

Instruction for assembly of Master Link plugs with hand tools



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The tool kit consists of 3 tools.
Tool A for removal of the cable sleeving,
tool B for making the connections with the
inner wires of the cable and tool C for
crimping the chassis ferrule.



Use tool A to remove 35 mm of the outer
sleeving of the cable. This is done by
pushing the cable through the small hole in
the tool in such a way that the cutter is on
the left. Turn the tool in direction MIN
(anti-clockwise) a couple of times, the pull
off the outer sleeve.



Remove the white foil.



Pull the black cover and the chassis ferrule onto the cable, the wider end of the ferrule must point towards the plug.



Unwind the twisted pairs. Remove the 3 screen foils. Use a small sharp tool, e.g. a small screwdriver to 'tear' the foil. Tear the outside. This makes it easy to remove the foil with your fingers.

Straighten each wire to make sure they do not twist.



Bend the 3 ground wires backwards along the outer sleeve.

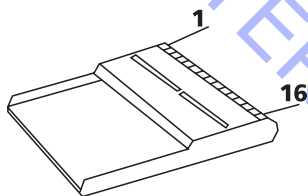
Mount the small plastic part.



Mount the wires and the ribbon cable in the small clear plastic part as shown in the survey below:

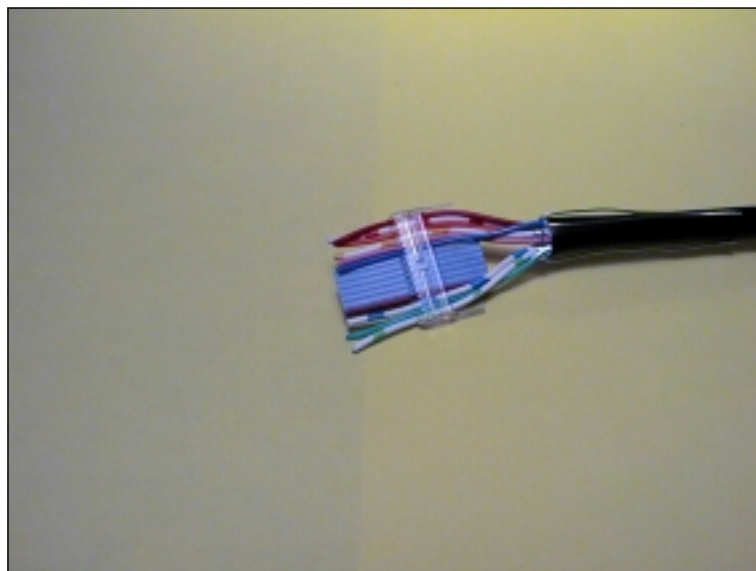
- 1 Green/white
- 2 Green
- 3 Blue/white
- 4-10 Ribbon cable
- 11 Blue
- 12 Pink
- 13 Orange/white
- 14 Orange
- 15 Red/white
- 16 Red

Push the wires through the plastic part. Make sure that the cables are not twisted or twisted as little as possible.

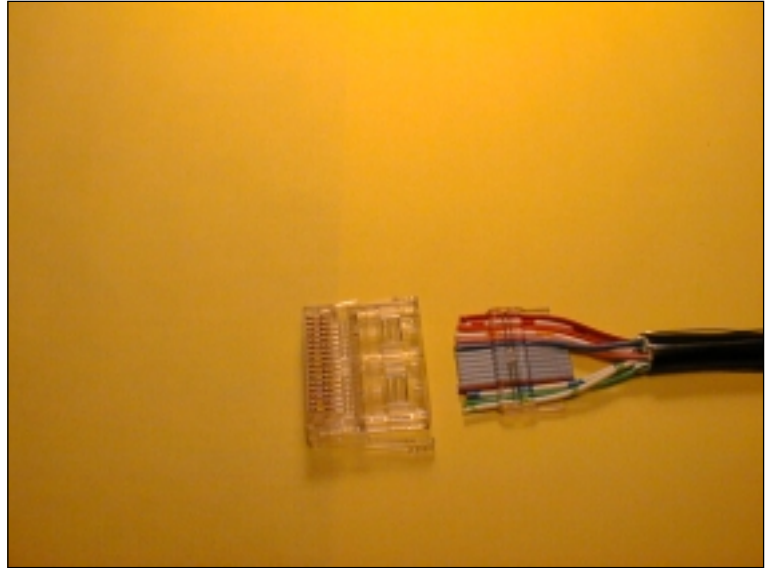


Press the plastic part as far towards the cable as possible. The wires must still be parallel.

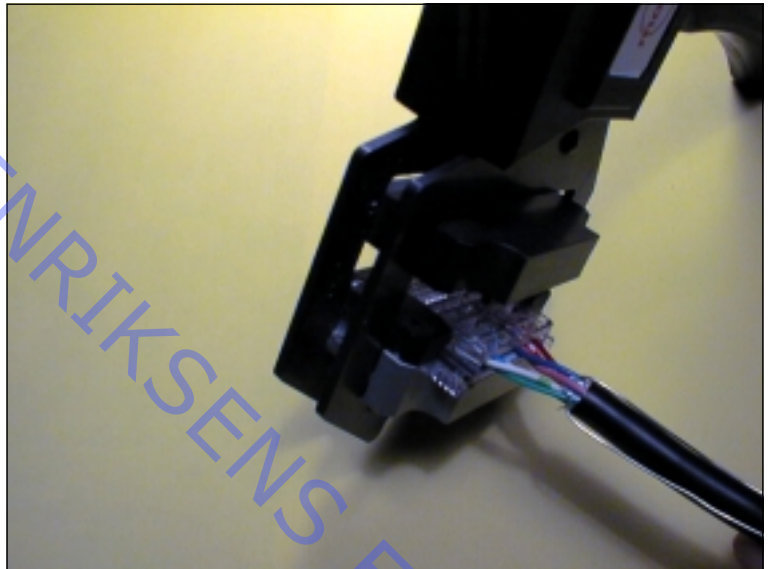
Cut the wires so they are approx. 9 mm from the plastic part.



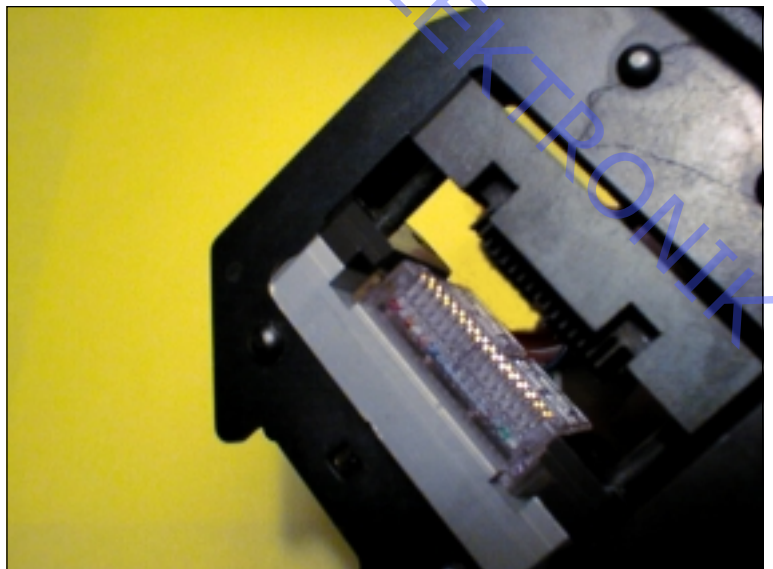
Mount the plastic part in the plug housing.



Place the plug in tool B.

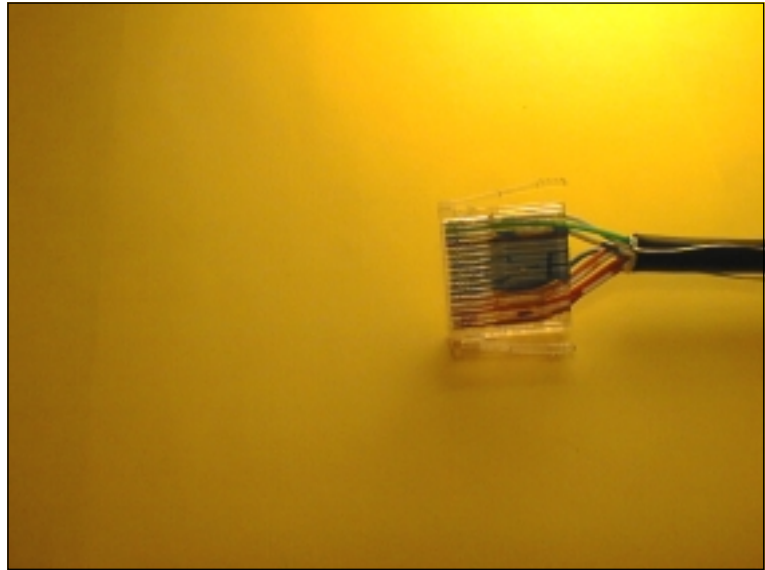


PUSH THE WIRES **completely in** and check this on the left side of the tool. Activate the tool.



The connections to the insulated wires have now been made.

If the wires are not completely in, the result is poor connections and thereby intermittent fault in the Master Link installation.



Mount the shield on the plug, placing the side with the two holes (indentations) on the same side as the switches on the plug.

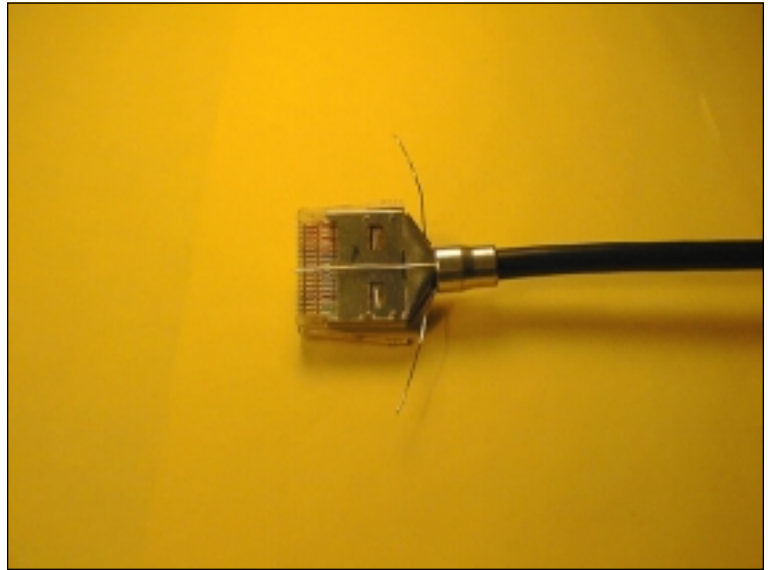


Press the shield together until a small click is heard.



Bend the 3 chassis wires upwards along the shield.

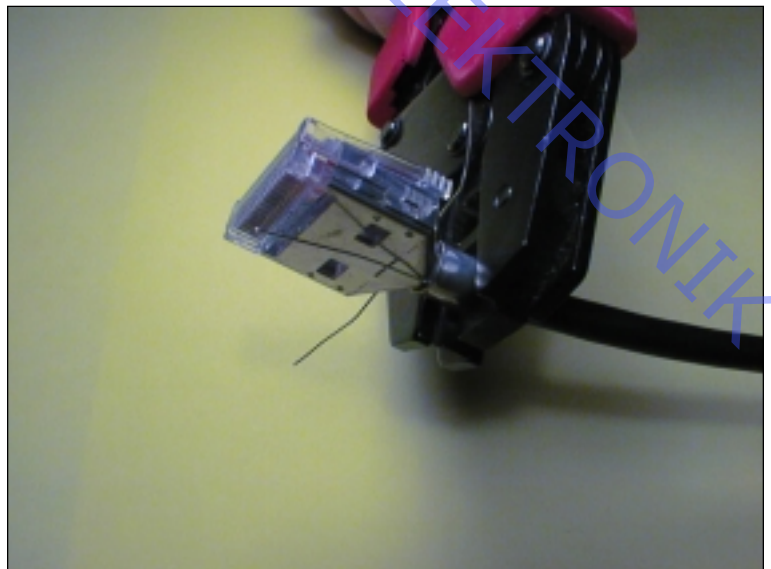
Push the chassis ferrule up and press it thoroughly over the shield.



Place the plug in the inner jaws of tool C and crimp the part nearest to the shield.



Place the plug in the outer jaws of tool C and crimp the other part of the chassis ferrule.



Cut off the 3 chassis wires as close to the chassis ferrule as possible.

Pull up the outer cover and push it into place.



The plug is now assembled and ready for use.



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