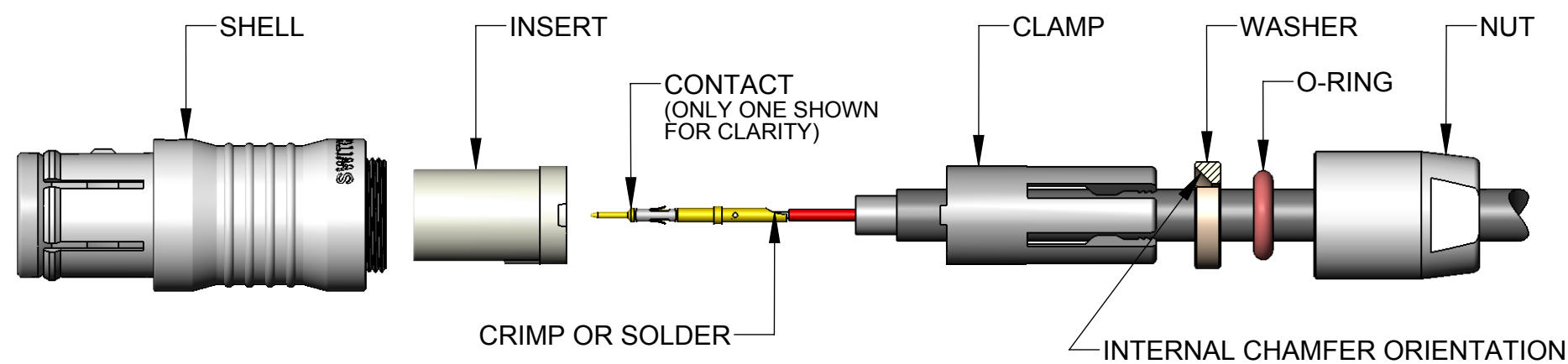
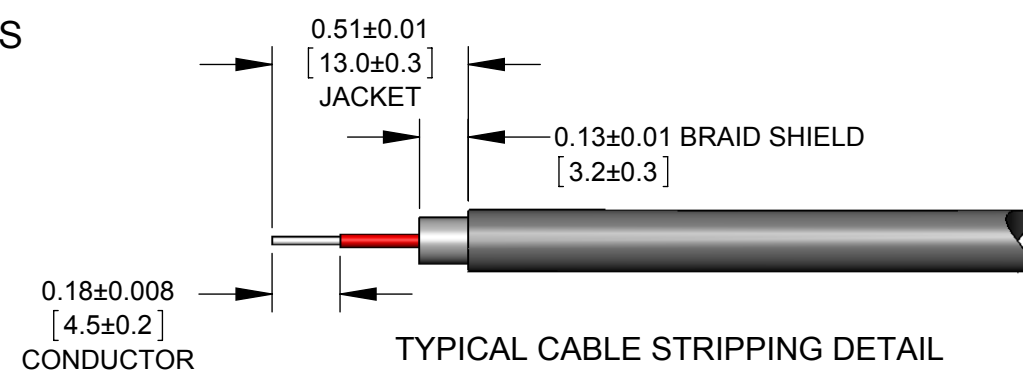
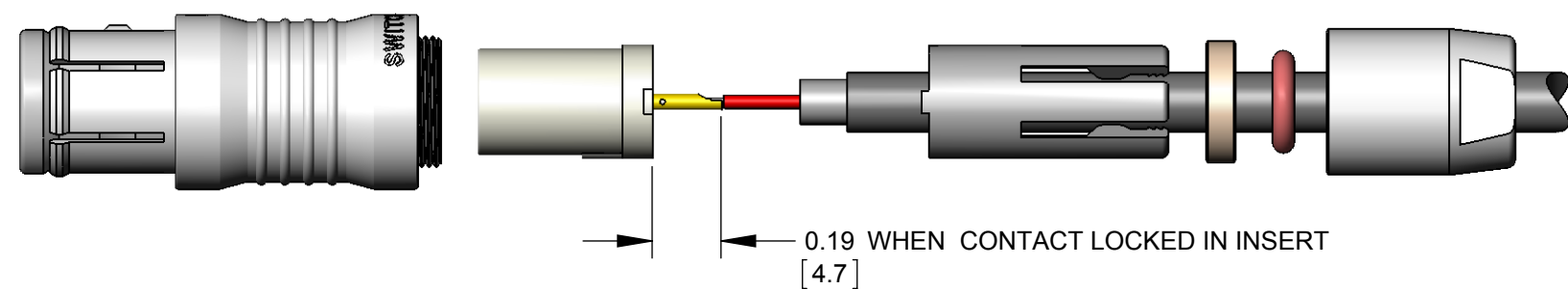


HS2 SERIES CABLE-END FIELD ASSEMBLY INSTRUCTIONS:

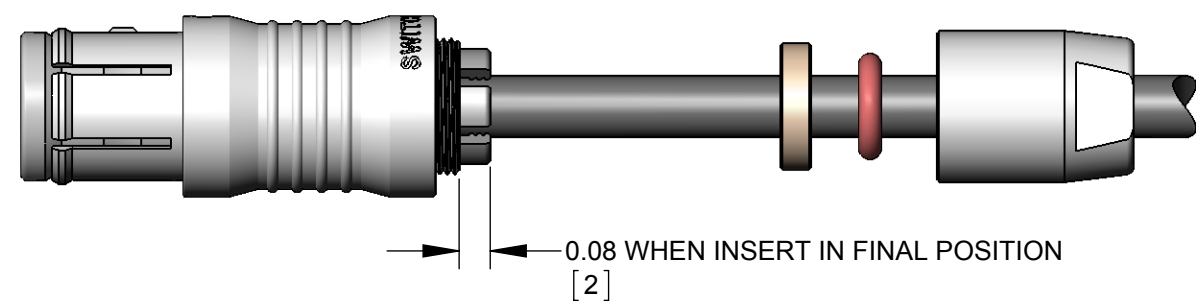
1. FEED THE FREE END OF CABLE THROUGH THE NUT, O-RING, WASHER, AND CLAMP IN THE ORDER SHOWN.
2. STRIP THE CABLE END AND THE CONDUCTORS AS SHOWN HERE.



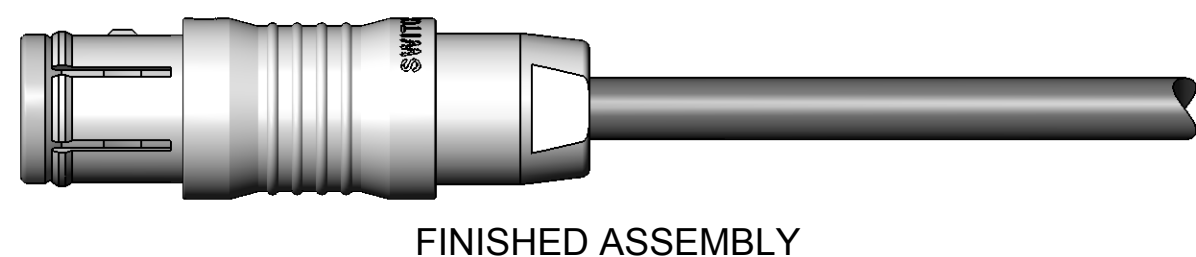
3. CRIMP CONDUCTORS TO CONTACTS USING HAND OR PNEUMATIC CRIMP TOOL* WITH CRIMP POSITIONER* SET PER CONTACT SIZE AND WIRE GAGE. IF SOLDERING, IT IS RECOMMENDED TO SOLDER CONDUCTORS TO CONTACTS BEFORE INSERTING THEM INTO INSERT.
4. GUIDE EACH WIRED CONTACT INTO INSERT HOLE AND PUSH UNTIL CONTACT SNAPS 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.



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



6. SLIDE WASHER, O-RING, AND NUT AGAINST CLAMP AND THREAD NUT ON UNTIL TIGHT, UP TO 12 IN-LB [1.4 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.

SCALE 2:1	Switchcraft®	
DATE DRAWN 01/06/16		
DRAWN BY PNK	PART No. HS2C SERIES_CD	REV 0A