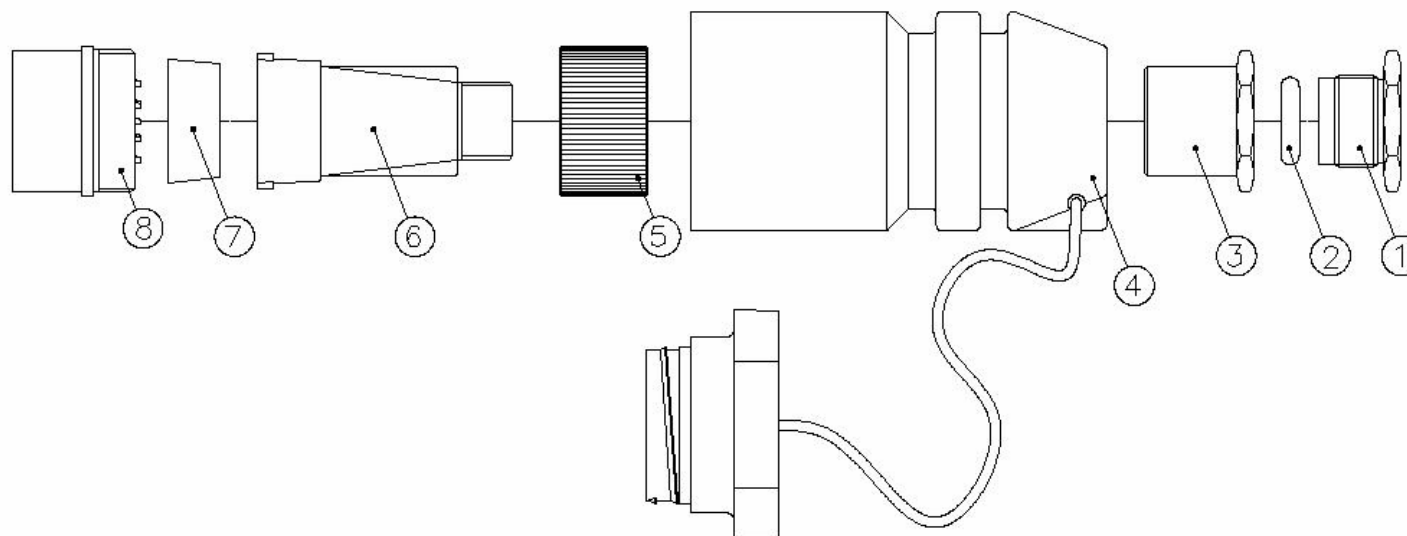


Assembly and Wiring Instructions of Free Intervehicle Connectors

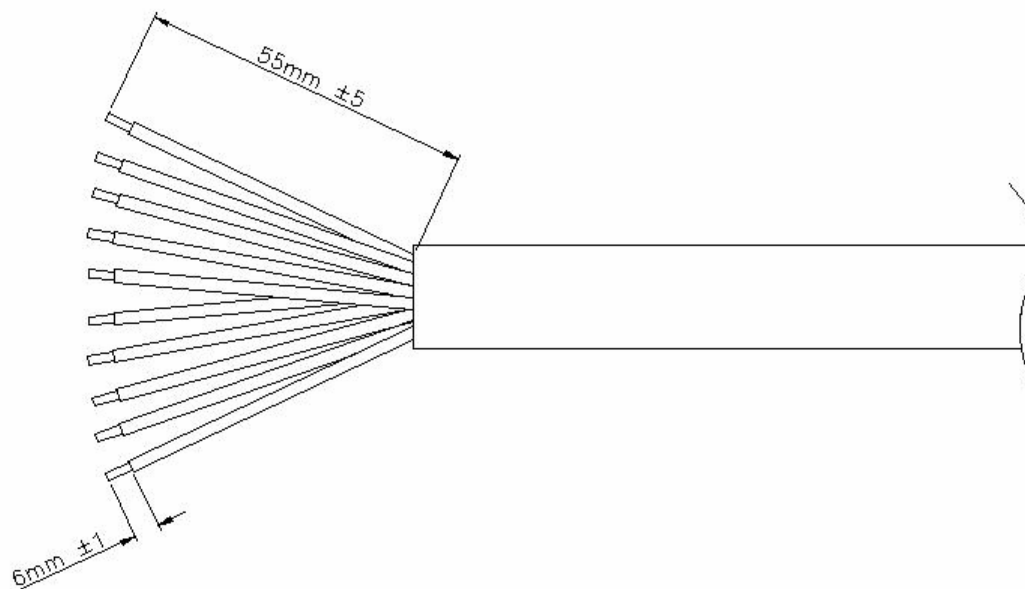
Fig. 1. Contents of connector assembly as packaged.



Item	Description
1	Cable clamp nut
2	Cable clamp grommet
3	Cable clamp liner
4	Protective sheath and cap assembly
5	Grommet nut
6	Follower
7	Grommet
8	Free shell assembly (pin)

Fig. 2. Conductor preparation.

Strip individual conductors as shown in the diagram below

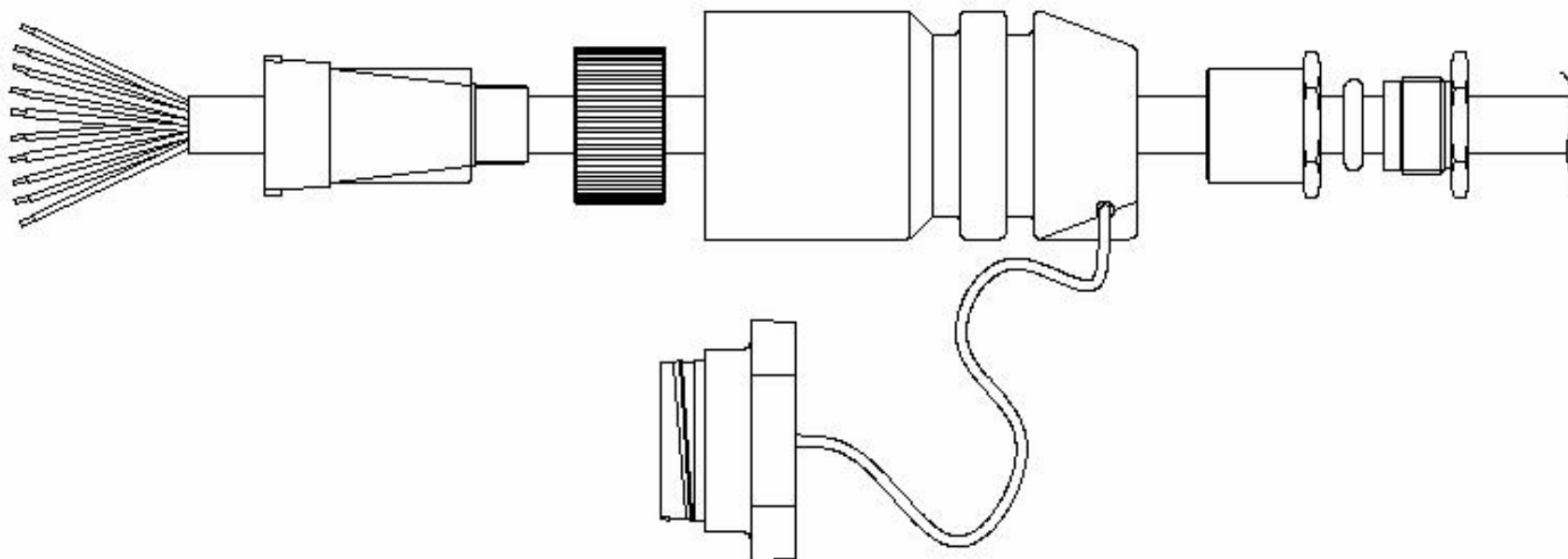


After Stripping, leave the end of the insulation clean and square. Should the lay of the strands be disturbed, correct it with a light twist.

Note: a stripped conductor with 'nicked' or cut strands is not acceptable. Ensure the conductor is clean before tinning.

Tin individual stripped conductors to prevent strands becoming separated and damaged during connector assembly.

Fig. 3. Preliminary positioning of connector components on cable.



Feed cable through connector components as shown in diagram.

Note: Grommet nut (item 5) threaded end should be on same side as prepared end of cable. Check components are positioned on cable in the correct order and orientation before continuing.

Fig. 4. Alignment of conductors, free shell assembly and grommet.

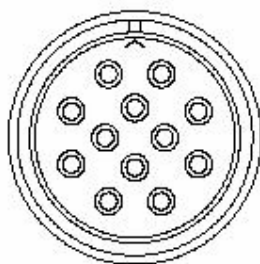


Fig. 4a

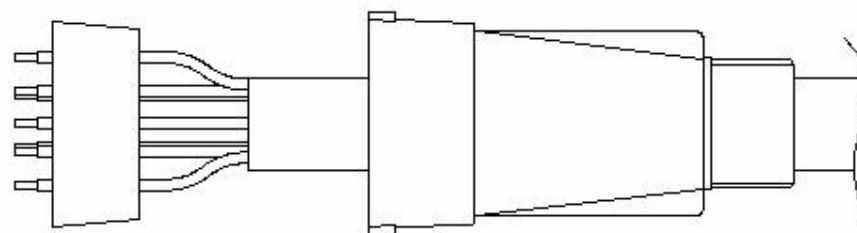
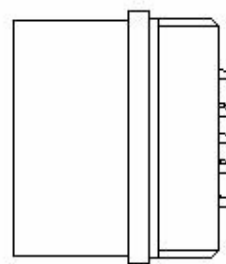


Fig. 4b

Establish terminal positions of individual conductors in free shell assembly.

Position grommet against free shell assembly so that holes and identification mark are in alignment. (see fig. 4a)

Ensure grommet is orientated correctly i.e. taper direction will allow grommet to seat correctly in follower. (see fig. 4b)

Insert individual conductors through correct holes in grommet leaving enough stripped ends of conductors exposed to allow soldering.

Fig. 5. Soldering of conductors to free shell assembly.

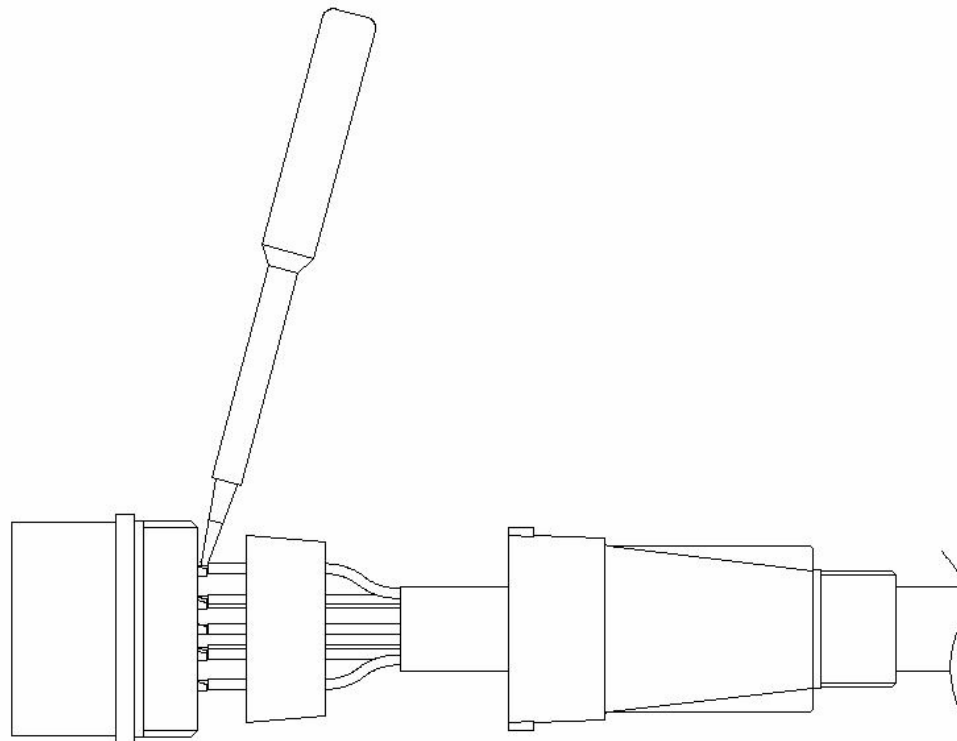


Fig. 6. Positioning of free shell assembly, grommet and follower.

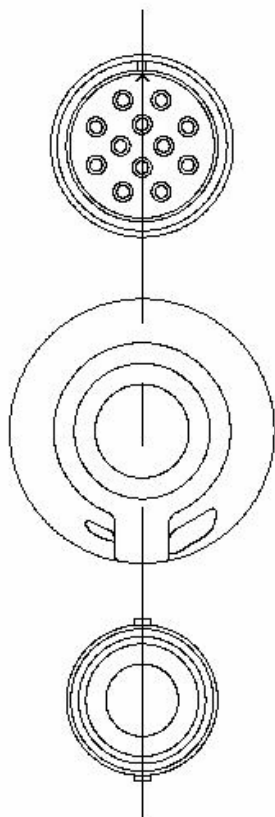


Fig. 6a.

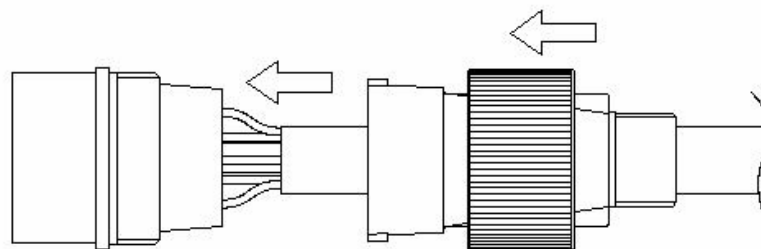


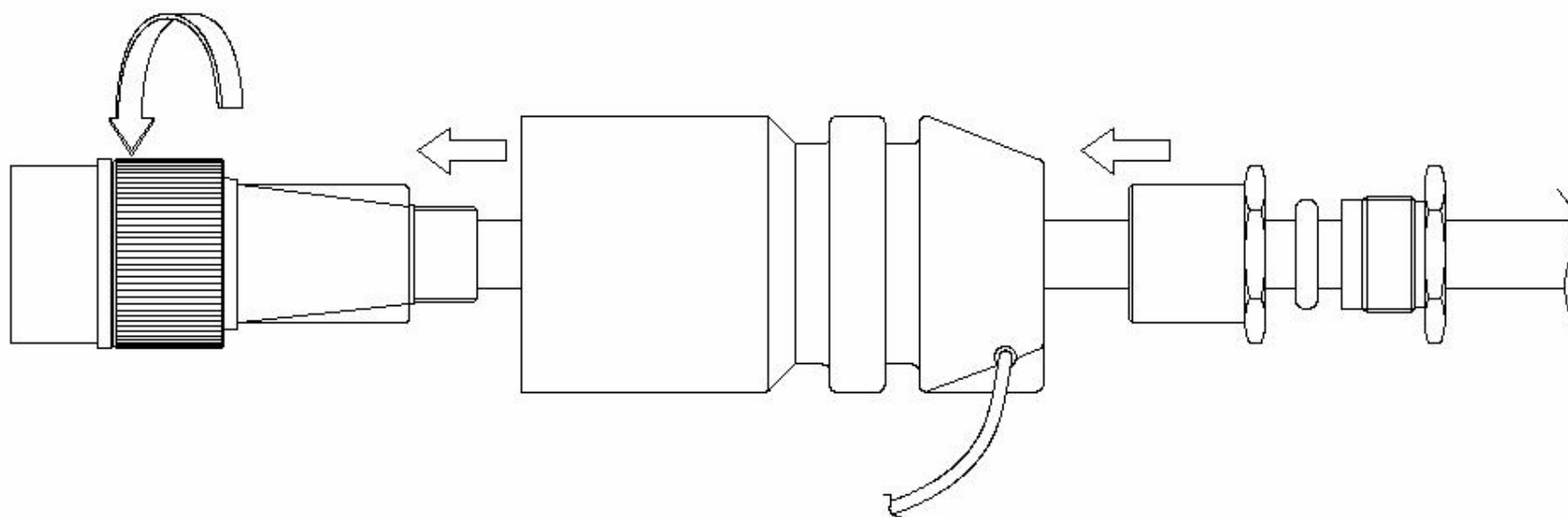
Fig. 6b.

Slide grommet along wires until flush with rear of free shell assembly.

Move follower along cable and push over grommet until seated snugly.

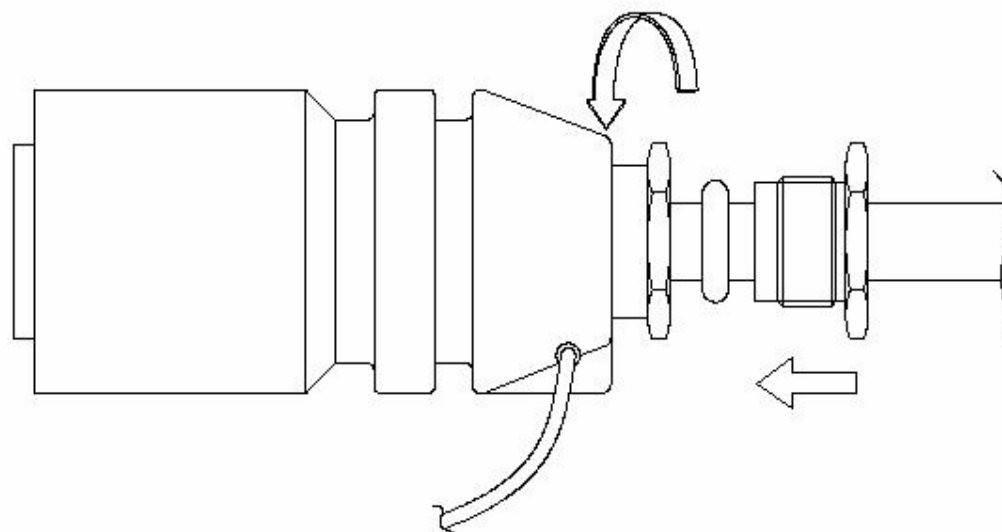
Note: Ensure correct alignment of follower key with keyway in free shell assembly.

Fig. 7. Coupling of grommet nut and insertion of connector assembly into protective sheath.



Slide grommet nut over follower and screw onto free shell assembly. Tighten with firm hand pressure. Move protective sheath over connector assembly. **Note:** ensure correct alignment of parts by rotating sheath so that the main connector keyway is at the opposite side to the cord-fixing lug on sheath. (See Fig. 6a for end on view of correct orientation of parts.) This will allow protective cap and cord to hang vertically when coupled with mating fixed connector.

Fig. 8. Coupling of connector with cable clamp liner.



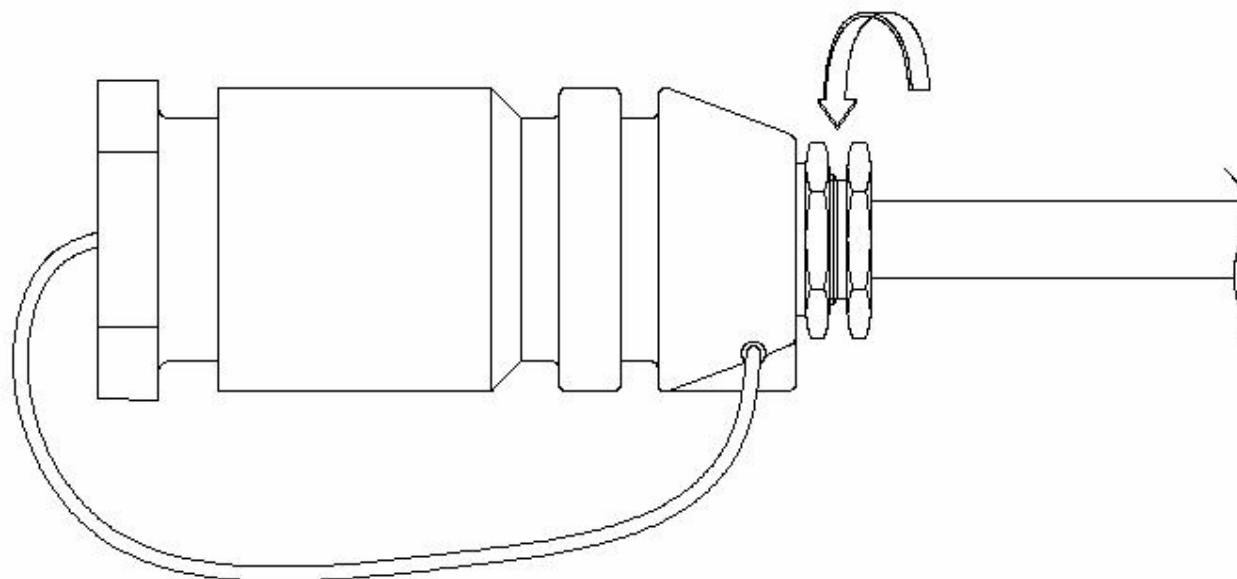
Insert cable clamp liner into protective sheath while pushing against front face of connector assembly.

Screw in cable clamp liner by hand and tighten using appropriate spanner. Do not over tighten.

Insert cable clamp grommet into cable clamp liner and screw in cable clamp nut until hand tight.

Note: Ensure cable is not under strain or subjected to rotation or twisting during this operation.

Fig. 9. Tightening of cable clamp nut. Assembly complete.



Tighten cable clamp nut using two spanners. Insert protective cap into sheath when connector is not mated. Connector assembly is now complete.