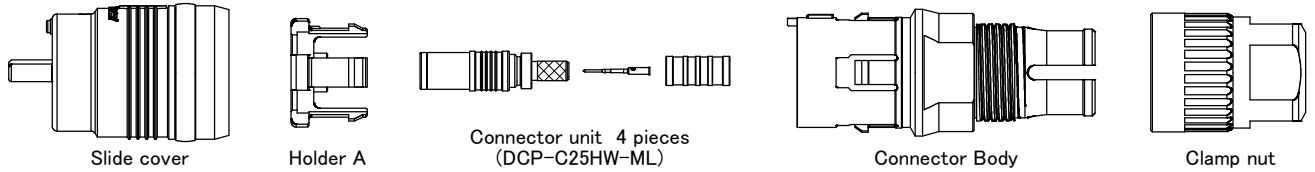
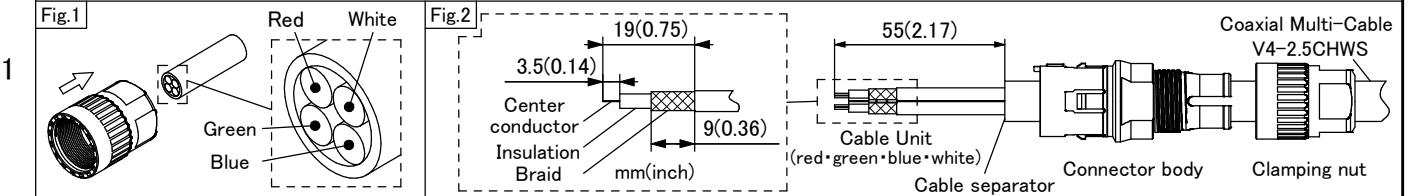


<Nomenclature>



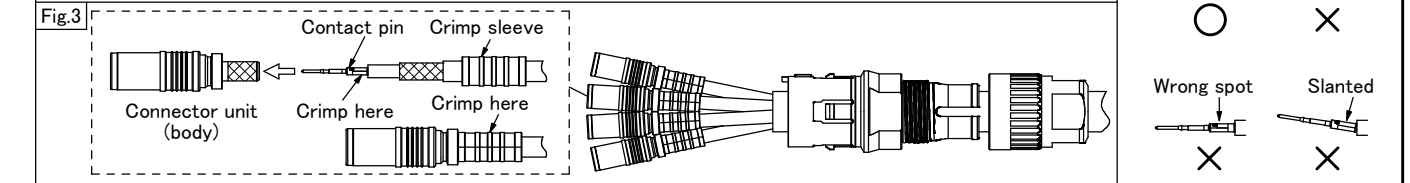
<Tools to Use> Crimping tool: TC-1 (tool), TCD-D253F (die) / Open-end wrenches: 21mm and 20mm (one each)

- a. Slide the clamp nut and connector body over the V4-2.5CHW Coaxial Multi-Cable (Fig. 2). Note the correct cable direction. (Fig. 1).
- b. Strip the ends of the multi-cable leads according to the lengths shown in Fig. 2 (cut away the cable separator at its base).

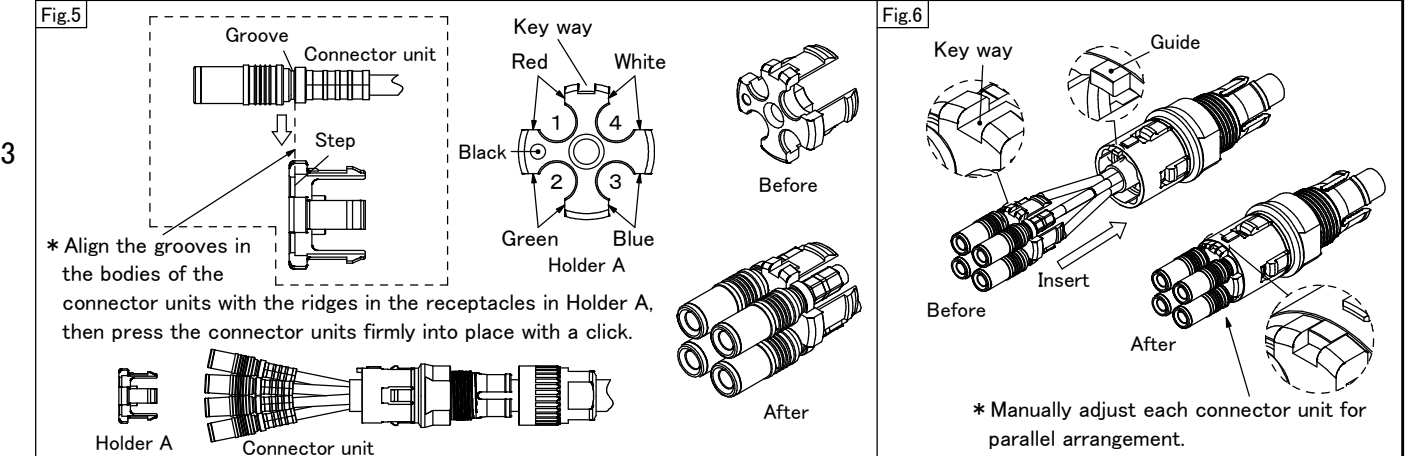


- a. Slide the connector unit crimping sleeves over each of the 4 colored leads. Slide a contact pin onto the end of each lead and crimp into place using the crimping tool (Fig. 3).  
NOTE: (1) Verify the correct crimp method by measuring the crimp height. Crimp height value: 1.08~1.16mm. If measured results are outside this range, readjust the crimping tool.  
(2) Avoid crimping the raised ridge portion of the contact pins. (3) No gap must be visible between each contact pin and its lead's insulation. (4) If a contact pin appears slanted after crimping, straighten it before continuing on to assembly (Fig. 4).

- b. Insert each contact pin into its connector unit until it clicks into place.  
NOTE: Pull lightly on each lead (4.9~9.8N·m) to ensure that the contact pin is locked into place.
- c. Slide each crimping sleeve up over the back of its connector unit, then crimp into place using the crimping tool.



- a. Insert connector into Holder A (Fig. 5).  
NOTE: Make sure to match the color of each connector unit lead with its corresponding color slot in Holder A.
- b. Lining up the internal tab in the connector body with its corresponding key way in Holder A, slide the connector body into place over Holder A. (Fig. 6).  
NOTE: The tabs around the circumference of Holder A must snap into place under the corresponding clips in the connector body.



- a. Lining up the arrow mark on the slide cover with the key tab on the connector body, slide the cover fully over the connector body until it locks firmly into place. (Fig. 7).  
NOTE: (1) The slide cover must not pull free from the connector body. (2) The slide cover must slide smoothly onto the connector body.
- b. Holding the connector body with the 21mm open-end wrench, tighten the clamp nut onto the back end of the connector using the 20mm open-end wrench (torque: 5~6N·m). (Fig. 8).

