

Assembly Type Connector Instructions

For Use with Part Numbers:

Hand Tool:	55-00096
Connectors:	55-00050
	55-00051

Materials Needed

Assembly Connector

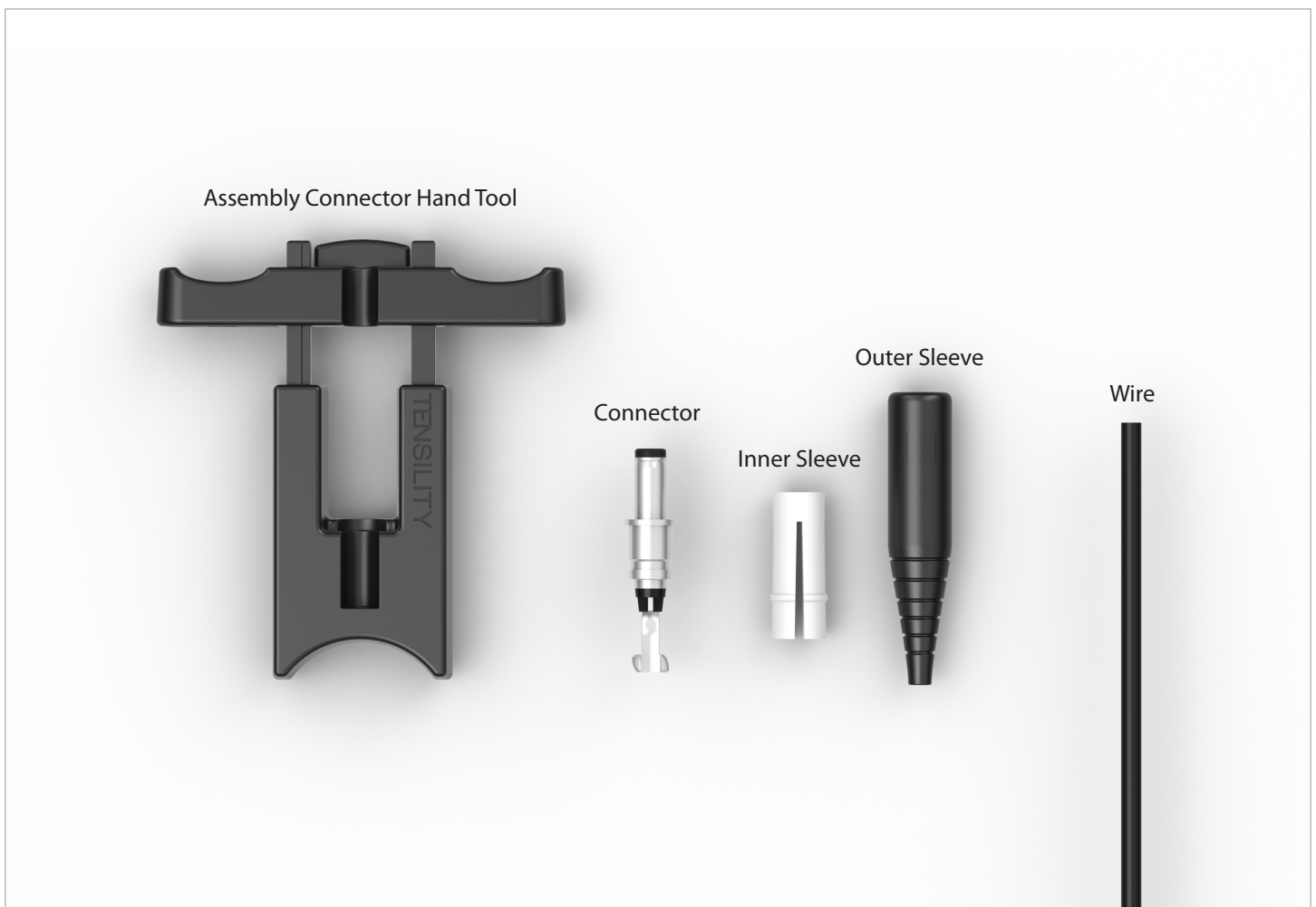
- Inner Sleeve
- Outer Sleeve
- Connector

Tools

- Assembly Connector Hand Tool (55-00096)
- Pliers (or other hand crimping tool)
- Wire stripping tool

Wire

- Round wire 2.5-5 mm outer diameter in desired length



1. Strip 10 mm off of the blunt end of the jacket.



2. Cut the negative insulated wire to 6 mm.



If using 1C shielded wire, process to the same 6 mm length.

3. Strip 5 mm of insulation off of the positive wire.



4. Strip the insulation on the negative wire as close to the base of the outside jacket as possible.

5A. Locate the outer sleeve, and notice that the notches are numbered with the wire outer diameter measurement.

5B. Find your desired wire diameter and cut outer sleeve at the notch above the number.

Ex: This wire is 3.5 mm in diameter, so it was cut on the line above 3.5.

Tip: Round up to the nearest number if the wire's outer diameter is not available. For example, a wire that is 3.25 mm outer diameter will fit into the 3.5 mm notch, but not the 3 mm notch.



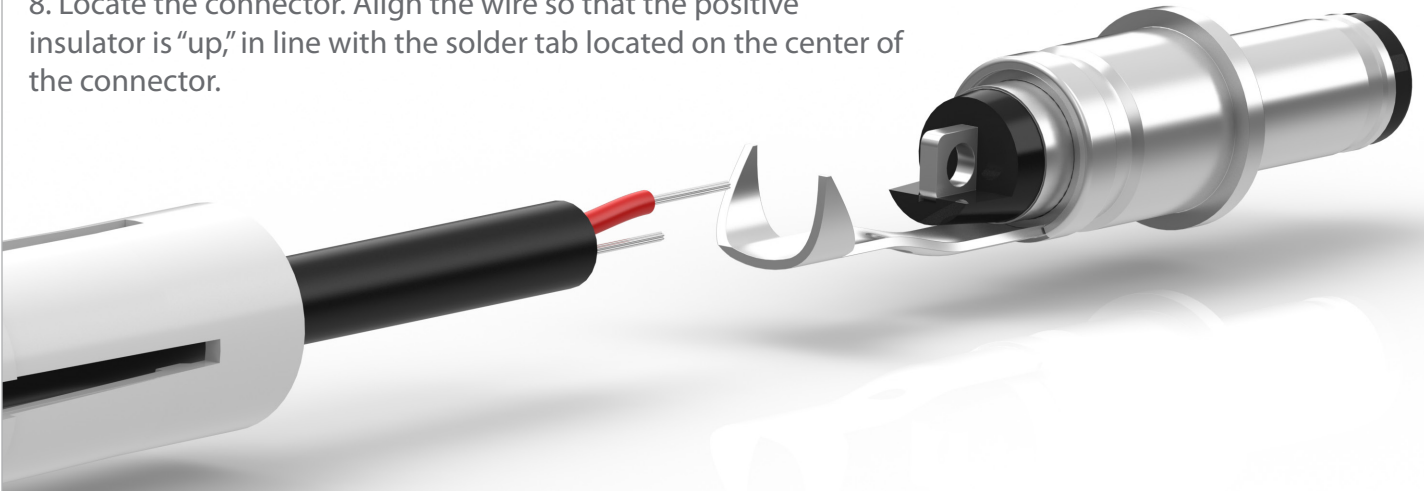
6. Thread wire through the base of the outer sleeve, stripped end first.



7. Place the inner sleeve over the stripped wire ends with the raised ring closest to the outer sleeve. Do not press it into the black outer sleeve.

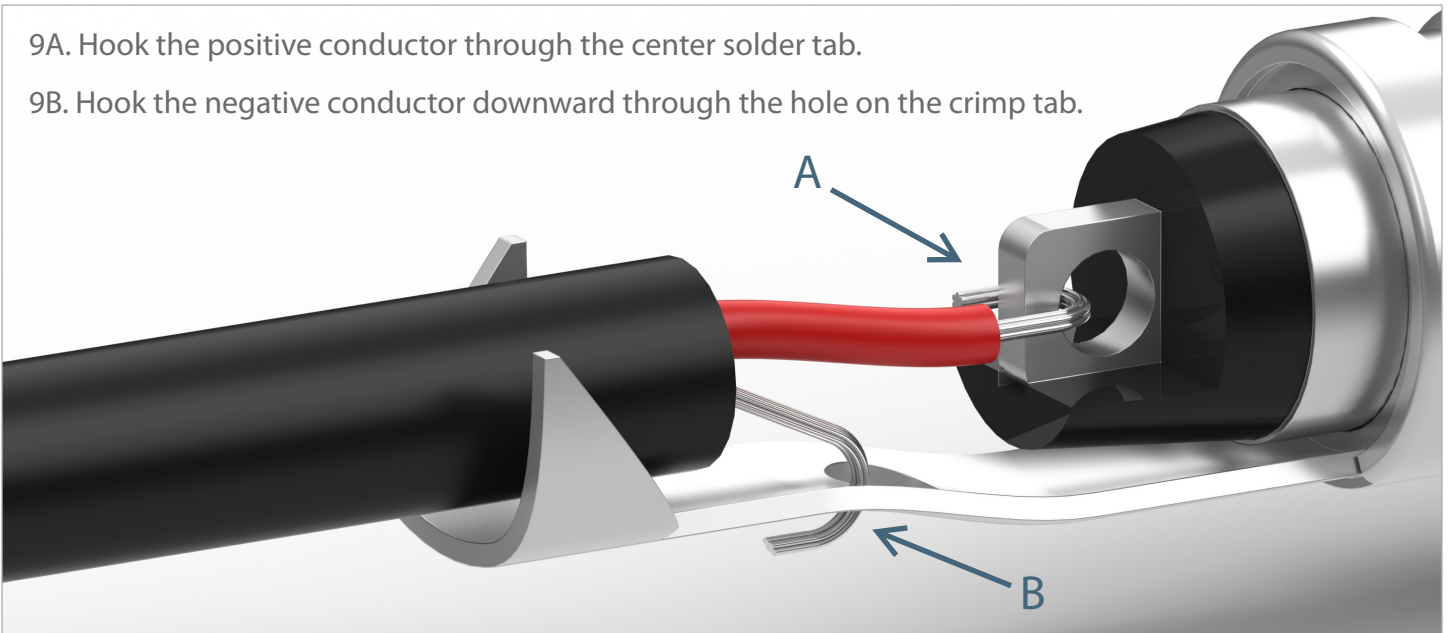


8. Locate the connector. Align the wire so that the positive insulator is "up," in line with the solder tab located on the center of the connector.



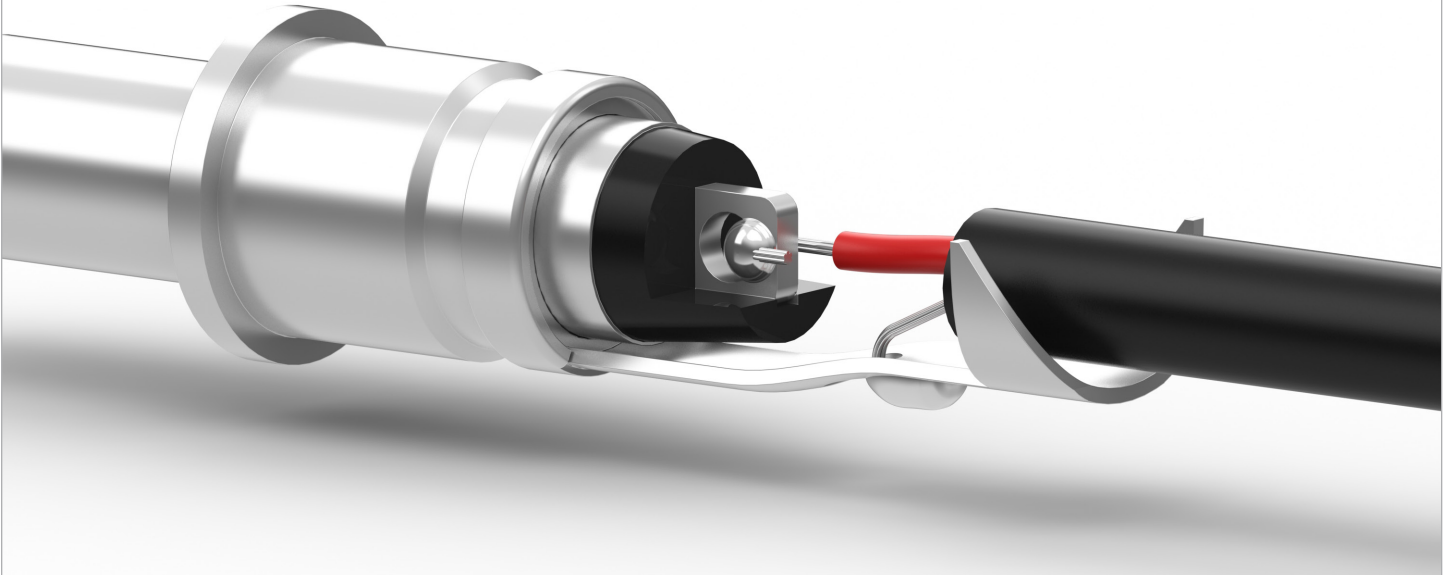
9A. Hook the positive conductor through the center solder tab.

9B. Hook the negative conductor downward through the hole on the crimp tab.

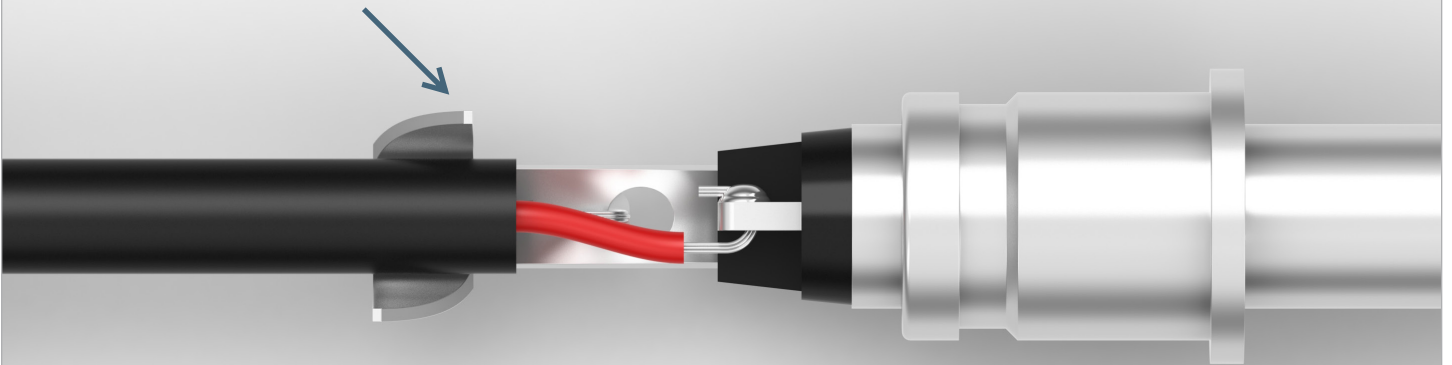


10. Solder the conductors to their respective tabs.

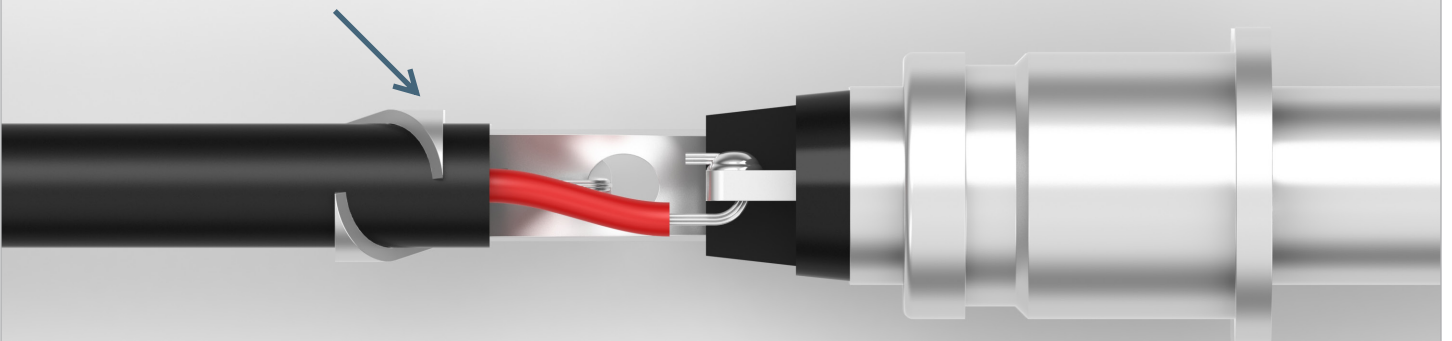
Tip: Tensility International Corporation has multiple stripping and tinning wire videos on Youtube.



11A. Press the crimp tab together around the jacket using a hand crimping tool, such as pliers.

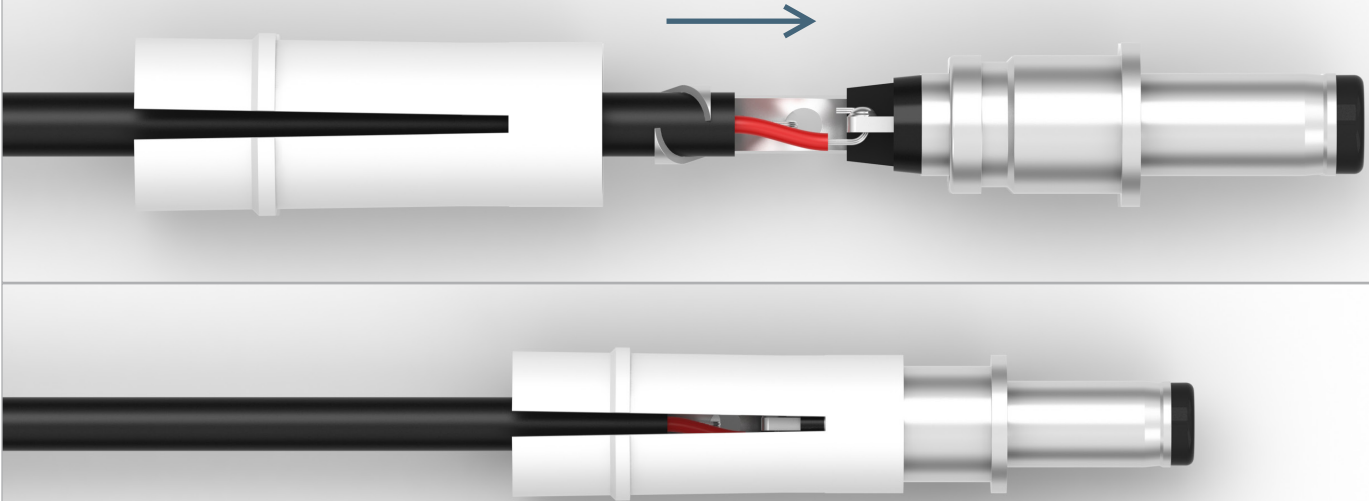


11B. Verify the crimp is tight against jacket, but do not puncture.

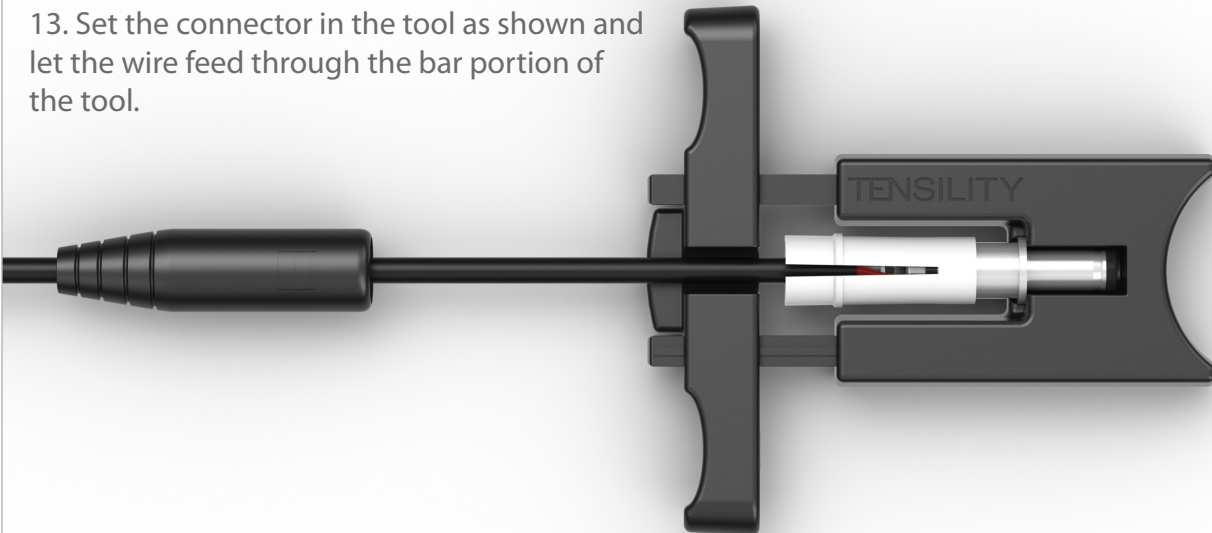


Tip: This crimp helps to stabilize solder joints.

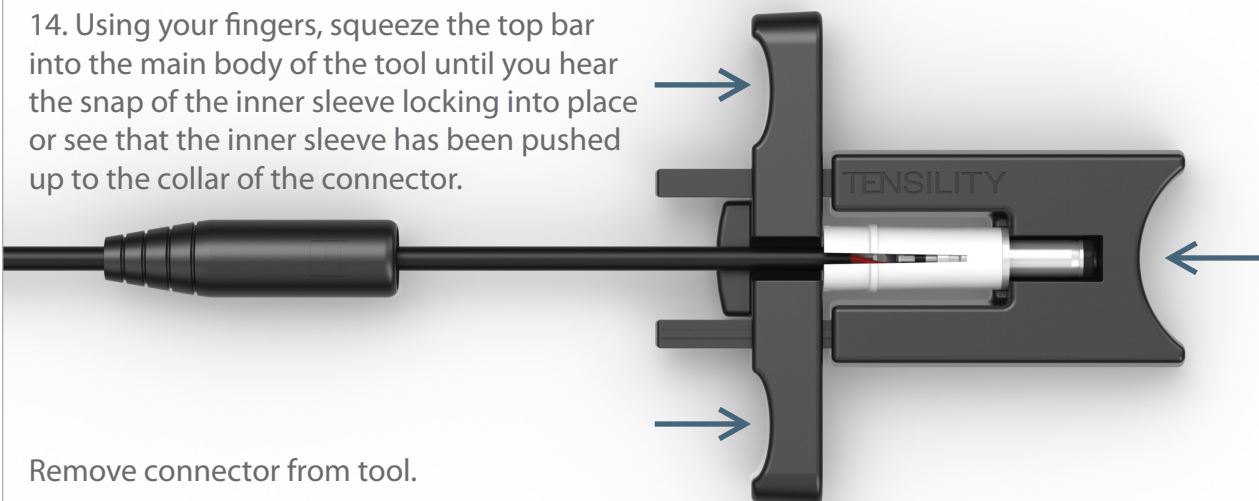
12. Slide the inner sleeve onto the connector up to the other side of the groove.



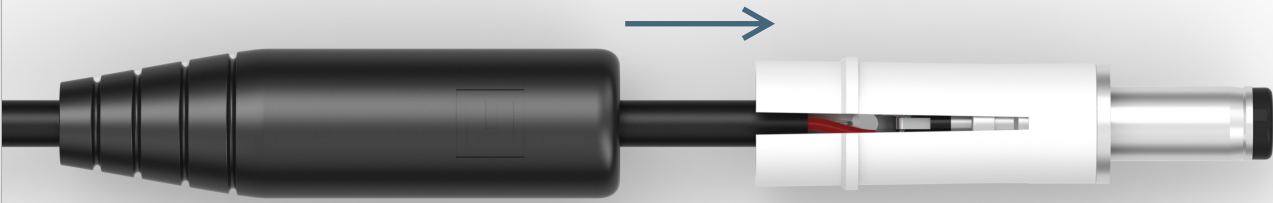
13. Set the connector in the tool as shown and let the wire feed through the bar portion of the tool.



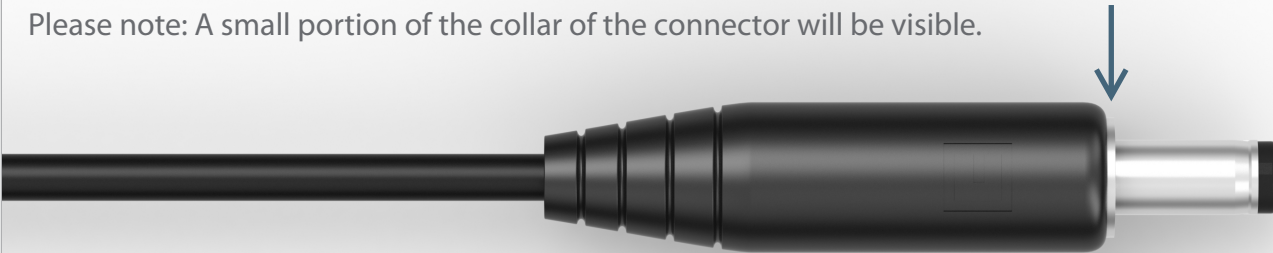
14. Using your fingers, squeeze the top bar into the main body of the tool until you hear the snap of the inner sleeve locking into place or see that the inner sleeve has been pushed up to the collar of the connector.



15. Slide the outer sleeve over the inner sleeve by hand.



Please note: A small portion of the collar of the connector will be visible.



Completed Cable:

