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rde Connectors & Cables, Inc.

Assembly Instructions for SF-Style 80DU, 8020, 8LDL, 8L20 SF-Style 90DU, 9020, 9LDL, 9L20

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) two wrenches of size 26 mm.

The following picture shows SF-Style 80DU and the assembly tools (wrenches). Styles SF-80DU, 8020, 8LDL and 8L20 have a coupling nut, whereas Styles SF-90DU, 9020, 9LDL and 9L20 have male threads at the top instead of a coupling nut, but the assembly is practically the same.



STEP 2 - DISASSEMBLED INTO PARTS

Disassemble the connector into its component parts. Pictured here are the parts of an SF-Style 80DU.



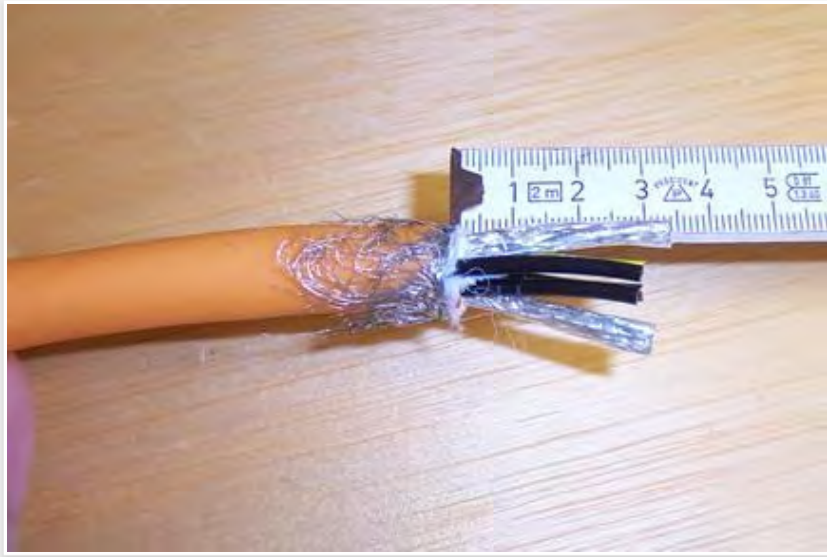
STEP 3 - STRIPPING OFF THE JACKET

Strip off the jacket by about 65 mm (2.5 inches) and fold the shield backwards to expose just the wires.



STEP 4 - CUTTING THE WIRES

After pulling back the shield (as shown), cut the wires by about 30 mm (1.2 inches).



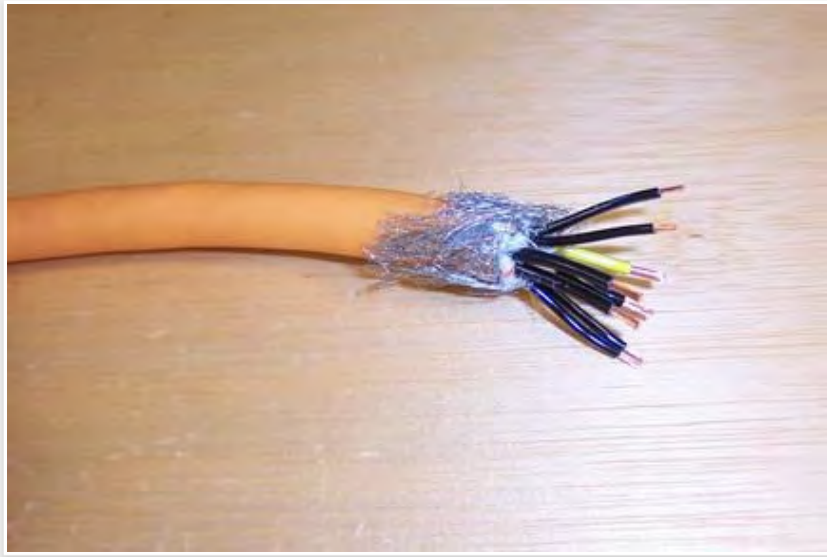
STEP 5 - PREPARING THE CABLE

Slide the endbell, seal ring, and shielding cage over the cable, as shown.



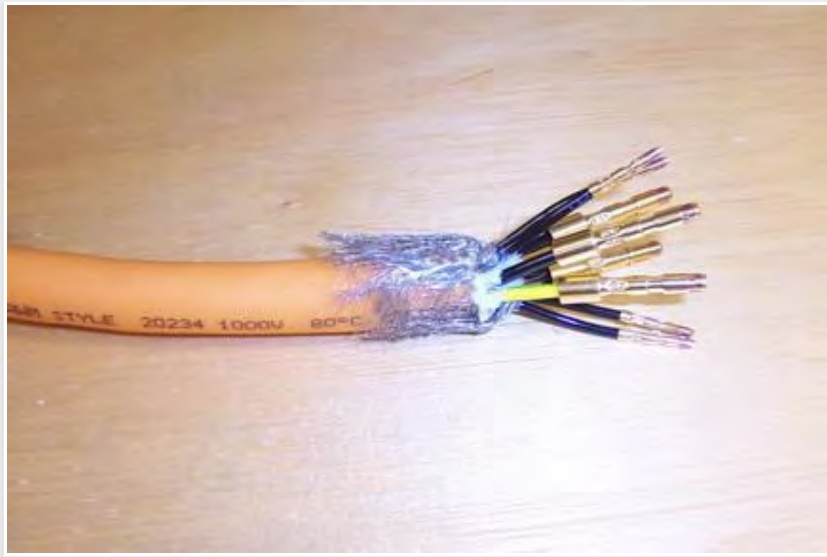
STEP 6 - STRIPPING THE WIRE ENDS

Strip the wire ends according to the contacts you use.



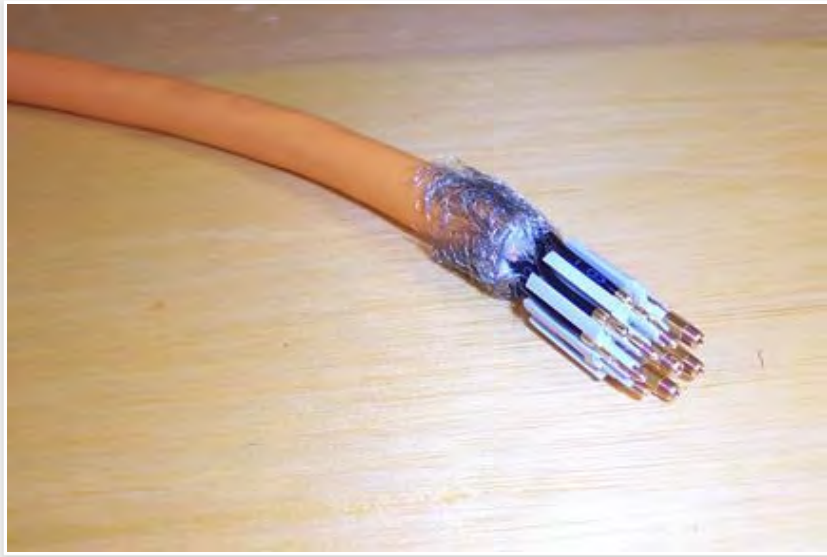
STEP 7 - CRIMPING

Crimp the pins or sockets onto the wire ends.



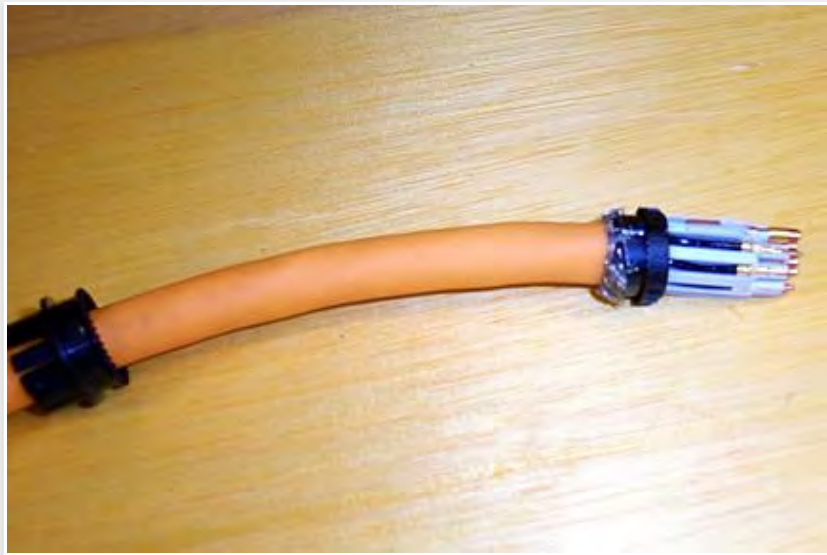
STEP 8 - ADDING THE CONTACTS

Clip the contacts into the contact holder, as shown.



STEP 9 - PREPARATION FOR FINAL ASSEMBLY

Slide the seal ring and shielding elements back to the contact holder.



STEP 10 -- FINAL ASSEMBLY

Slide the connector insert with the clipped-in contacts into the connector housing. Make sure you watch the coding.



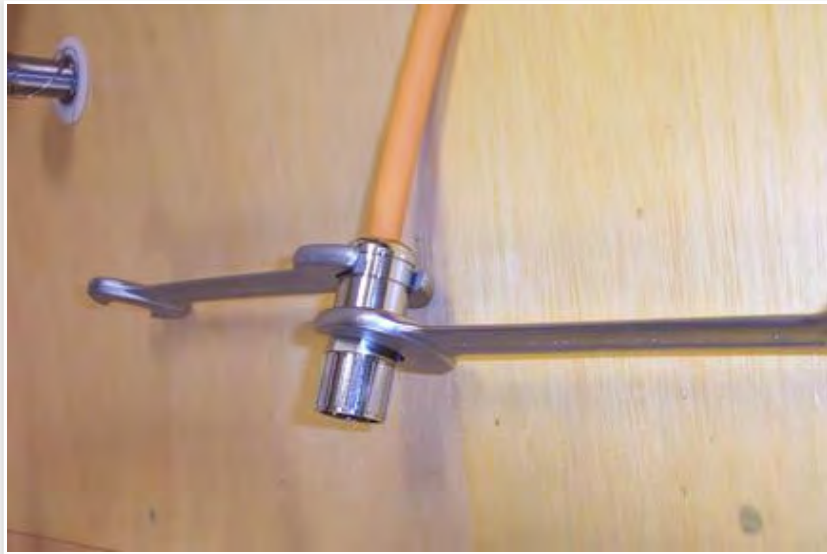
STEP 11 - ADDING THE ENDBELL

Turn the endbell onto the housing thread.



STEP 12 - TIGHTENING

Tighten the connector and endbell with wrenches, as shown.



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