



8

7

6

5

4

3

2

1

F

E

D

C

B

A

STEP 1

STEP 2

STEP 3

STEP 4

STEP 5

STEP 6

0.51±0.01  
[13.0±0.3]  
JACKET

0.18±0.008  
[4.5±0.2]  
CONDUCTOR

0.13±0.01 BRAID SHIELD  
[3.2±0.3]

CLAMP

WASHER

O-RING

NUT

INTERNAL CHAMFER ORIENTATION

CONTACT

ONE CONTACT SHOWN HERE FOR CLARITY

CRIMP OR SOLDER

SHELL

COUPLING RING

INSERT

INTERFACE SEAL O-RING

0.19 WHEN CONTACT LOCKED INTO INSERT  
[4.7]

0.08 WHEN INSERT IN FINAL POSITION  
[2.0]

INTERFACE SEAL O-RING IN FINAL POSITION

FINISHED ASSEMBLY

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.

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 INSTALLATION.

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.

SLIDE COUPLING RING OVER SHELL ORIENTED AS SHOWN.

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

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.

GUIDE THE INTERFACE SEAL O-RING OVER THE INSERT AND PUSH INTO THE GROOVE OF THE SHELL.

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

TS2 SERIES CABLE-END  
FIELD ASSEMBLY INSTRUCTIONS

SCALE 2:1	Switchcraft®	
DATE DRAWN 04/19/16		
DRAWN BY PNK	PART No. TS2C SERIES_CD	REV 0A

SolidWorks CAD File

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