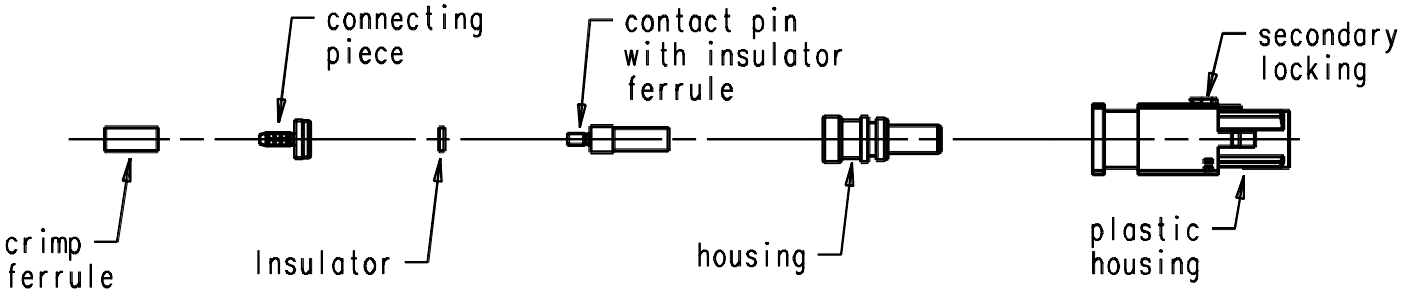
M-156

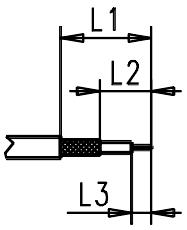
Assembly Instruction

IMS CONNECTOR SYSTEMS

Date: 14.12.04
Rev.: b

For the part number 3403.SMBA.1E10.049 please use the cable stripping on the outline drawing.

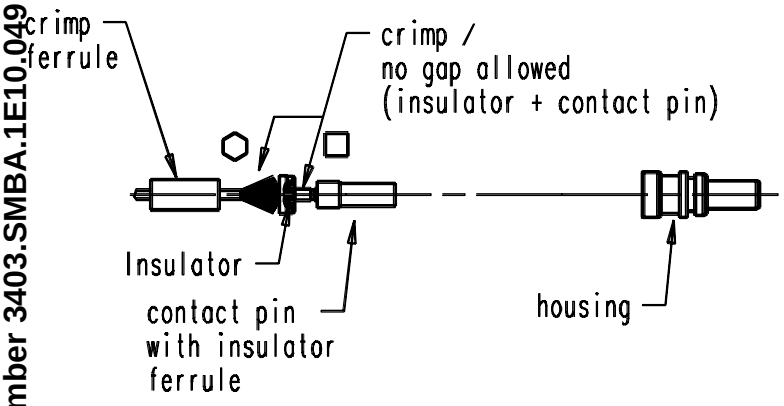




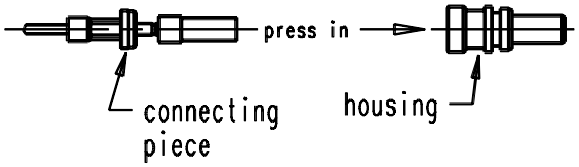
Y= Variable	Cable type	L1	L2	L3
1	Nexans ET 124899	10,3	4,6	2,5
4	Hirose U.FL-LP-066	10,3	4,6	2,5

Cable stripping as shown in the picture. Dimensions according to the table.

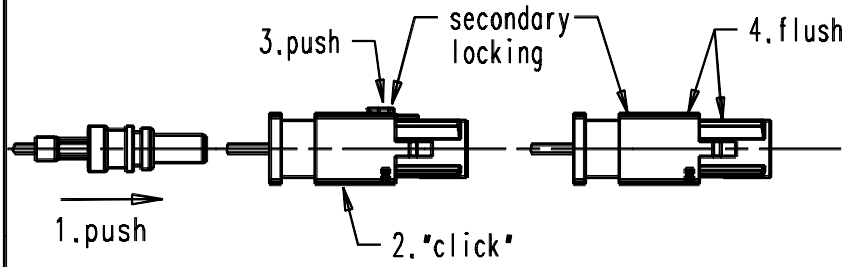
Please be careful when handling the cable and do not damage the braid, dielectric or center conductor.



Put the braid over the crimpneck and fit the center conductor of the cable into the contact pin. No gap allowed between insulator and contact pin. Crimp the contact pin by using the square size or crimp die listed in the table below. Push the crimp ferrule over the braid. Crimp the ferrule with the hex size or tool listed in the table below.



Carefully press the pre-assembled connecting piece into the housing.



Push the preassembled connector into the plastic housing until you feel and hear a "click".
Push the secondary-locking into the plastic housing until it is flush with it.

Y= Variable	Cable type	outer contact ⬡ hex-Crimp size	outer contact ⬡ hex-Crimp length	center contact □ square-Crimp size	center contact □ square-Crimp length	Crimp die IMS-number
1	Nexans ET 124899	2,67	4	1,23	1,5	AGK-3573-10
4	Hirose U.FL-LP-066	2,67	4	1,23	1,5	AGK-3573-10