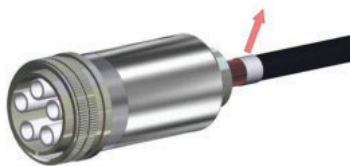
Place shrinking tubes on insulators. Tubes shall cover both insulators and wires. Then shrink tubes. Shrinking temperature 100°C.

13.



Screw adapter (4) to housing basis (6).

14.



Remove tape.

15.



Completely widen shield braid.

16.



Completely slide seal insert (2) under shield braid into cable gland basis (3).

17.



Cut overlapping shield braid.
 ⚠ Carefully remove shield strands. Loose strands can cause electrical break down.

18.



Screw cable gland cap (1) to cable gland basis (3).

Screwed cable gland size	Wrench size (SW)	Tightening torque [Nm]
M16	20	5
M20	24	8
M25	30	12
M32	40	20

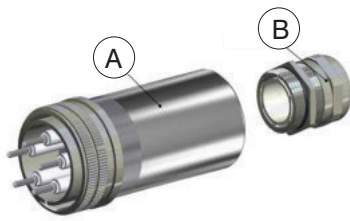
19.



Assembly finished.

Assembly Instructions Series M (plug, cable mount)

1.



Part as supplied.
Connector housing (A)
Optional: Screwed cable gland (B)

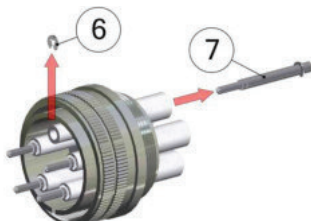
2.



Components
Screwed cable gland (B): cap (1),
sealing insert (2), cable gland basis (3)

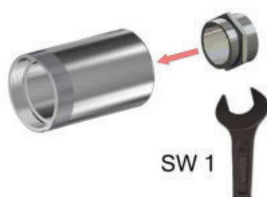
Connector housing (A): housing adapter (4),
housing basis (5)

3.



Remove contacts if supplied mounted.
Remove snap rings (6) and take out male contacts (7).

4.



Screw cable gland basis (3) to housing adapter (4).

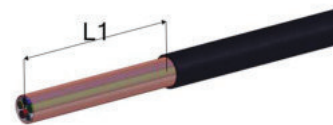
Screwed cable gland size	Wrench size (SW 1)	Tightening torque [Nm]
M16	20	5
M20	24	8
M25	30	12
M32	40	20

5.



Place cap (1), sealing insert (2) and housing adapter (4) on cable.
⚠️ Respect correct order of parts (see picture).

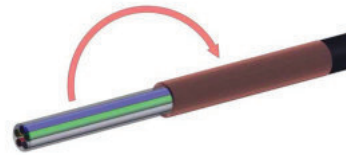
6.



Fold back shield braid over jacket.
⚠️ Do not damage shield braid.

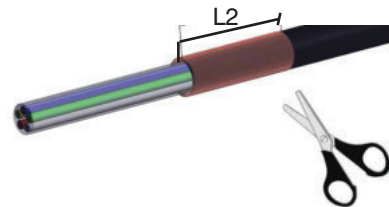
Connector size	L1 [mm]
M3 / M5 / M7	70 [2.756"]
M9	85 [3.346"]

7.



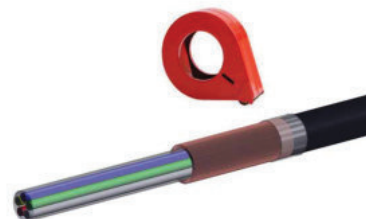
Fold back shield braid over jacket.

8.



Shorten shield braid to length L2 = 40 mm.

9.



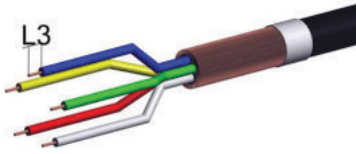
Fix shield braid with tape.

10.



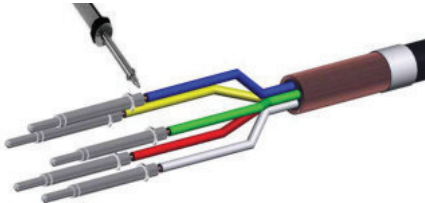
Remove any filling elements from cable.

11.



Remove dielectric insulation
(L3 = min. 5 mm [.197"]).

12.



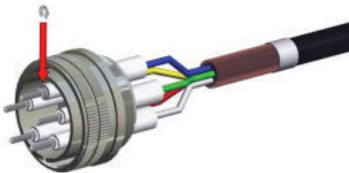
Solder male contacts (7) on conductor.
⚠ Tin-solder must not remain on contact surface.

13.



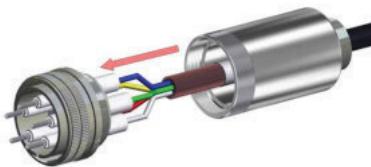
Slide contacts (7) completely into insulation
tubes (5).

14.



Fix contacts (7) with snap rings (6).

15.



Screw adapter (4) to housing basis (5).

16.



Remove tape.

17.



Completely widen shield braid.

18.



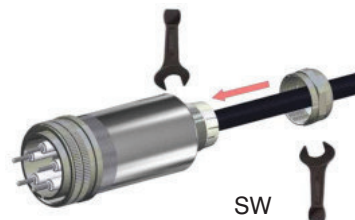
Completely slide seal insert (2) under shield braid
into cable gland basis (3).

19.



Cut overlapping shield braid.
⚠ Carefully remove shield strands. Loose strands
can cause electrical break down.

20.



Screw cable gland cap (1) to cable gland basis (3).

Screwed cable gland size	Wrench size (SW)	Tightening torque [Nm]
M16	20	5
M20	24	8
M25	30	12
M32	40	20

21.



Assembly finished.