



Member of the Phoenix Contact Group

**rde Connectors & Cables, Inc.**

## **Assembly instructions for HC-Style 8, 9, R, F, Q UC-Style 8, 9, R, F, Q TU-Style 8U, 9U**

**Disclaimer:** rde Connectors & Cables, Inc., cannot be held liable for failure to follow these instructions properly or for accidents that may occur during assembly.

### **STEP 1 - CONNECTOR & TOOL**

First, make sure you have all you need: (1) the assembled connector as shipped from us; and (2) the assembly tool. Instead of an assembly tool, you can also use two wrenches (24 mm).

The following picture shows HC-Style 8 / UC-Style 8; HC-Style R / UC-Style R; TU-Style 8U; and the assembly tool.



The following picture shows HC-Style 9 / UC-Style 9; HC-Style F / UC-Style F; HC-Style Q / UC-Style Q; TU-Style 9U; and the assembly tool.



## STEP 2 - DISASSEMBLED INTO PARTS

Disassemble the connector into its component parts. Pictured here are the parts of a UC-Style 8. (For UC-Style 9, the only difference is a male thread instead of a coupling nut.)



### STEP 3 - SEAL RING

First, measure the cable diameter and pull out the inner seal rings to correspond with the diameter of your cable.



#### **STEP 4 - PREPARING THE CABLE**

Slide the endbell, the seal ring, the shielding cage, and the shielding bell over the jacket. For styles R and F, the cable gland must also be slid over the cable, before the endbell.



#### **STEP 5 - STRIPPING OFF THE JACKET**

Strip off the jacket at a length of 50 mm (2 inches). Pull back the shielding braid (flip it backwards) and, if desired, tape it to the jacket with a piece of scotch tape so you will be able to assemble the wire ends more easily.



#### **STEP 6 - REMOVAL OF FILLING MATERIALS**

Cut out any filling materials.





#### **STEP 7 - CUTTING THE WIRES**

Cut the wires to a length of 30 mm (1.2 inches). If possible, try to slide the jacket back another 10 mm (0.5 inches).



#### **STEP 8 - STRIPPING THE WIRE ENDS**

Strip the wire ends according to the contacts you use.



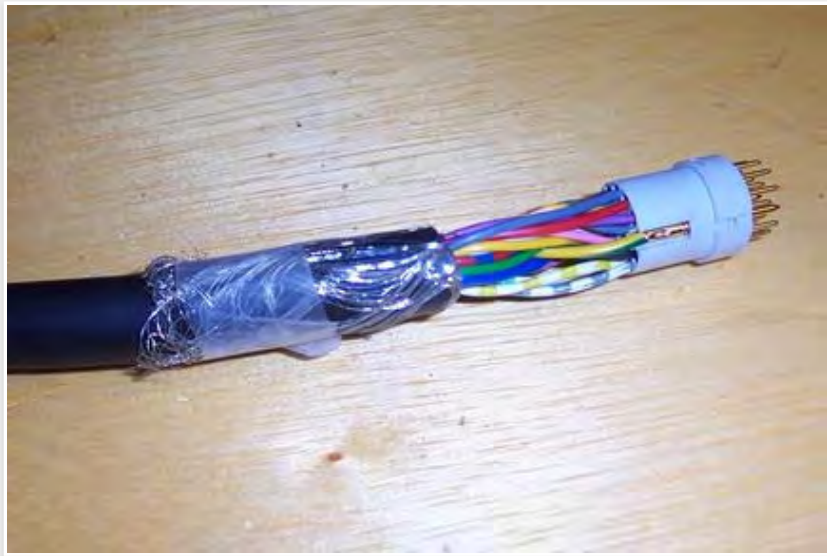
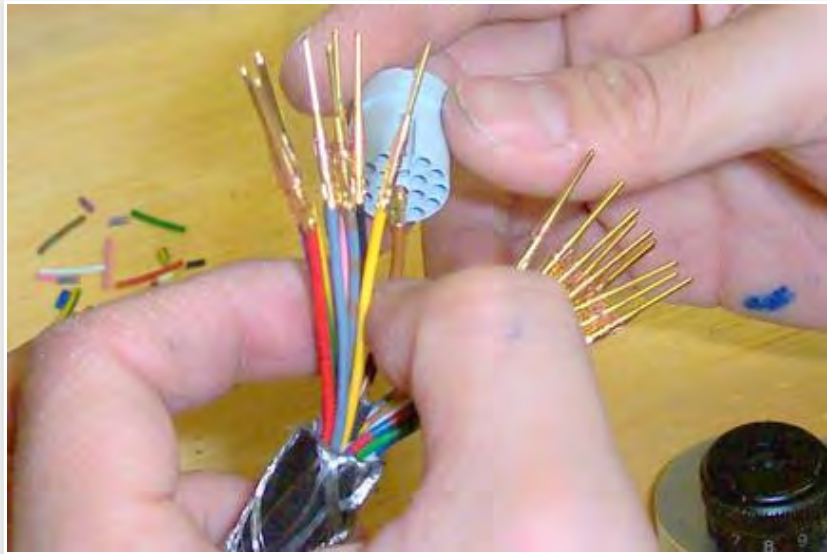
#### **STEP 9 - CRIMPING**

Crimp the pins or sockets onto the wire ends.



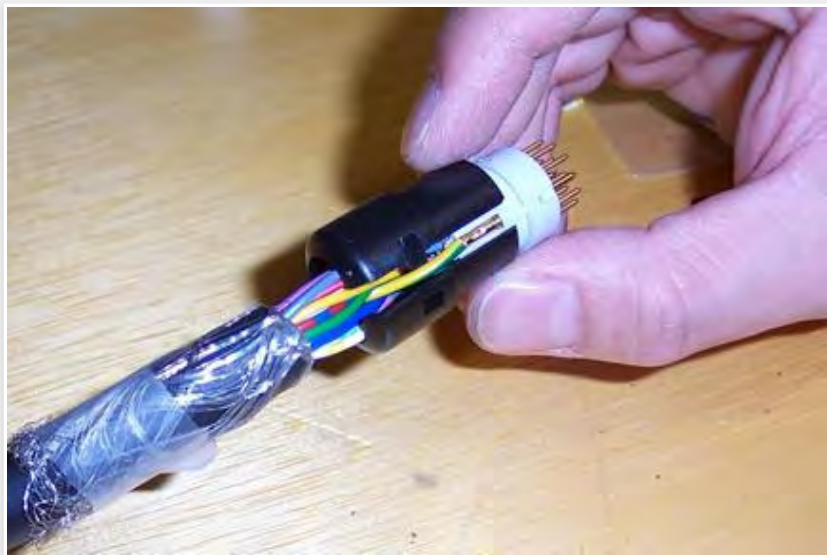
#### **STEP 10 - INSERTING THE CONTACTS**

Click the contacts into the connector insert, one by one.



#### **STEP 11 -- CLIPPING ON THE PLASTIC COVER**

Fold the black collapsible plastic cover around the connector insert. The cable end with the connector insert is now ready to assemble with the housing.







#### **STEP 12 - PUTTING ON THE FRONT PART OF THE CONNECTOR BODY**

Put the front part of the connector body onto the assembled end, with the coupling nut style 8/R, or with the male threaded end style 9/F/Q. (Also, now take off the scotch tape you may have used to hold back the shielding braid.)



#### **STEP 13 - CUTTING THE SHIELD**

Now cut the shield wires around the edge of the connector opening as shown.





#### **STEP 14 - PUSHING THE SHIELDING BELL INTO THE BODY**

Push the shielding bell into the connector body to ensure that the shielding wires are connected to the connector shell.



The following picture shows the same with style 9/F/Q.



#### **STEP 15 - ADJUSTING THE JACKET**

If necessary (and if possible), push the jacket back into the connector body as much as possible



#### **STEP 16 - USING THE ASSEMBLY TOOL (or Wrench)**

Push the assembly tool into the connector insert as shown and hold the connector in place in this manner. Alternatively, you can also hold the flats of the connector front part with wrenches.



The following picture shows the same with style 9/F/Q.



#### **STEP 17 - BLACK CAGE AND ENDBELL**

Push the black cage into the opening to hold and press the shielding material; then push the endbell over it and screw it onto the thread.





#### **STEP 18 - READY FOR TIGHTENING**

The connector is now assembled and ready to be tightened--using either the assembly tool and one wrench, or two wrenches (size 24 mm).



The following picture shows the same with the male threaded front part.



#### **STEP 19 - TIGHTENING**

Tighten the endbell of the connector. Remember you can also use two 24-mm wrenches instead of the assembly tool. The assembly tool has the advantage of allowing the connector to be put in a vise.



#### **DONE!**

The connector has been assembled.



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