



**1**

Cut cable end and place the shrinkable strain relief and the ferrule over cable (fig1)

- Strip the outer jacket back on 7 mm. Trim away the braid at the edge of jacket.
- Strip the outer jacket back a further 8 mm

**FIG 1**

**2**

Fold back braid onto the cable and trim both fillers. Cut and pre-strip conductors as shown in fig2.

**FIG 2**

**Double check the stripping lengths.**

**3**

Remove the dielectrics of the wires and insert conductors inside contacts :  
White conductor in central contact, blue conductor in one of the holes of the intermediate contact.

(\*) *Note* : Color convention can be changed

**4**

Install the crimp die "AX-CD-02" or "AX-CD-03" into crimping tool "M22520/5-01". Insert contact assembly, with cable conductors in place, against the round die cavity shoulder.

**Line up center contact crimping pins with clearance holes.(fig3 & fig4).**

**FIG 3**

**5**

Slide the insulator over the wires into the gap between the contact assembly and the braid.

Using the insulator, snap the contact assembly into connector body until a retention is obtained (lightly pull the cable to check it)

**FIG 4**

**After crimping :**  
**Check that the clearance length behind the contact is less than 0.8mm.**  
**No defect due to the crimping allowed in/around the clearance holes.**

*Note* : "AX-CD02" dies are used with straight versions of connectors and "AX-CD03" with elbow versions

**6**

Fold braid forward over the crimp area of the connector body. Slide the ferrule over the braid and the connector body. Crimp the ferrule using the hexagonal cavity of the die.

**Note** : "AX-CD02" dies are used with straight versions of connectors and "AX-CD03" with elbow versions

**7**

Bring and shrink the strain relief over the connector body as shown below:

For PG connector, set the shrinkable relief between 2 and 3 mm after ferrule.

For right angle version, shrink the strain relief and tie the ty-rap as shown below: