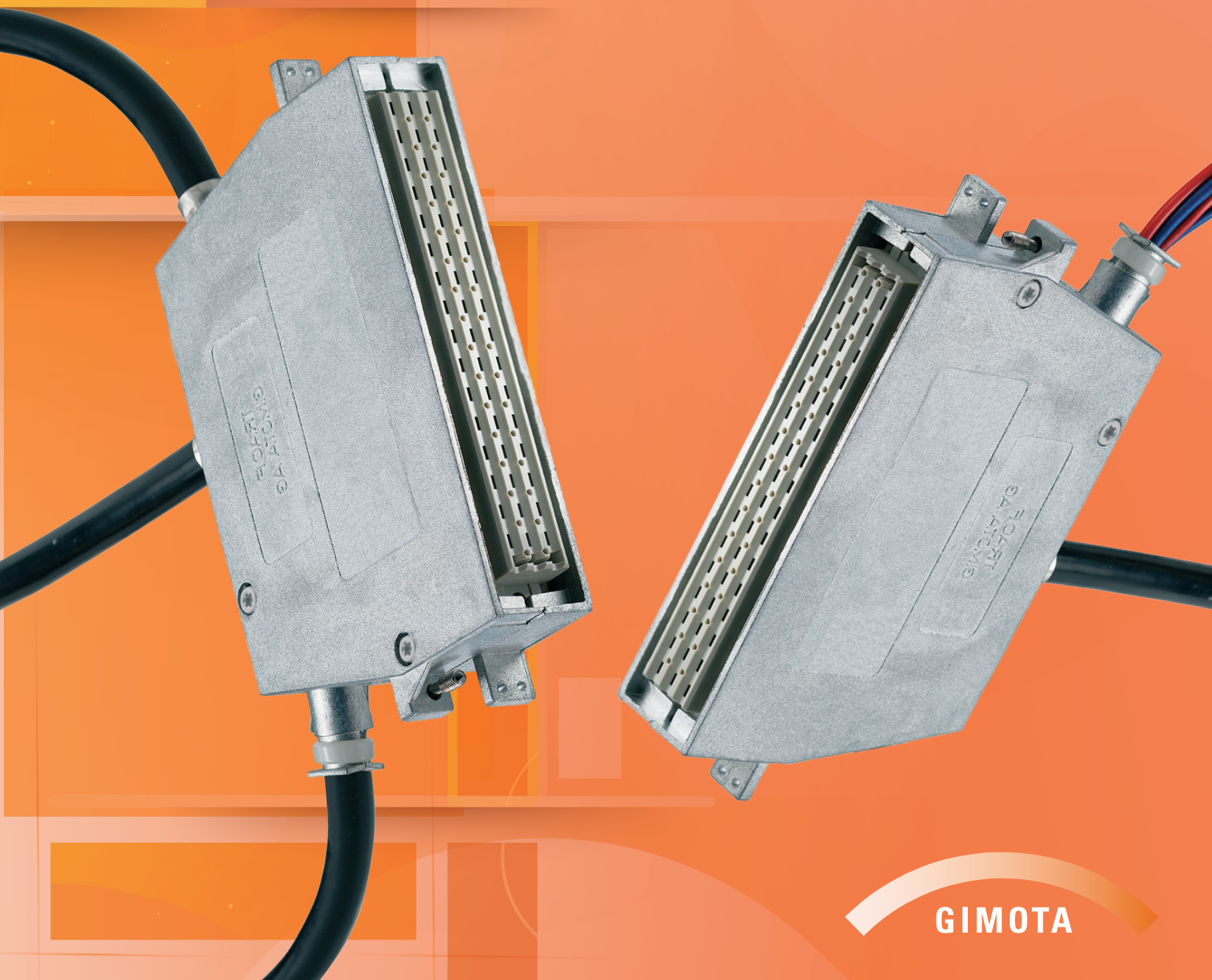


GIMOTA AG

Data connectors DIN F Assembly Instructions 2020



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This assembly instruction replaces all previous editions.

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1 Assembly Instructions TRAC F

1.1 Preparation

Standard part sets

Parts sets are supplied corresponding to the order in set-packages. Please note that contacts and shielding sleeves as well as optional filling tubes are not included in the parts sets. They have to be ordered separately for each case.

The following standard parts sets are available:

Cover	TRACF00
Cover with contact insert 48p	TRACF48
Cover with contact insert 31p	TRACF31
Cover with contact insert 15p	TRACF15

You will find the part set overview in the GIMOTA data connector catalogue chapter 4.3.1.

Individual part sets according to customer specification

Individual part sets according to customers specification can be defined and supplied on request.

Contacts

Contacts are to be selected according to the relevant information of the data connector catalogue:

- Contact layout (number of poles) (acc. data connector catalogue chapter 4.2.1)
- Conductor cross-section (acc. data connector catalogue chapter 4.2.6)
- Manufacturing mode (single contacts or contacts on reels)

Shielding sleeves

Shielding sleeves have to be selected according the corresponding cable clamp, the following assignment applies:

Item number cable clamp	requires shielding sleeve	colour
SUKABC06S	SUGSC297	silver
SUKABC067S	SUGSC297	silver
SUKABC09S	SUGSC460	silver
SUKABC10S	SUGSC460	silver
SUKABC12S	SUGSC500	silver

Tools

Crimping tools for cable clamps (see data connector catalogue chapter 4.4.1)
Crimping tools for shielding sleeves (see data connector catalogue chapter 4.4.1)
Crimping tools for contacts (see data connector catalogue chapter 4.4.2)
Supporting tools (see data connector catalogue chapter 4.2.3 - 4.4.4)

Moreover the following standard tools are recommended:

- Torx screwdriver T8
- Crosshead-screwdriver
- Cable stripper
- Knife
- Plastic hammer

Accomplishing Material (optional)

- Cable tie SUKBV69K to cable clamp SUKABV69 (see chapter 1.2)
- Heat shrinkable tubes to single conductor bundles (see chapter 1.2)
- Heat shrinkable tubes for diameter adaption (see chapter 1.2)
- Heat shrinkable tubes for conductor identification
- Label for connector identification

1.2 Cable set

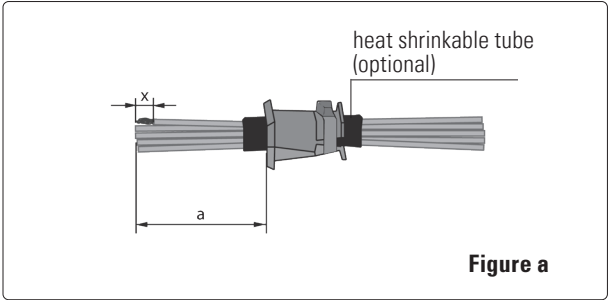
Conductor dismanteling [Table 1]

Conductor area	mm ²	0.12 - 1.5	0.5 - 2.5
Stripping length	mm	x = 2.5	x = 2.5
For contact type		Snap-In	FASTON

Single conductors, non-shielded [Figure a]:

Single conductor bundles may be fixed with the divisible cable clamp SUKABV69 for various diameters from 6 up to 9 mm.

- Dismantle the wires by (x) mm acc. Table 1
- A heat shrinkable tube can be applied at the clamping area (optional)
- Firmly tight the cable clamp with the cable tie SUKBV69K

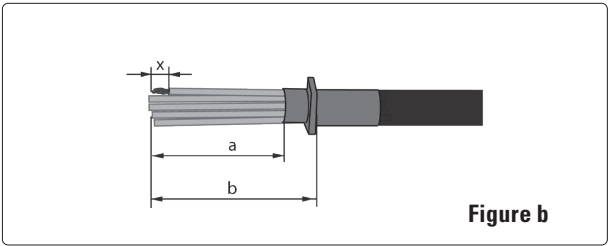


	Cable entrances at the side	Cable entrances at the rear
Approximate distance from cable clamp to end of conductors	a = 93 mm	a = 73 mm

Multiple conductor cable, non-shielded [Figure b]:

For adequate strain relief of non-shielded cables the cable clamps SUKABCxx can be used for 6 mm to 12 mm cable diameters.

- Dismantle the wires by (x) mm acc. Table 1
- A heat shrinkable tube can be applied at the clamping area to enlarge the cable diameters (optional)



	Cable entrances at the side		Cable entrances at the rear	
Cable outer diameter	≤ 9	< 9	≤ 9	< 9
Approximate distance from cable clamp to end of conductors	a = 87 mm	a = 97 mm	a = 67 mm	a = 77 mm
Approximate distance from cable insula- tion to contacts	b = 93 mm	b = 103 mm	b = 73 mm	b = 83 mm

Multiple conductor cable, shielded [Figure a]:

For adequate strain relief and excellent shielding performance the cable clamps SUKABCxxS can be used for 6 mm to 12 mm cable diameters.

- Dismantle the wires by (x) mm acc. Table 1
- A heat shrinkable tube can be applied at the clamping area to enlarge cable diameters (optional)

	Cable entrances at the side		Cable entrances at the rear	
Cable outer diameter	≤ 9	< 9	≤ 9	< 9
Approximate distance from cable clamp to end of conductors	a = 87 mm	a = 97 mm	a = 67 mm	a = 77 mm
Approximate distance from cable insulation to contacts	b = 93 mm	b = 103 mm	b = 73 mm	b = 83 mm
Approximate distance from shield to contacts	c = 80 mm	c = 90 mm	c = 60 mm	c = 70 mm

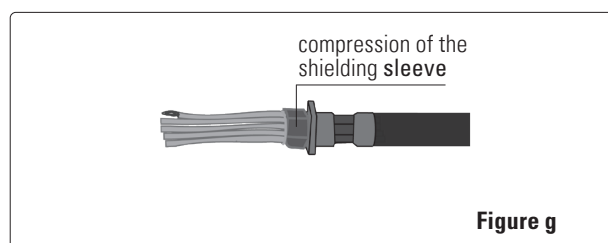
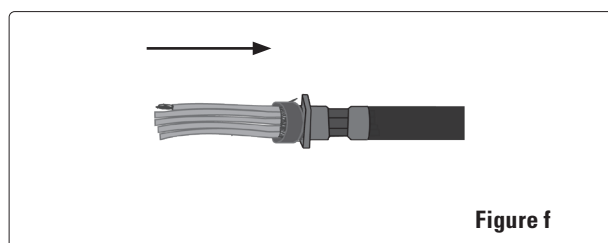
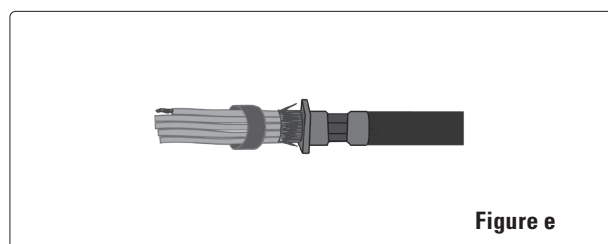
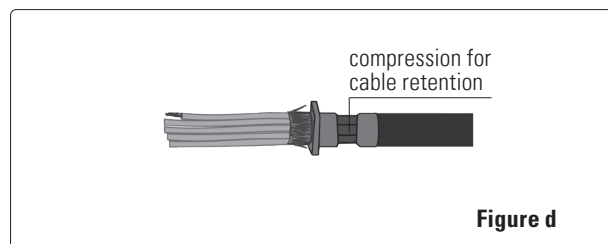
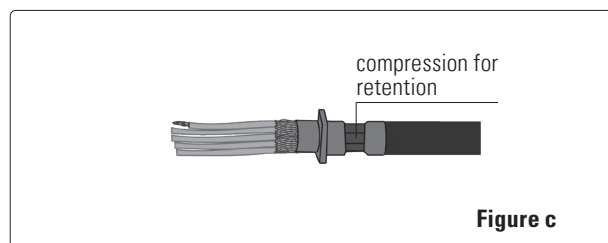
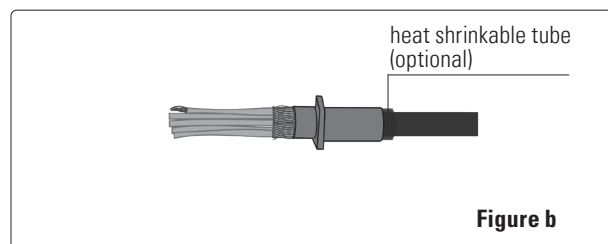
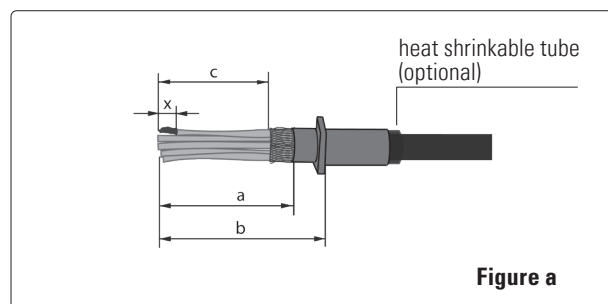
Application of cable clamp SUKABCxxS for cable retention

If the overall diameter of the cable is more than 1 mm smaller than the cable clamps inside diameter, the application of a heatshrinkable or filler tube with a length of approximately 25 mm is required. [Figure b]

Press the strain relief area on the cable clamp with the tool specified in chapter 4.4.1 in the data connector catalogue. [Figure c]

Application of shielding sleeve to crimp cable clamp SUKABCxxS

- After pressing the cable clamp, the shield should protrude by max. 8 mm over the shield connection area
- Fold back the shield over the shield connection area according to [Figure d]
- Place the shielding sleeve in flush with the end of the cable clamp [Figure e] [Figure f]
- Press the shielding sleeve with the specified tool according to chapter 4.4.1 of the data connector catalog [Figure g]



Contact crimping [Figure a]

Contact: To be crimped with the specified tool. acc. chapter 4.4.2 Dataconnector Catalogue

IMPORTANT: The crimping tool must be closed completely, i.e. until it opens again automatically

Check

Crimping: Examine the position and the shape of the crimping
Single wires: No individual wires may stick out of the crimping area
Contact shape: The contacts must not be deformed or damaged outside the crimping areas

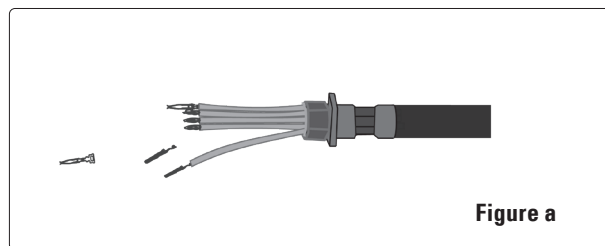


Figure a

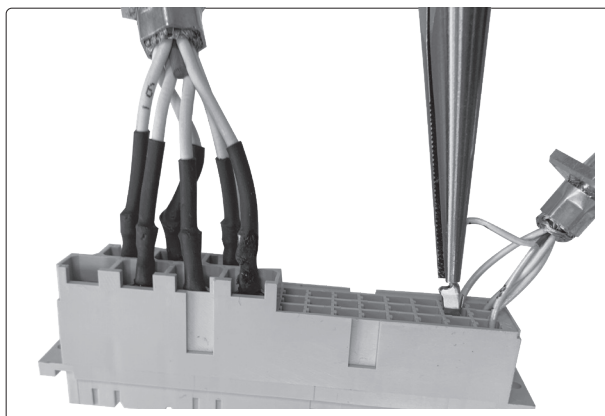
Heat Shrinkable Tubes, fixing

Optional: In the connection area of the individual conductors, heat-shrinkable tubing can be fitted for wire identification, support or insulation reinforcement

1.3 Assembling

Contacts application

Apply the contacts, corresponding to the contact layout requirement, into the contact housing until they properly click in. Examine the correct contact fixing by slightly pulling each conductor.



IMPORTANT:

It is required that the retaining-spring at every Snap-In contact is positioned towards the catching-groove, or towards the contact row indication side. [Figure b] [Figure c]

In case of wrong insertion, no fixation in the contact chamber can be achieved and the retaining-spring will be damaged. The contact finally **must** be replaced before re-insertion of the contact!

Check the arrangement, put it in adequate order if necessary

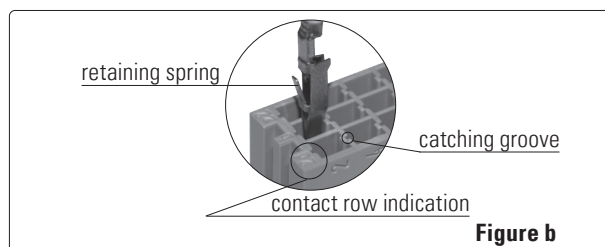


Figure b

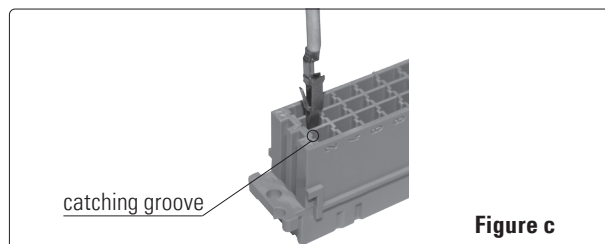
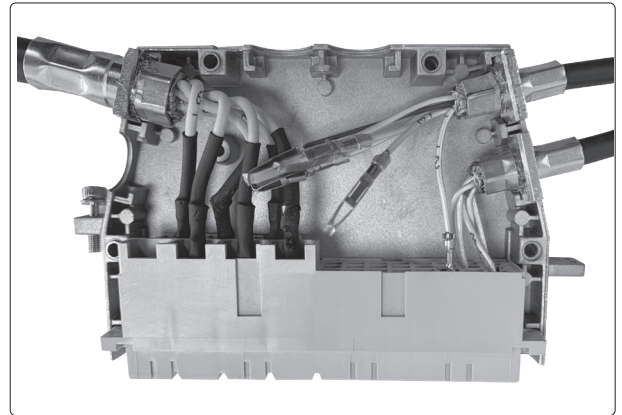


Figure c

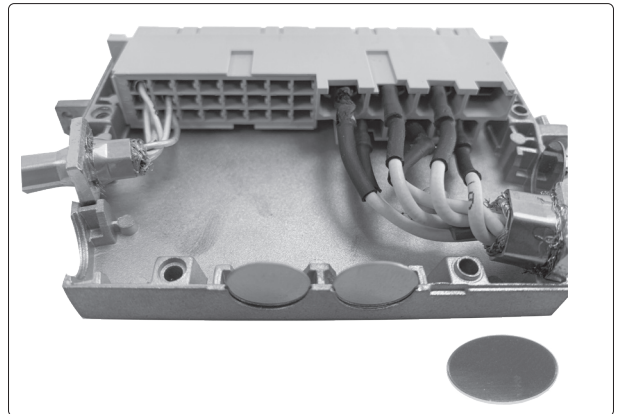
Check arrangement, put it in adequate order if necessary
Connector Assembling

Examine the cover regarding residues (eg. wire rests) and clean it accordingly

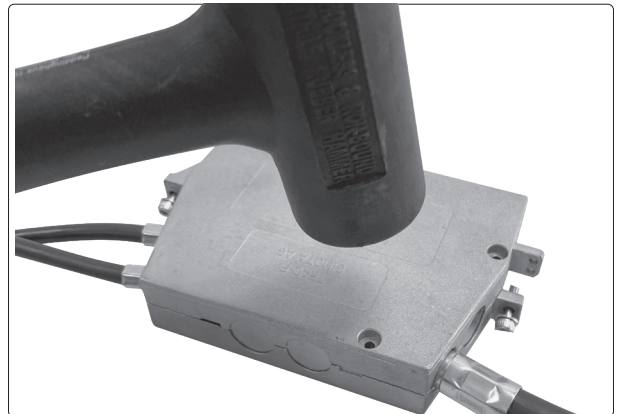
Apply the contact housing into the correct position and push the cable clamps in the foreseen position (1 -6) of the cover. (If required use a plastic hammer to set them in)



Apply wire hole plugs FBL12.8x0.4 in all empty cable entries. No cable entry should remain empty. (If required use plastic hammer to set them in)



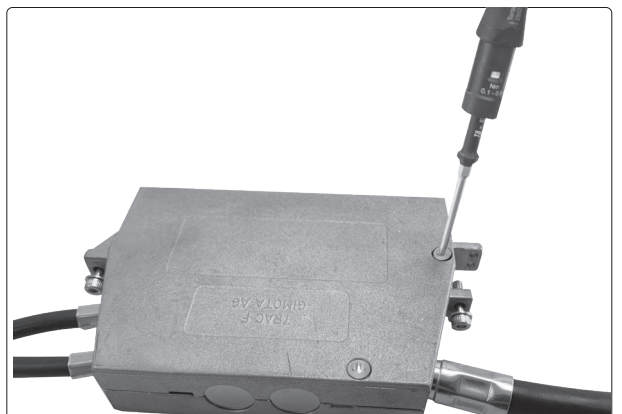
Place the upper cover shell at the lower shell and close them.
(If required use plastic hammer to set them in)



Apply the four cover screws FSCTX8M2.5x12 and tighten them with 0.5 - 0.6Nm tightening torque with a torx screw driver size T8.

Apply fixing screws FI6KTM3x12 including the spring washers SUBN2312 with the foreseen hexagonal screw driver GIW903

Optional: apply selfadhesive lable for connector identification
Optional: apply the coding screws at the connector case



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