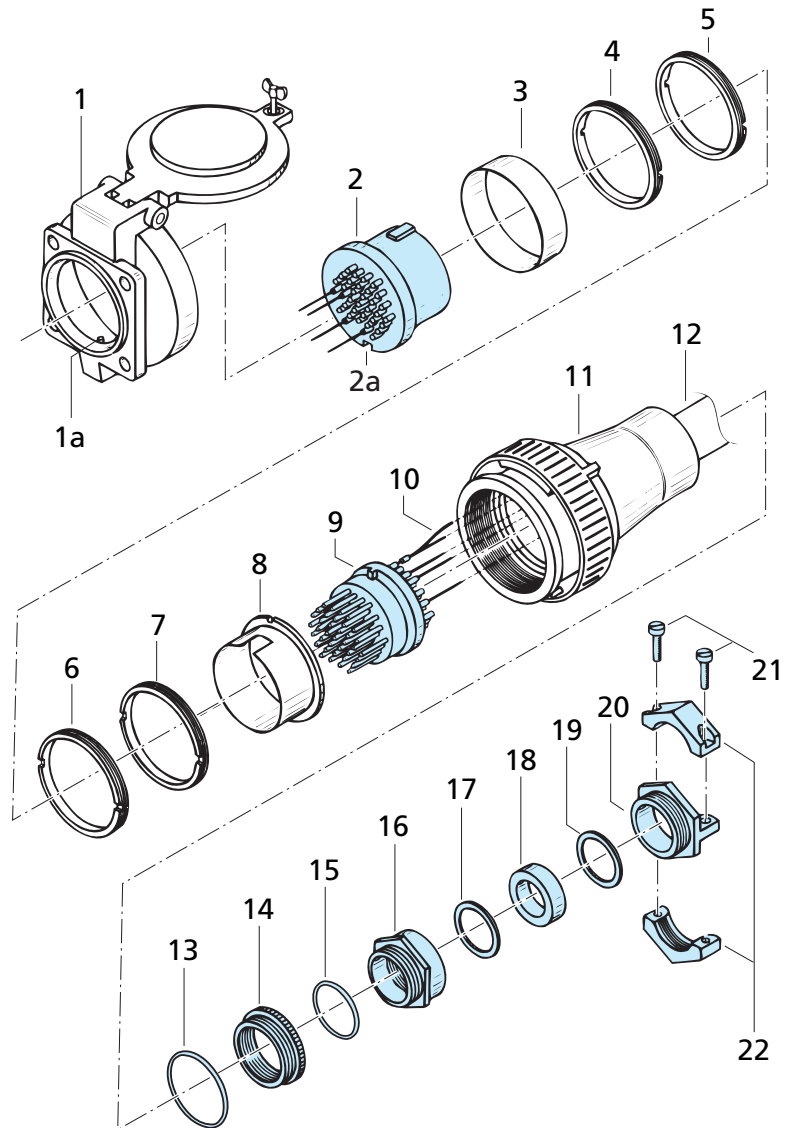
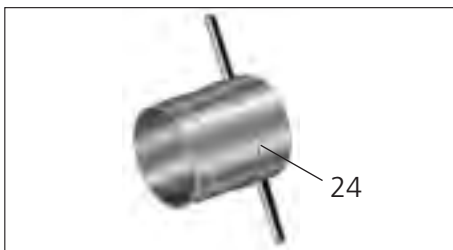


Series 308, 309 and 310
Assembly Instructions

Parts Description	
1	Receptacle Housing
2	Socket Insert
3	Spacer Ring
4 - 7	Threaded Ring
8	Guide Ring (only for unprotected pins)
9	Pin Insert
10	Ground Cable
11	Plug Housing
12	Cable
13 - 22	Cable Clamp
order separately	



Assembly Tool
 for Series 308, 309 and 310

for Series	Part Number for Assembly Key
308	308.098.001.719.000
309	309.098.000.719.000
310	310.098.001.719.000

Assembly of Receptacle	
1.	Push stripped conductors through receptacle (1).
2.	Solder conductors to contacts.
3.	Either socket or pin Insert (2) into Receptacle (1); important, Pin (1a) must snap into groovet (2a).
4.	With Socket Insert spacer ring (3) must be used.
5.	Fasten threaded ring (4, 5) with assembly tool.

Assembly of Plug	
1.	Push cable clamp (13 - 22) and plug housing (11) over Cable (12).
2.	Connect ground strap (10) to ground cable (12).
3.	Solder stripped conductors to contacts.
4.	Mount either pin oder socket insert (9) into plug housing (11), important: Pin (1a) must snap into groovet (2a).
5.	With pin Insert guide ring (8) on insert (9). Watch out for keying!
6.	Fasten threaded ring (4 – 7) with assembly tool.
7.	Connect cable clamp (13 – 22).

Instruction about blowtorch soldering > 6 mm²

During heat-stress it can come to a damage on the contact-elements on the insulating materials as well. (Limit temperature 120°C)

Remedy: Put the inserts into the water. (If possible, distilled water)

Attention! Warmed water at 35°C must be renewed.

After the solder process the connector has to be carefully dried.

