



ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

Assembly Instruction
CAI- Connector with
universal Endbell

Shell size 10 to 36 with
APK – contact / Trident T2P - contact

Illustration and assembly exemplary of CAI Layout 20-0306
with APK / Trident T2P stamped contact

Bearbeitet:
AKUGeprüft:
VM / FA

Norm:

Änd.-Stand:
B4078WÄnd.-Datum:
26.09.2011



ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

Table of contents

page:

1.) Structure of the connector

1.1) Description of the connector components	3
1.2) Part overview of the stamped contacts	5
1.3) Crimp tool overview	6
1.4) Operating instruction, stamped contacts	7

2.0) Assembly / preparation of the cable

2.1) Stripping of the cable for T2P – pin contact	8
2.2) Stripping of the cable for APK – pin contact	8
2.3) Crimping, single wire T2P und APK25	8
2.4) Stripping of cable and crimping, shielded cable system	9
2.5) Crimping contacts to shielded cable system	9

3.0) Assembly connector

3.1) Insertion of stamped contacts	10
3.2) List of components to be assembled	11
3.3) Assembly of Universal Endbell	12

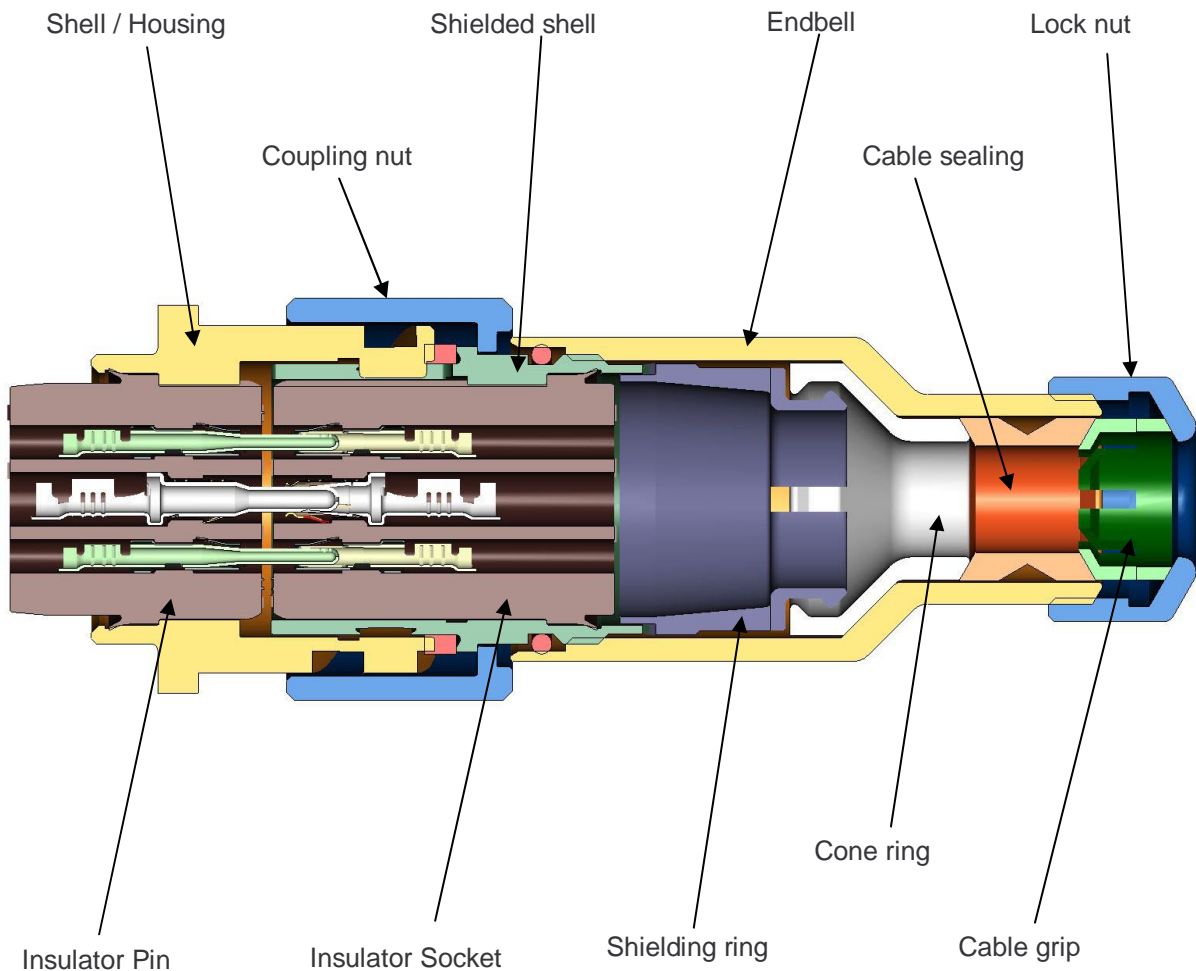
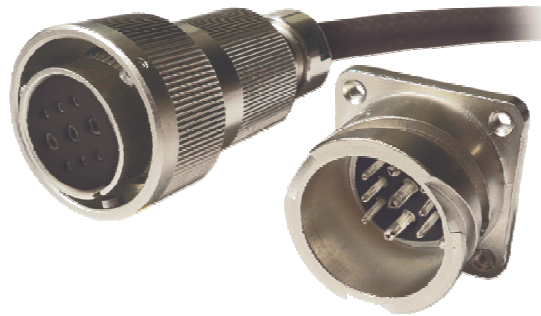
4.0) Removal of contacts

4.1) Removal of contacts	16
4.2) Extraction tools	17

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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Wiring and assembly instruction CAI

1.1) Description connector components



Bearbeitet:
AKU

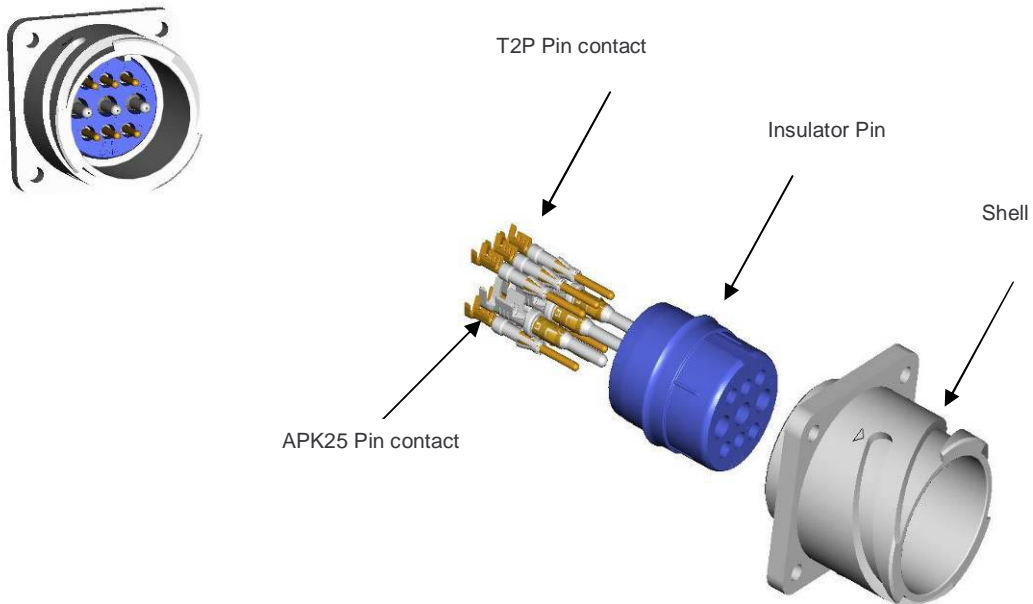
Geprüft:
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Norm:

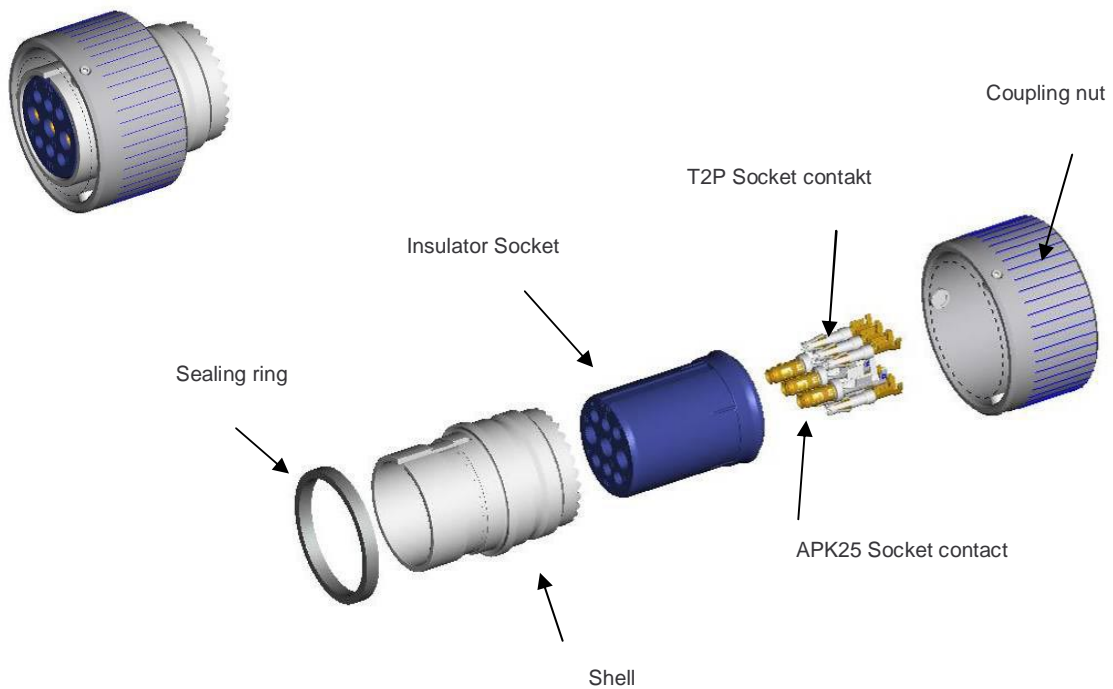
Änd.-Stand:
B4078W

Änd.-Datum:
26.09.2011

Exploded view example of the flange housing assembly with pin contacts



Exploded view example of the shielded barrel with socket contacts



Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
--------------------	---------------------	-------	-----------------------	---------------------------



ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

1.2) Part overview stamped contacts:

Trident T2P:

Socket contact, crimp version



Pin contact, crimp version



Wire Size			Part Number for Reeled Contacts		
mm ²	AWG	Contact	Standard Material Tin Plating	Gold Flash	High Conductivity Material
0,14-0,25	26-24	Pin	192990-2510	192990-2650	192900-0120
0,14-0,25	26-24	Socket	192990-2550	192990-2690	192900-0121
0,32-0,50	22-20	Pin	192990-2500	192990-2640	192900-0124
0,32-0,50	22-20	Socket	192990-2540	192990-2680	192900-0125
0,75-1,50	18-16	Pin	192990-2490	192990-2630	192900-0000
0,75-1,50	18-16	Socket	192990-2530	192990-2670	192900-0001
1,50-2,50	16-14	Pin	192990-2480	192990-2620	192900-0004
1,50-2,50	16-14	Socket	192990-2520	192990-2660	192900-0006

APK 25:

Socket contact, crimp version



Pin contact, crimp version



Wire Size			Part Number for Reeled Contacts		
mm ²	AWG	Contact	Standard Material Tin		
0,50-1,00	20-18	Pin	121668-0000		
0,50-1,00	20-18	Socket	121668-0100		
1,50-2,50	16-14	Pin	121668-0001		
1,50-2,50	16-14	Socket	121668-0101		
2,50-4,00	14-12	Pin	121668-0002		
2,50-4,00	14-12	Socket	121668-0102		

The contacts are crimped with insulation crimp.

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
--------------------	---------------------	-------	-----------------------	---------------------------



ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

1.3) Crimp tool overview:

Handcrimp tool



Single contacts are crimped with hand tool:

AWG / Wire size	Description / Part Number:
26-20 AWG; 0,14-0,50mm ²	CHT-Trident 121586-5236
18-16 AWG, 0,75-1,50mm ²	CHT-Trident 121586-5237
16-14 AWG, 1,50-2,50mm ²	CHT-Trident 121586-5238
20-12 AWG, 0,50-4,00mm ²	CHT-APK25-Standard 121586-5241

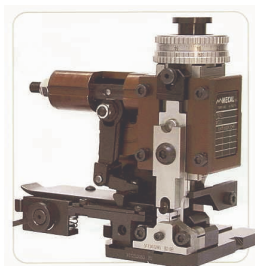
Crimp machine basic - press TT



Crimp machines are used for high volume production. We recommend basic press TT with mini-applicator WWZ-20.100 or WWZ-EVS.

<u>Description:</u>	<u>Part number:</u>
Basic - press -TT	121586-5225

Crimp tool, Mini Applicator WWZ-EVS



Technical specification (CAS) for crimp tools (mini – applicator) are included.

Support and training for crimp tools and machines by the crimp service of ITT-Cannon GmbH

Wire size	Contacts	Description	Part Number
0,14-0,50 mm ²	Trident	WWZ – EVS	121586-5239
0,75-1,50 mm ²	Trident	WWZ – EVS	121586-5217
1,50-2,50 mm ²	Trident	WWZ – EVS	121586-5240
0,50-1,00 mm ²	APK 25	WWZ – 20.100	121586-5128
1,50-2,50 mm ²	APK 25	WWZ – 20.100	121586-5129
2,50-4,00 mm ²	APK 25	WWZ – 20.100	121586-5130




Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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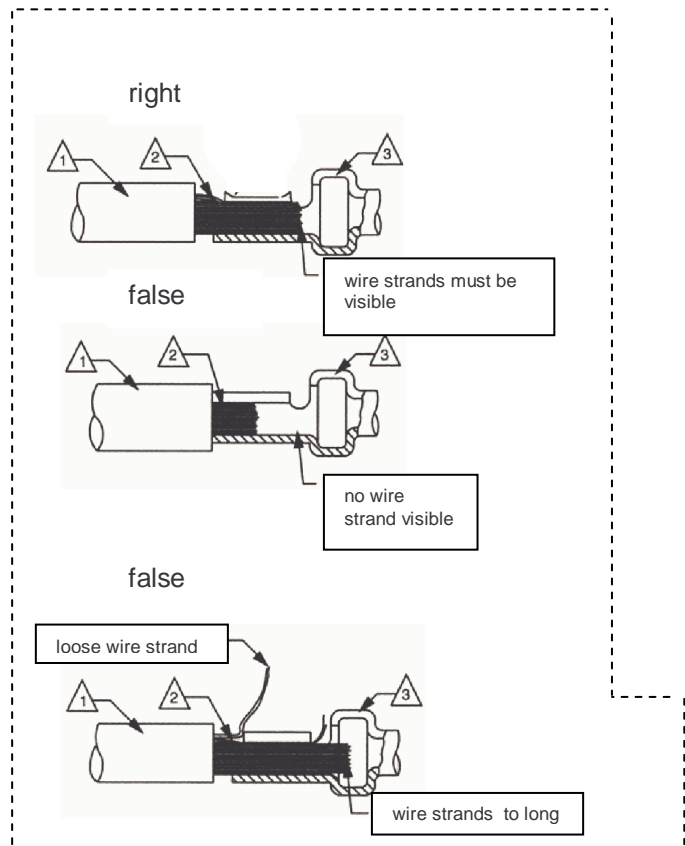
1.4) Operating instructions stamped contacts:

- 1.) Strip wires to length, for stripping details see 2.1 and 2.2)
- 2.) Open hand tool and insert the contact in the selected crimp profile
- 3.) Position the stripped cable in the contact
- 4.) Press hand tool to end position
- 5.) Open hand tool and extract the contact, check the contact visually

- there shall be no loose strands out of the crimp section
- the contact must be crimped straight to the cable
- deformed contacts must not be used. Crimp again

-comments:

-  Insulation of cable
-  Wire strands
-  Contact



Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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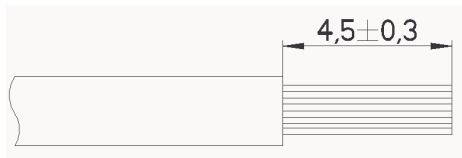
Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

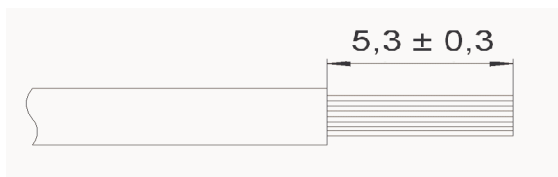
2.0) Assembly / preparation of cable

2.1) Stripping cable for T2P pin contact



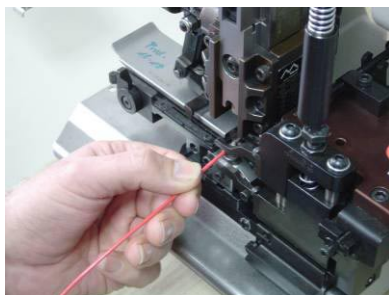
The recommended stripping length of the stamped pin and socket contact is 4, 5+/- 0,3mm. The stripping of cable is carried out with relevant stripping unit. Thereby the wire strands must not be damaged.

2.2) stripping cable for APK pin contact



The recommended stripping length of the stamped pin and socket contact is 5, 3+/- 0,3mm. The stripping of cable is carried out with relevant stripping unit. Thereby the wire strands must not be damaged.

2.3) Crimping single wire T2P and APK 25 contacts



The stamped contacts can be crimped with Hand tool or Mini-applicator (see 1.3) Crimp tool overview



The picture shows crimping process with Mini-applicator

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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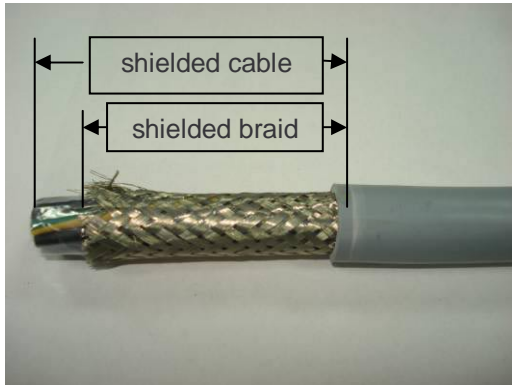
ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

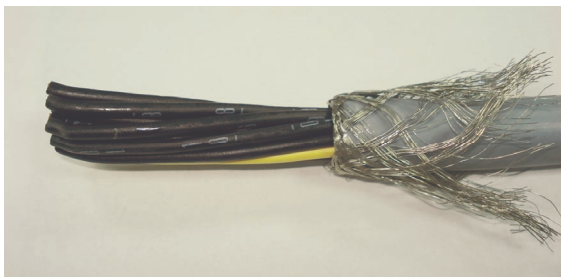
2.4) Stripping, shielded cable system



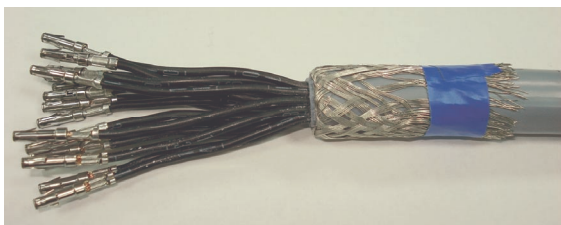
The stripping length for shielded cable has to be determined that the shielded cable is inside of the grounding ring after assembly. The stripping of cable is carried out with relevant stripping unit. Thereby the shielding braid must not be damaged.

The recommended stripping length for shielded braid is 40mm. Stripping length for single wires see 2.1) + 2.2).

2.5) Crimping contacts to shielded cable system



turn over braid and remove the protective foil if available



fix the shielding braid with tape for easier assembly

stripping single cables and crimp the contacts see 2.1) + 2.2)

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

3.0) Assembly of connector

3.1) Insert of pin and socket contacts:

PIN:



SOCKET:

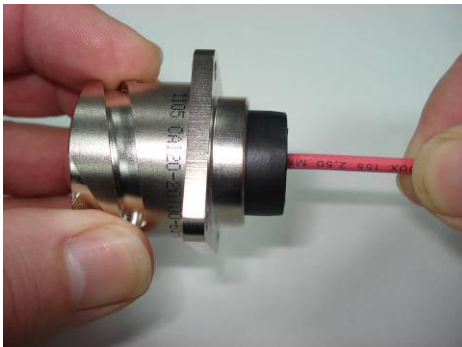


Insertion:

An insertion tool is not required. The stamped contacts are pushed by hand into the cavity from the rear side of the connector. A “click” indicates that the contact is in the final position.

The contact can not be pulled back. Forwards the contact position is defined by a shoulder inside the insulator.

PIN:



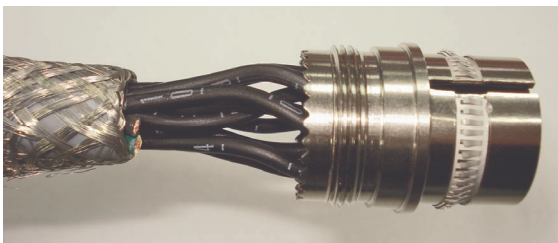
SOCKET:



ATTENTION !!!

After assembling the contacts must be checked if safely locked into position in the insulator.

Do not use contacts if they are not locked.



component assembly after insert of contacts

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Änd.-Stand:
B4078W

Änd.-Datum:
26.09.2011

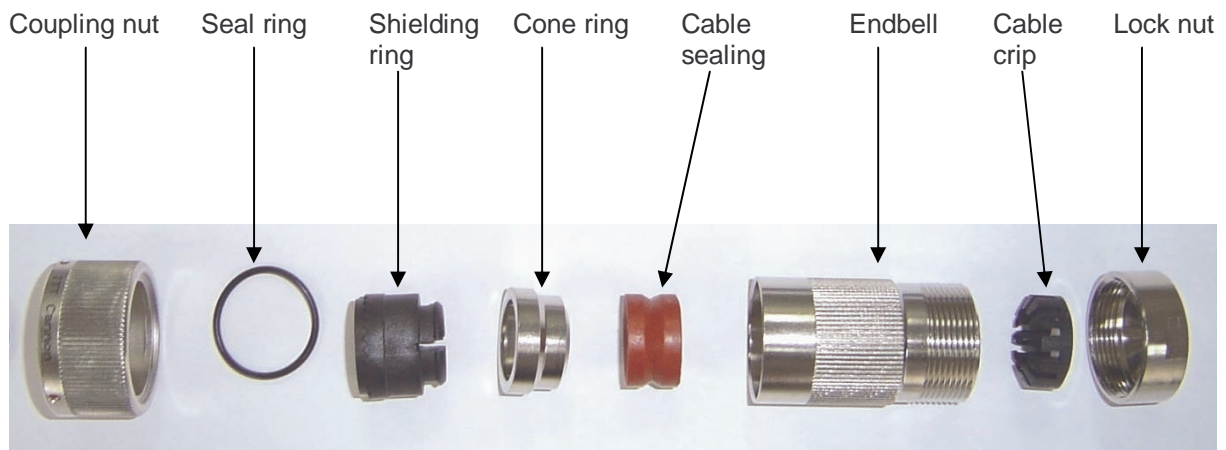


Assembly Instruction
CAI – Connector with universal Endbell

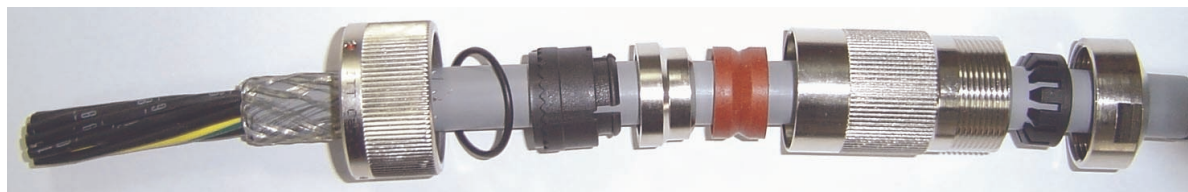
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3.2) Overview of parts to be assembled

CAI connector socket with shielded cable system



For longer cable lengths or for applications with already connected cables, slide all parts on the cable before assembling contacts into barrel and insulator. Pay attention to the correct order of all parts, as pictured.



ASSEMBLY DIRECTION
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Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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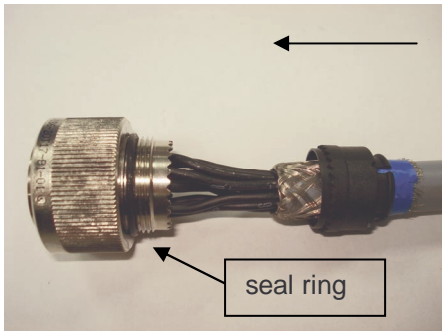
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Assembly Instruction

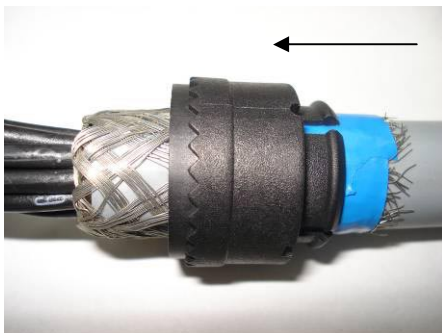
CAI – Connector with universal Endbell

CAS25089E

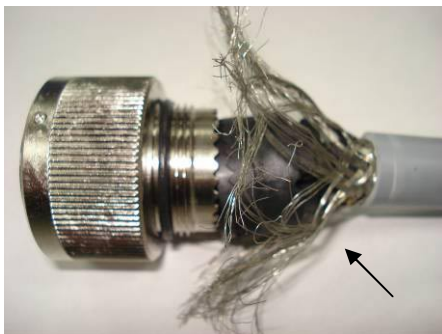
3.3) Assembly Universal Endbell



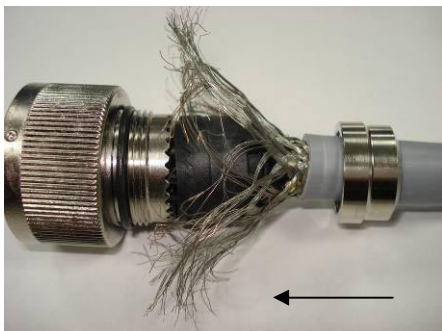
3.3.1) Move coupling nut over the shell and mount the seal ring



3.3.2) Move the support sleeve to the shell and remove the tape. Make sure that the tothing shows to shell.



3.3.3) Weave shielding and arrange evenly over the support sleeve



3.3.4) Move grounding ring to the support sleeve

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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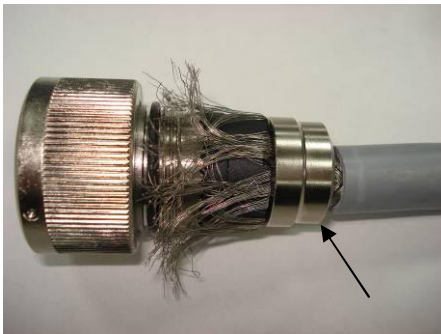
ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

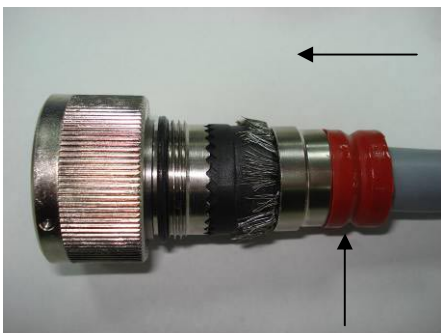
3.3) Assembly Universal Endbell



3.3.5) Mount grounding ring on the support sleeve (snap on connection)



3.3.6) Cut shielding braid (according to picture)



3.3.7) Move the grommet to the grounding ring

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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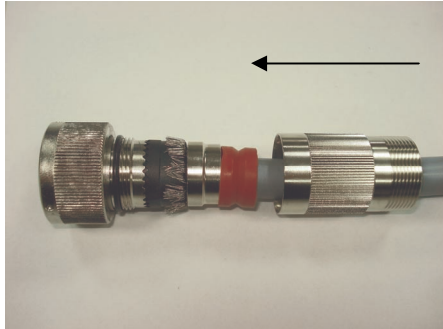
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Assembly Instruction

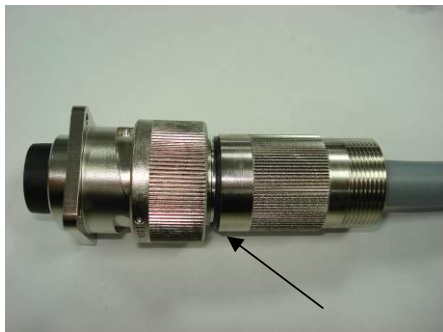
CAI – Connector with universal Endbell

CAS25089E

3.3) Assembly Universal Endbell



3.3.8) Move Universal Endbell to the connector



3.3.9) Move Universal Endbell to position to seal ring



Permitted torque	
Shell size	Nm
10	3
14	5,1
16	7
18	8
20	9
22	10,6
24	12,9
28	16,7
32	18,1
36	23,9

3.3.10) Tighten Endbell and note the permitted torque

TIP: as installation support the right flange shell can be used

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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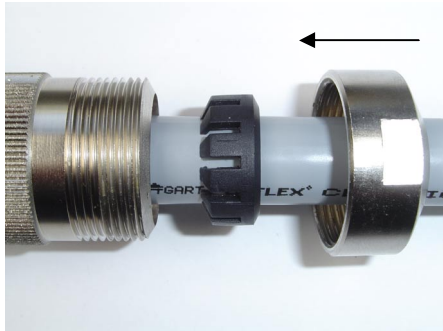
ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

3.3) Assembly Universal Endbell



3.3.11) Move the cable grip (according to picture) to the Universal Endbell and screw the clamp nut



3.3.12) Mount the clamp nut and pull tight with an open end wrench. Recommended torque is 3+/-1Nm



3.3.13) Connector is assembled completely.

Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
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Assembly Instruction
CAI – Connector with universal Endbell

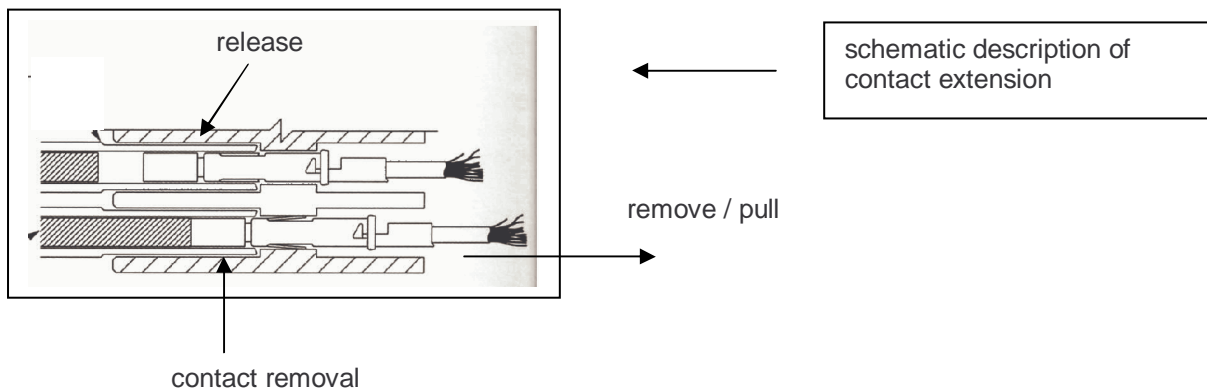
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4.0) Removal of contacts



4.1) Removal of APK and T2P contacts

Removal of the stamped contacts, pin and socket is done from the front of the housing / shell with the extraction tool. The extraction tool is inserted from the front side of the connector. The locking springs are compressed and the contact can be pulled out on the cable side.



Bearbeitet: AKU	Geprüft: VM / FA	Norm:	Änd.-Stand: B4078W	Änd.-Datum: 26.09.2011
--------------------	---------------------	-------	-----------------------	---------------------------



ITT Industries

Assembly Instruction

CAI – Connector with universal Endbell

CAS25089E

4.0) Removal of contacts

4.2) ITT – Cannon Extraction tools



Extraction tool Trident:
P/n.: 192922-1450



Extraction tool APK 25:
P/n.: 121086-3278



Extraction tool APK 25:
P/n.: 192900-0176

Bearbeitet:
AKU

Geprüft:
VM / FA

Norm:

Änd.-Stand:
B4078W

Änd.-Datum:
26.09.2011



Компания «ЭлектроПласт» предлагает заключение долгосрочных отношений при поставках импортных электронных компонентов на взаимовыгодных условиях!

Наши преимущества:

- Оперативные поставки широкого спектра электронных компонентов отечественного и импортного производства напрямую от производителей и с крупнейших мировых складов;
- Поставка более 17-ти миллионов наименований электронных компонентов;
- Поставка сложных, дефицитных, либо снятых с производства позиций;
- Оперативные сроки поставки под заказ (от 5 рабочих дней);
- Экспресс доставка в любую точку России;
- Техническая поддержка проекта, помощь в подборе аналогов, поставка прототипов;
- Система менеджмента качества сертифицирована по Международному стандарту ISO 9001;
- Лицензия ФСБ на осуществление работ с использованием сведений, составляющих государственную тайну;
- Поставка специализированных компонентов (Xilinx, Altera, Analog Devices, Intersil, Interpoint, Microsemi, Aeroflex, Peregrine, Syfer, Eurofarad, Texas Instrument, Miteq, Cobham, E2V, MA-COM, Hittite, Mini-Circuits, General Dynamics и др.);

Помимо этого, одним из направлений компании «ЭлектроПласт» является направление «Источники питания». Мы предлагаем Вам помощь Конструкторского отдела:

- Подбор оптимального решения, техническое обоснование при выборе компонента;
- Подбор аналогов;
- Консультации по применению компонента;
- Поставка образцов и прототипов;
- Техническая поддержка проекта;
- Защита от снятия компонента с производства.



Как с нами связаться

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