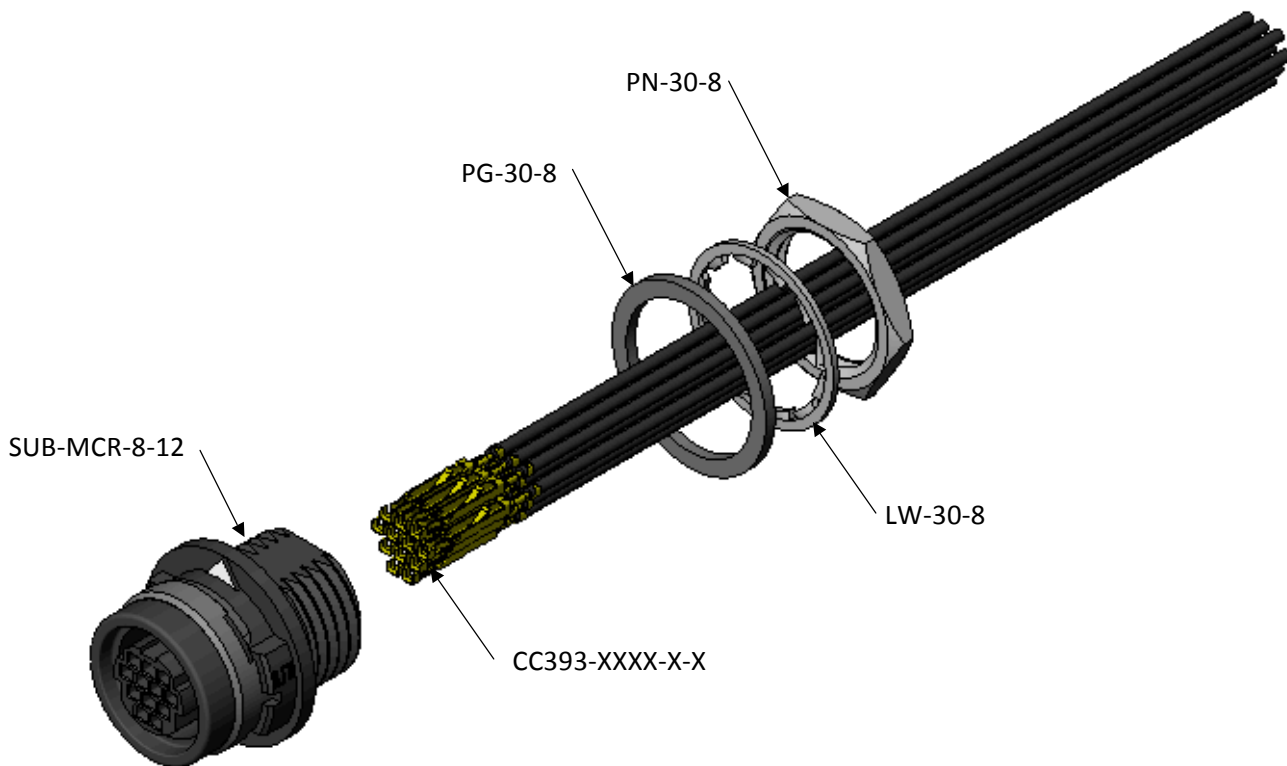


MCRK-8 Series Assembly/Wiring Instructions

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.

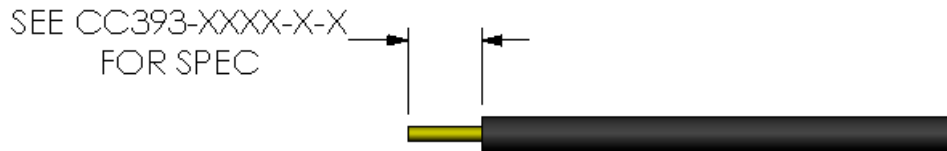


FIG 1

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.

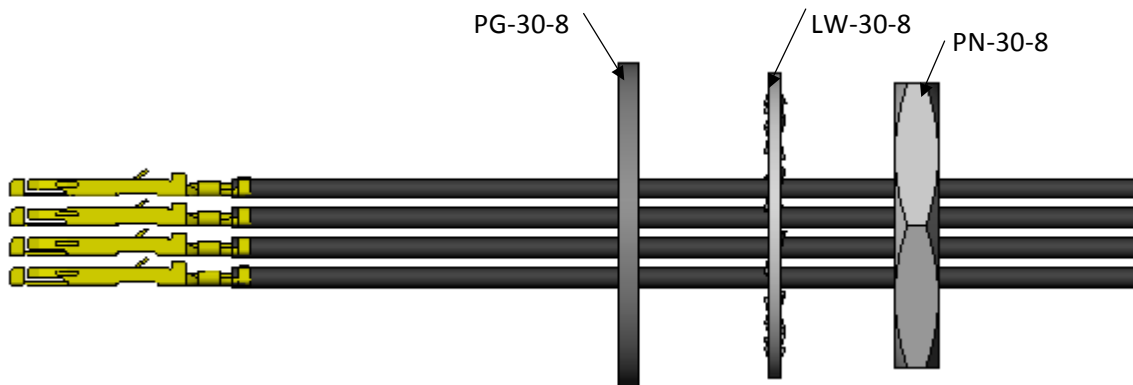


FIG 2

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.

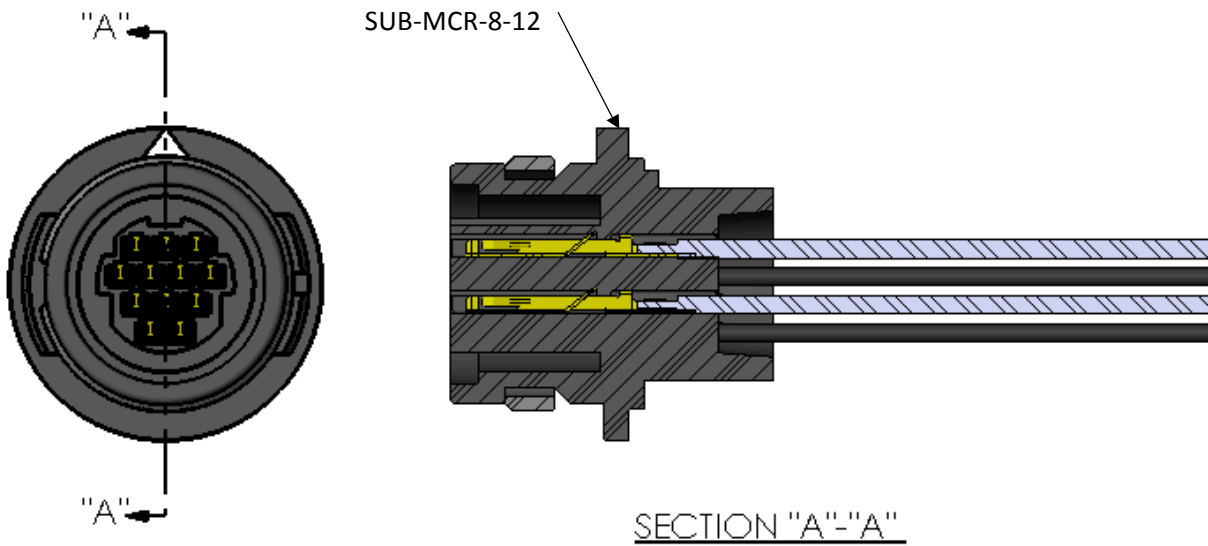


FIG 3

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.

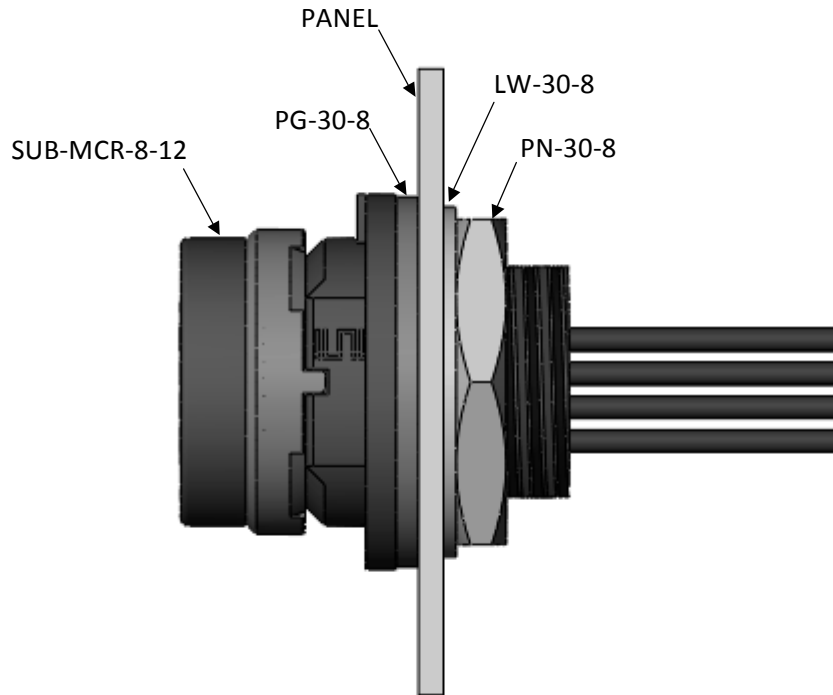


FIG 4

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

