

## 032200 / 033200



## 036000 / 036500



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## 1. Product types

### Solder variants 032200 / 033200

Plug and threaded coupling, optimized assembly, protected against vibration, shielded, with solder connection, for cable diameters up to 10mm.



Acc. to data sheet 032200 01



Acc. to data sheet 033200 01

### Crimp variants 036000 / 036500

Plug and threaded coupling, optimized assembly, protected against vibration, shielded, with empty housing for crimp contacts, for cable diameters up to 10 mm.

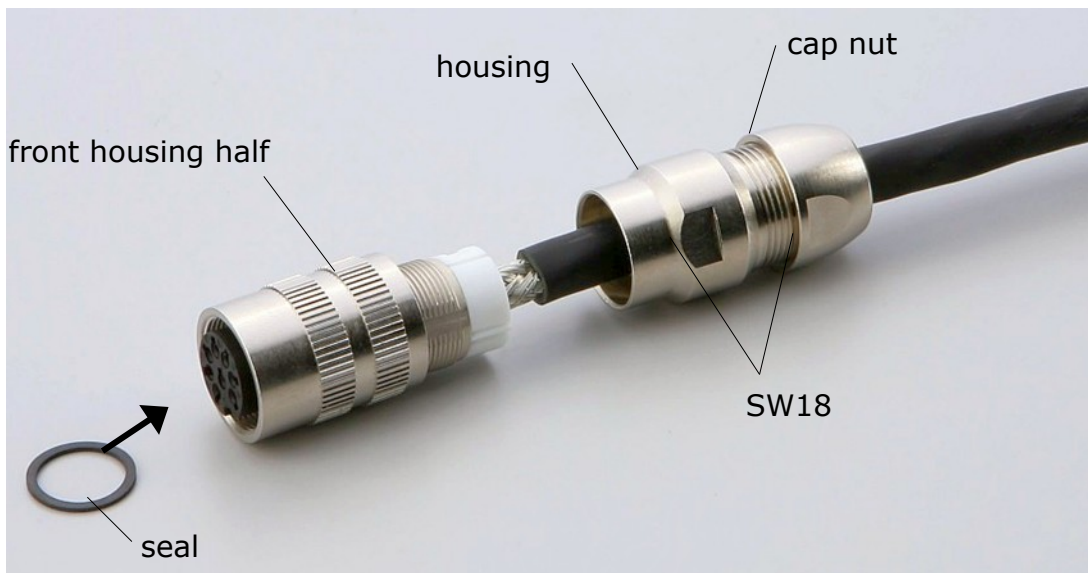
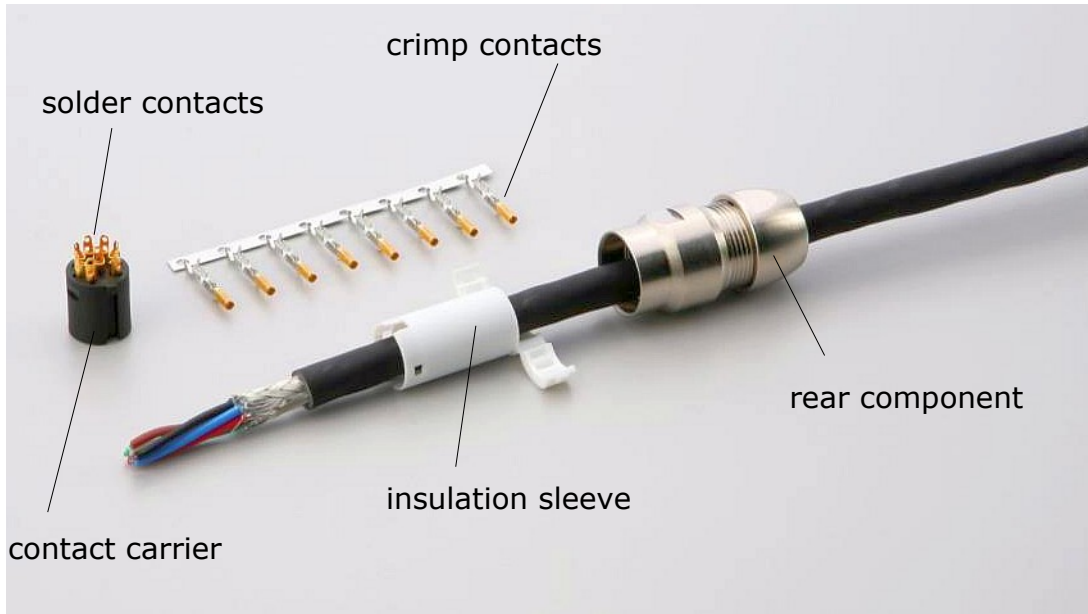


Acc. to data sheet 036000 01



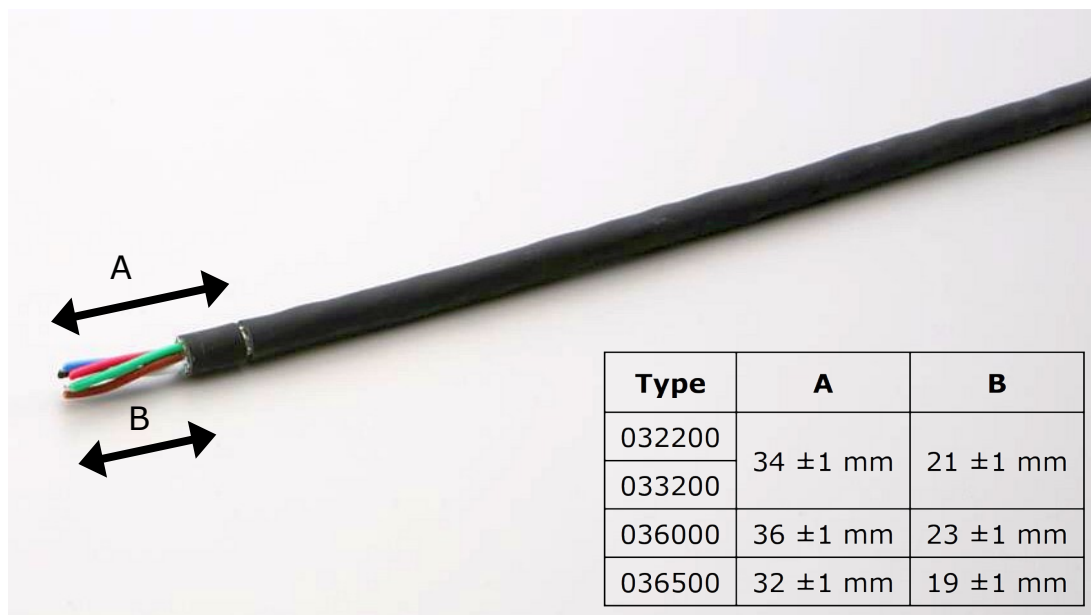
Acc. to data sheet 036500 01

## 1.1. Part description



## 2. Assembly instructions

### Step 1: Strip the cable



### Step 2: Expose the braided shield



## Step 3: Thread through the rear component and the insulating sleeve

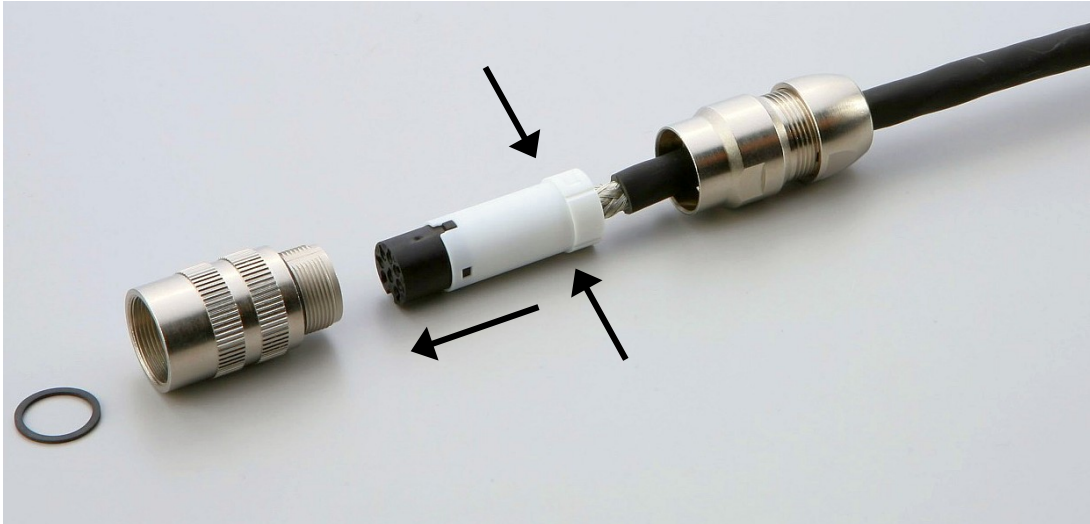


## Step 4: Connect the contacts





## Step 5: Snap in the insulating sleeve and close it



## Step 6: Push the contact carrier in the front housing half





## Step 7: Insert the front seal (Only for couplings)



## Step 8: Visual check for position of rear seal



## Step 9: Screw on the housing

Use the assembly wrench 0380 and an 18 mm open-end wrench

Tightening torque 3 Nm



## Step 10: Tighten the cap nut

Use the assembly wrench 0380 and an 18 mm open-end wrench or two 18 mm open-end wrenches

Tightening torque 3 Nm



## Step 11: The assembly is completed

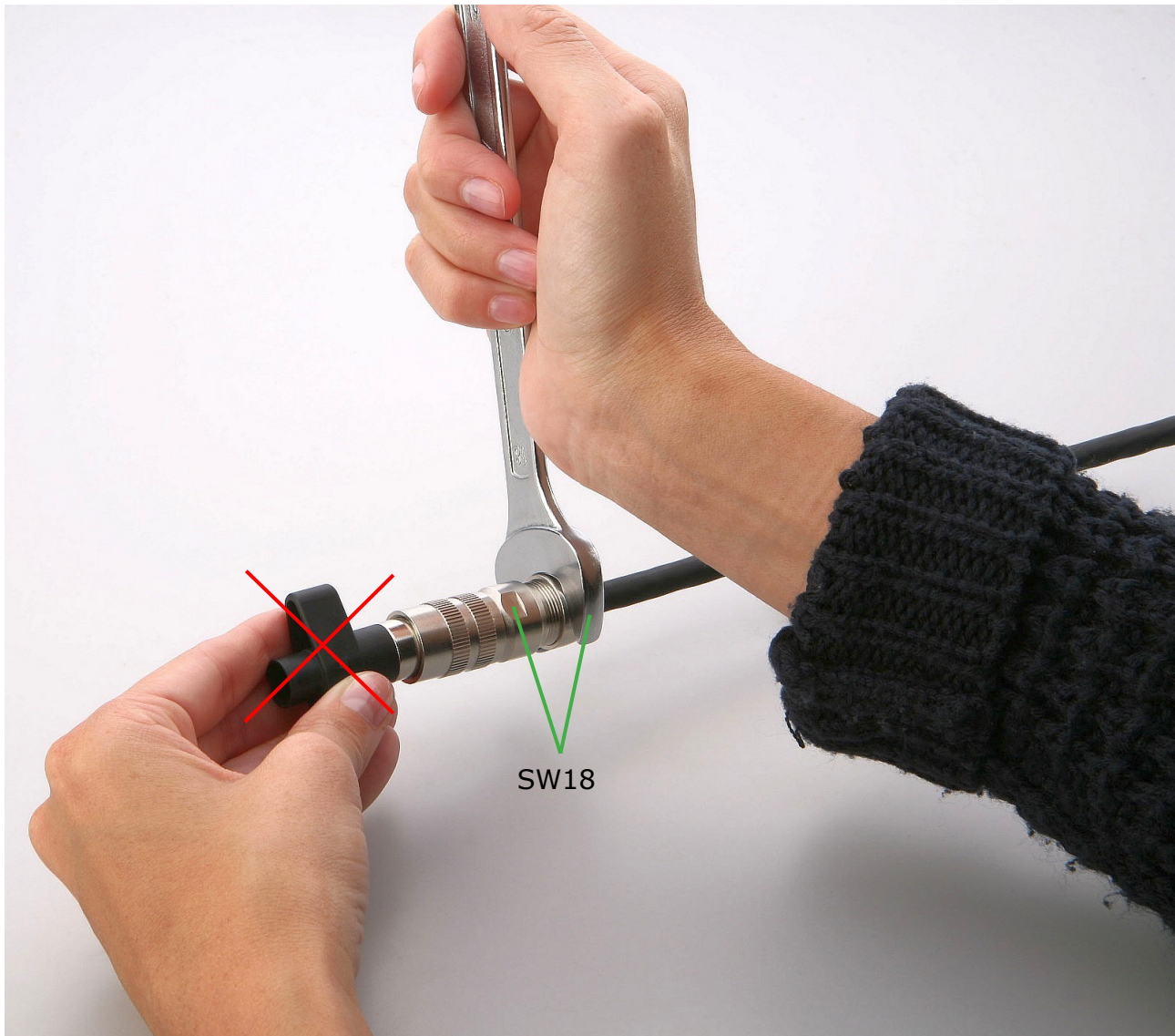




## 3. Disassembly instructions

### Step 1: Loosen the cap nut

Caution! The cap nut must be loosened using two 18-mm open-end wrenches.



**Step 2: Further disassembly is carried out in reverse order.**

## 4. Quality assurance

For all working and processing steps and alterations (e.g. product launch, changes of the cable, changes of the tool or machine...), which may affect the product quality, the responsible departments have to take care for appropriate quality assurance steps.

### 4.1. Quality features

The following quality features must be taken into consideration:

- Stripping
- Assembly sequence
- Location of seals
- Tightening torques
- Important recommendations and notices

### 4.2. Stripping

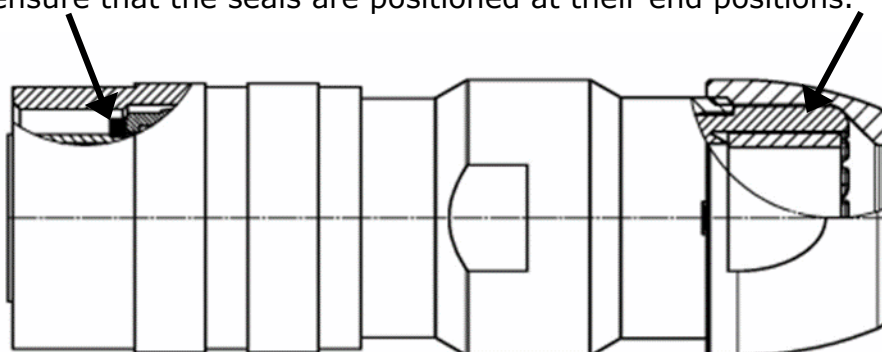
The user must ensure that the individual wire strands are not damaged during the stripping process. The stripping lengths specified in section 2 must be maintained. A tolerance of  $\pm 1$  mm is permitted.

### 4.3. Assembly sequence

Follow the precise order of assembly as described in section 2.


### 4.4. Location of seals

The user must ensure that the seals are positioned at their end positions.



### 4.5. Tightening torques

Use the tightening torques specified in section 2. These also apply to the screwing with the counterpart.

<p>LUMBERG CONNECT GMBH</p> <p>Im Gewerbepark 2 58579 Schalksmühle</p>	<p><b>Processing Instruction</b></p> <p><b>Circular connectors</b> <b>AISG – Next Generation</b></p>	<p><b>Lumberg</b>  passion for connections</p> <p><b>03V01EN</b></p> <p>Page 15 of 15</p>
<p><b>4.6. Important recommendations and notices</b></p> <p>Any use of auxiliary substances (lubricants, oil, fats, etc.) during the assembly is not permitted. Any type of contamination during assembly (from dust, moisture, etc.) will have a negative impact on the lifespan and functionality of the system. Thus, it is very important to carry out the assembly in clean surroundings.</p> <p><b>5. Storage</b></p> <p>Tin-plated and silver-plated surfaces can undergo a physical aging process that may negatively affect their ability to be soldered. In order to maintain the best connection characteristics, make sure that the following instructions are closely followed during additional processing steps:</p> <p>Storage conditions: The parts should ideally be stored in the original packaging, at a constant temperature of 21 – 25° C, with a relative humidity of no more than 55%. The components should not be exposed to direct light. They should also be protected from any extreme ambient conditions (such as air pollution).</p> <p>The storage time should be kept as short as possible, especially for silver-plated components and for solder connections in general. Our experience is that tin-plated components can be soldered for about a year after delivery when using the proper conventional flux. Silver-plated components, owing to their physical characteristics, should be processed within about six months of delivery.</p> <p>These specifications are based on experience using components stored under optimal conditions. They do not constitute a binding commitment for the fulfillment of any characteristics.</p> <p>Ask Lumberg for more information about alternative packaging options for other temperatures and environmental conditions.</p>		