Assembly Information

1. Cable Requirements

1.1 Cable O.D. range (strain relief guaranteed): \( \varnothing 4 \text{ mm} - \varnothing 7 \text{ mm} \)

1.2 Wire gauge (IDC width): AWG 24 (0.22 mm\(^2\)) to AWG 26 (0.14 mm\(^2\))

1.3 Wire insulation outside diameter: \( \varnothing \leq 1.5 \text{ mm} \)

2. Cable Preparation

- Assemble bushing and chuck onto the cable
- Strip the jacket of the cable as shown (≈ 20 mm)
- Twist the shield carefully
3. Assembly

- Insert the wires into contacts ‘2’ + ‘3’ up to the inner stop (around 12 mm) and after what lift the ground contact and insert the twisted shield strands under the contact element.
- Press the IDC contacts with your fingers and then force the chuck over completely up to the stop face.

Note: There are two possible positions the chuck can be assembled. You can choose whether or not the housing will be grounded (connected to contact ‘1’) by rotating the chuck 90°.

- Push the housing onto the insert and screw on the bushing.

Available IDC Assembly Tools

- HTY (hand)
- BTY (bench)
- ATY (machine)