MCRK-8 Series Assembly/Wiring Instructions

Following are instructions for assembling Samtec’s MCRK-8 Series AccliMate™ IP67 Sealed Circular Cable Assembly, receptacle version, using our Field Termination Kit.
CABLE/WIRES PREP

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

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SEE CC393-XXXX-X-X FOR SPEC
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![FIG 1](image1)

CRIMP WIRES

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

ADD COMPONENTS TO CABLE

3. Slide PG-30-8, LW-30-8, and PN-30-8 components on the wires as shown in FIG 2.

![FIG 2](image2)
INSTALL HOLDER BODY
4. Poke crimped wire 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.
INSTALL GASKET, PANEL, LOCK WASHER, AND NUT

5. Slide PG-30-8 forward to seat against SUB-MCR-8 flange. Insert assembly into panel (See Appendix 1 for recommended panel cutout). Slide LW-30-8 forward to seat against panel. Torque PN-30-8 onto SUB-MCR-8 to 0.9Nm.

CAUTION: Over tightening the nut could result in an imperfect seal.

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.
APPENDIX 1

RECOMMENDED PANEL CUT OUT