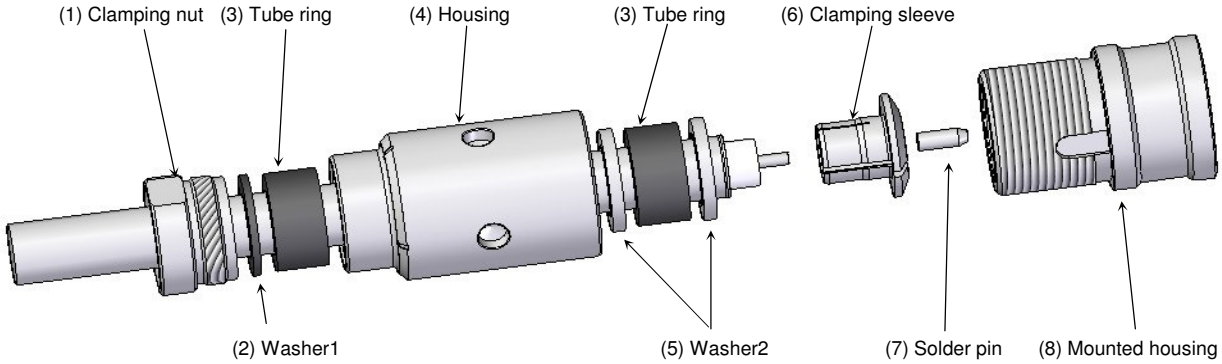
For the part number 4223.DNS.1110.389 please use the cable stripping on the outline drawing.

Assembly Instruction

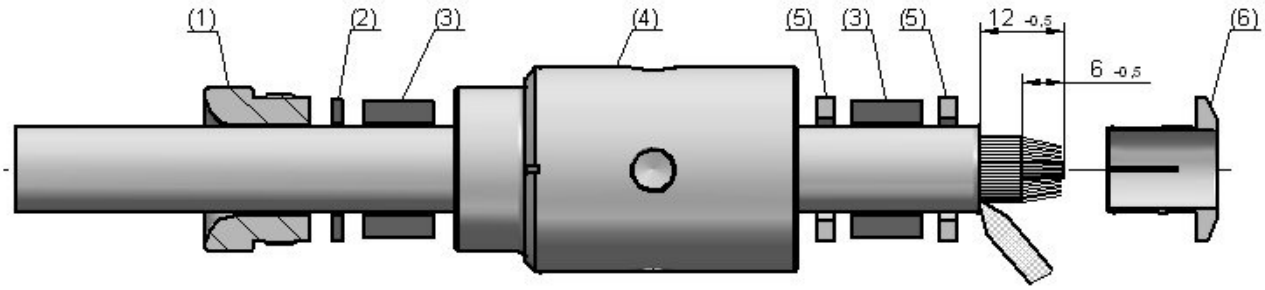
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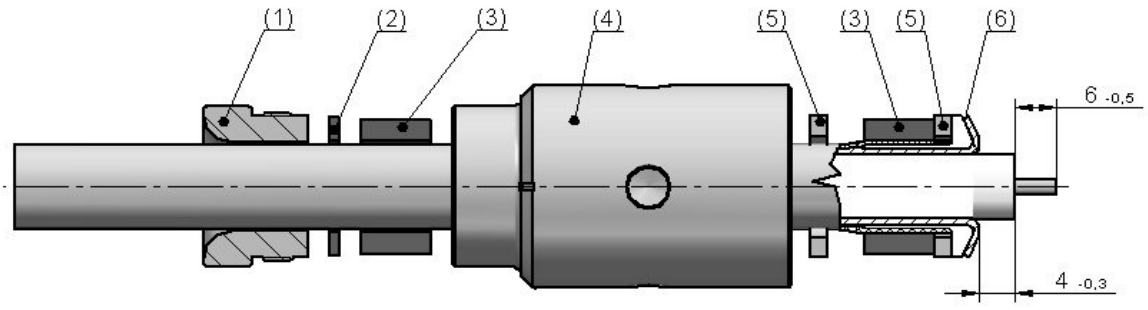
Number:	**M-223**	Date:	**2007.01.25**
Description:	**Cable mount plug**	Signature:	**Pölz N.**
		Page:	1 of 2



Recomended tools: Sheath splitting knife, shear, soldering iron, little file, brush, hook wrench DIN 1810 25-28A and 30-32B, open-ended wrench WA22



Put parts (1)-(5) onto cable. Remove 12mm of the cable jacket. Adjust braid, bend it backwards and shorten dielectric for round about 6mm. Adjust braid forward and squeeze it conical together. Expand cable jacket.



Push Clamping sleeve (6) over the braid and under the widened cable jacket. Put braid equally around part 6, adjust and cut it. Check dimension 4-0,3mm. Tin-plate cable center contact.

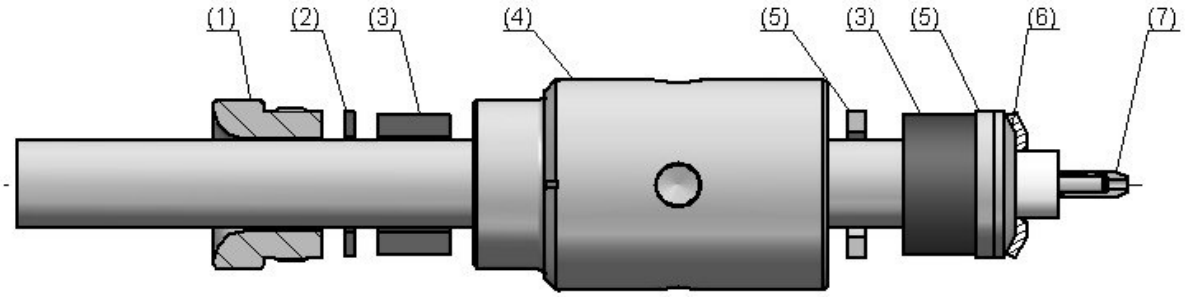
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Assembly Instruction

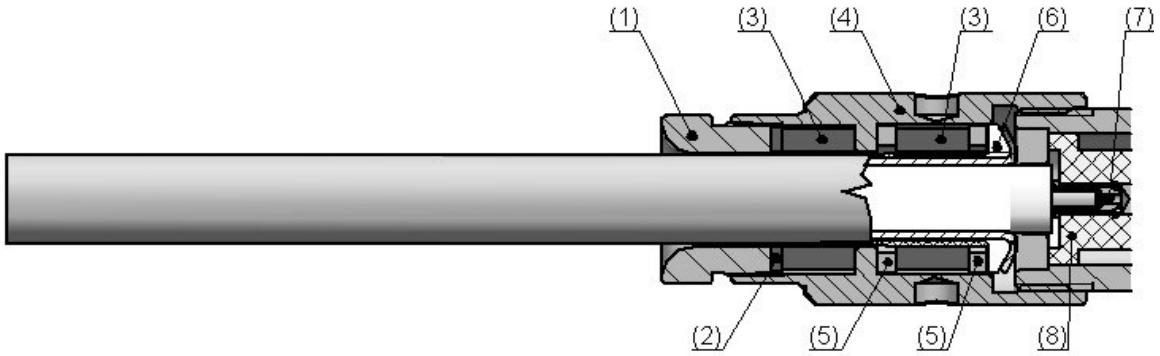
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		Page:	2 of 2



Put solder-pin (7) onto cable center contact and solder.Remove leaked solder tin. There shouldn't be a gap between solder pin and the cable insulator.



Put the mounted housing (8) on pre-mounted cable.Screw down part (4) and (8). After that screw down part (1) and part (4) A screw locking device (e.g. Loctite) should be used for both threads.