MCPK-8 Series Assembly/Wiring Instructions

Following are instructions for assembling Samtec’s MCPK Series AccliMate™ IP67 Sealed Circular Cable Assembly using our Field Termination Kit. Refer to the following pages for specific instructions:

MCPK-8-T see page #2

MCPK-8-S see page #8
Following are instructions for assembling Samtec's MCPK-8-T Series AccliMate™ IP67 Sealed Cable Assembly.
CABLE/WIRES PREP

1. Strip the cable/wires according to FIG 1.

![FIG 1](image)

CRIMP WIRES

2. Crimp TC114-XXXX-X-X terminals onto stripped wires according to TC114-XXXX-X-X specification.

ADD COMPONENTS TO CABLE

3. Samtec recommends applying Loctite 7649 primer to the internal threads of CN-30-8. Slide CR-30-8, SPR-30-8, CG-30-8, CC-30-8, and CN-30-8 components on the cable as shown in FIG 2.

![FIG 2](image)
INSTALL HOLDER BODY

4. Poke crimped wire with TC114-XXXX-X-X terminals into SUB-MCP-8 until their retention features lock into place. As a reference, the Samtec logo “S” will be in the up position and the retention lance on the terminal will also be up.

FIG 3
**SUB-MCP-8 PREP**
5. Samtec recommends applying Loctite 7649 primer to the threads of SUB-MCP-8.

![FIG 4](image)

**POSITION COUPLING RING**

![FIG 5](image)
**POSITION SPRING, CLAMP, AND GASKET**


![Diagram of cable assembly with labeled parts CAT-TF-MCX-8-01, CC-30-8, CR-30-8, CG-30-8.]

**FIG 6**
INSTALLING CABLE NUT

8. Samtec recommends applying Loctite 271 adhesive to the internal threads of CN-30-8. Thread CN-30-8 onto SUB-MCP-8. Torque to 0.5N (4.4 IN-LBS) using CAT-WR-MCX-8-01.

For additional questions regarding assembling any of Samtec’s AccliMate™ line of sealed systems, please contact Samtec’s Interconnect Processing Group at +1-800-SAMTEC-9 (USA & Canada) or +1-812-944-6733 or email us at ipg@samtec.com.
Following are instructions for assembling Samtec’s MCPK-8-S Series AccliMate™ IP67 Sealed Cable Assembly.

- CN-30-8
- CG-30-8
- CC-30-8
- CC393-XXXX-X-X
- SPC-30-8
- SUB-MCR-8-12
- SUB-MCR-8-12
CABLE/WIRES PREP

1. Strip the cable/wires according to FIG 8.

\[ 18.00 \pm 1.00 \pm 0.709 \pm 0.039 \]

SEE CC393-XXXX-X-X FOR SPEC

FIG 8

CRIMP WIRES

2. Crimp CC393-XXXX-X-X contacts onto stripped wires according to CC393-XXXX-X-X specification.

ADD COMPONENTS TO CABLE

3. Samtec recommends applying Loctite 7649 primer to the internal threads of CN-30-8. Slide SPC-30-8, CG-30-8, CC-30-8, and CN-30-8 components on the cable as shown in FIG 9.

FIG 9
INSTALL HOLDER BODY

4. Poke crimped wires with CC393-XXXX-X-X contacts into SUB-MCR-8 until their retention features lock into place. As a reference, the 1st position indicator will be in the up position and the retention lance on the contact will also be up.

FIG 10
POSITION SPACER, CLAMP, AND GASKET


FIG 11
**SUB-MCR-8 PREP**


![FIG 12](image)
INSTALLING CABLE NUT

7. Thread CN-30-8 onto SUB-MCR-8. Torque to 0.5N (4.4 IN-LBS) using CAT-WR-MCX-8-01

FIG 13

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