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STEP 1

0.51±0.01
[13.0±0.3]
JACKET

0.18±0.008
[4.5±0.2]
CONDUCTOR

0.13±0.01
[3.2±0.3]
BRAID SHIELD

CLAMP

WASHER

O-RING

NUT

INTERNAL CHANFER ORIENTATION

FEED THE FREE END OF CABLE THROUGH THE NUT, O-RING, WASHER, AND CLAMP IN THE ORDER SHOWN.

STRIP THE CABLE JACKET, THE CONDUCTORS, AND THE CABLE SHIELDING AS SHOWN.

STEP 2

CONTACT

CRIMP OR SOLDER

ONE CONTACT SHOWN HERE FOR CLARITY

CRIMP CONDUCTORS TO CONTACTS USING HAND OR PNEUMATIC CRIMP TOOL* WITH CRIMP POSITIONER* SET PER CONTACT SIZE AND WIRE GAGE.

IF SOLDERING, IT IS RECOMMENDED TO SOLDER CONDUCTORS TO CONTACTS BEFORE INTALLATION.

STEP 3

SHELL

INSERT

0.19
[4.7]
WHEN CONTACT LOCKED INTO INSERT

GUIDE EACH WIRED CONTACT INTO INSERT HOLE AND PUSH UNTIL CONTACT SNAPS IN PLACE. USE INSERTION TOOL* IF NECESSARY.

COLORED CONDUCTORS CAN BE ASSIGNED TO CONTACT POSITION NUMBERS AS DESIRED.

TO REMOVE A CONTACT, INSERT THE EXTRACTION TOOL* FROM THE FRONT OF INSERT AND LIGHTLY PRESS THE SPRING LOADED PLUNGER INWARD TO PUSH THE CONTACT OUT.

STEP 4

0.08
[2.0]
WHEN INSERT IN FINAL POSITION

ALIGN INSERT ASSEMBLY INTO SHELL FOLLOWED BY THE CLAMP. PUSH CLAMP LIGHTLY FORWARD AND ROTATE UNTIL THE ASSEMBLY SNAPS IN THE FINAL POSITION SHOWN.

STEP 5

COMPLETED ASSEMBLY

SLIDE WASHER, O-RING, AND NUT AGAINST CLAMP AND THREAD NUT ON UNTIL TIGHT - NOT TO EXCEED 9 IN-LB [1 Nm] TORQUE. A 5/16" [8mm] WRENCH CAN BE USED, IF NECESSARY.

*REFER TO TOOLS TABLE ON THIS DRAWING FOR SELECTION OF TOOLS PER CONTACT AND WIRE SIZE.

**TS2 SERIES CABLE-TO-CABLE
FIELD ASSEMBLY INSTRUCTIONS**

SCALE 2:1	Switchcraft®	
DATE DRAWN 04/20/16		
DRAWN BY PNK	PART No. TS2L SERIES_CD	REV 0A

SHEET 2 OF 2

SolidWorks CAD File

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