

Step 1: Slide over plastic connector cap, rubber seal and 2 x grounding rings.

Step 2: Strip back orange outer insulation 32mm from end of cable

Step 3: Trim and strip back Stainless braiding & white insulation 22mm from end of cable.

Step 4: Push the crimp lug over the conductor strands and until they bottom out in the lug.

Step 5: Using the hand/air crimper, crimp down the lug on to the conductor strands.

Step 6: Slide the smaller grounding ring up flush to the edge of the orange insulation

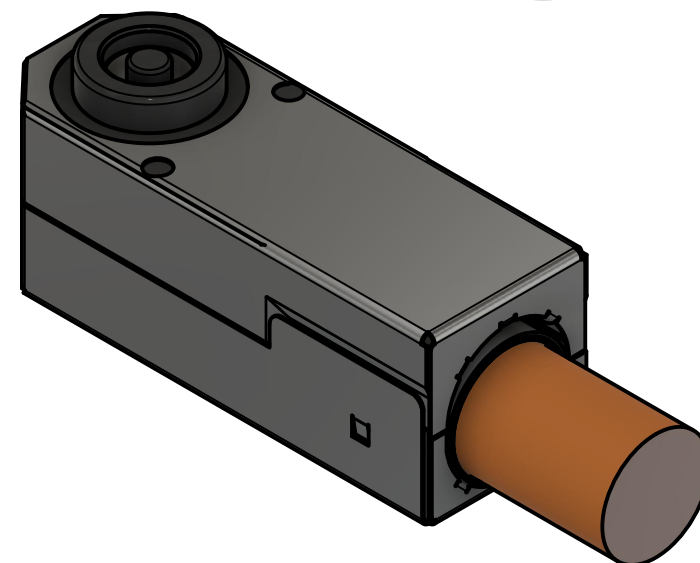
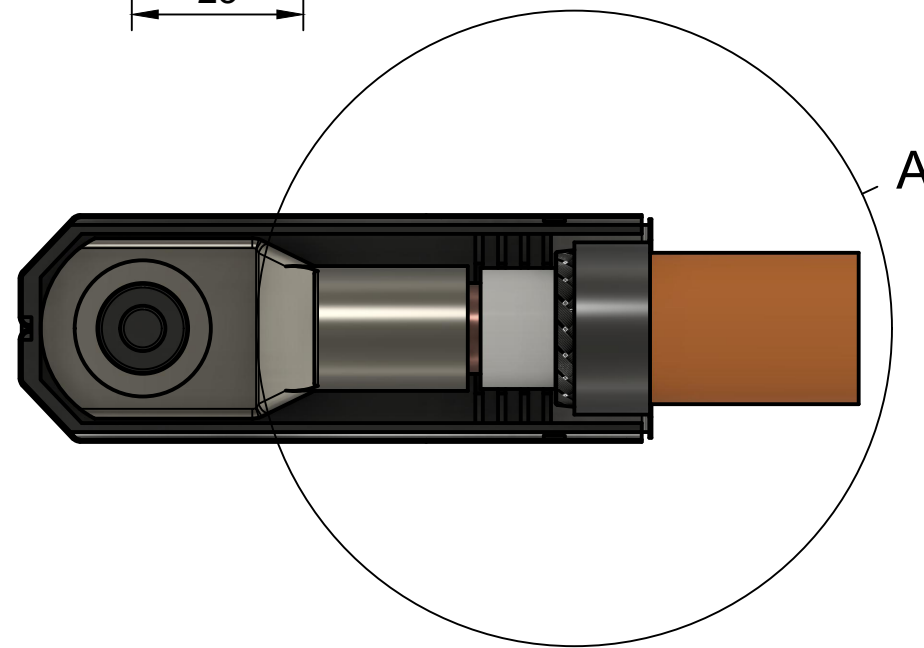
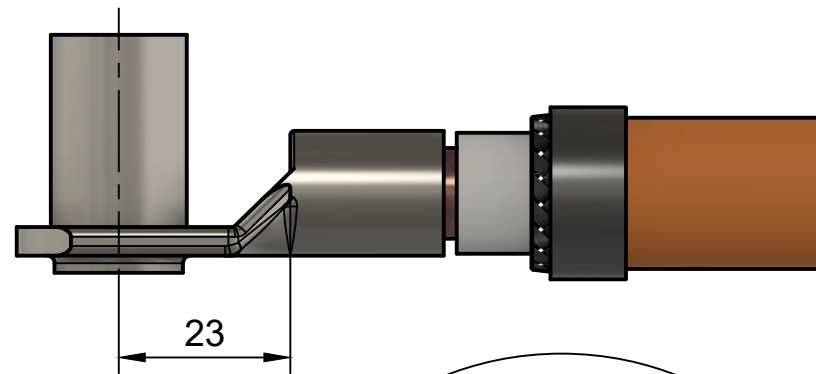
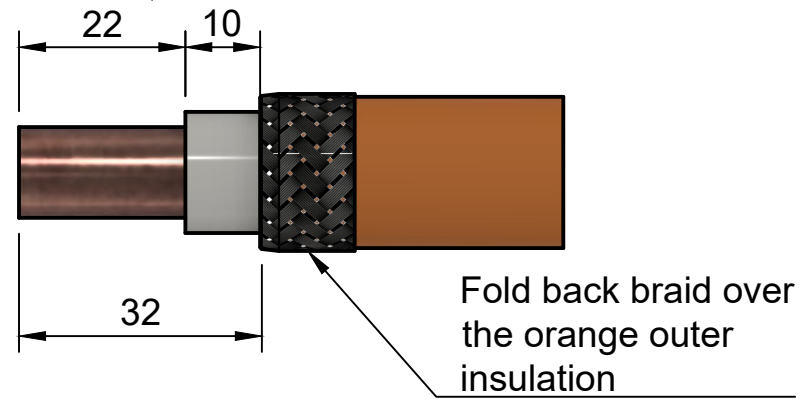
Step 7: Fold back 10mm of the braided shielding over the smaller grounding ring.

Step 8: Slide the larger grounding ring over the top of the braiding/small grounding ring.

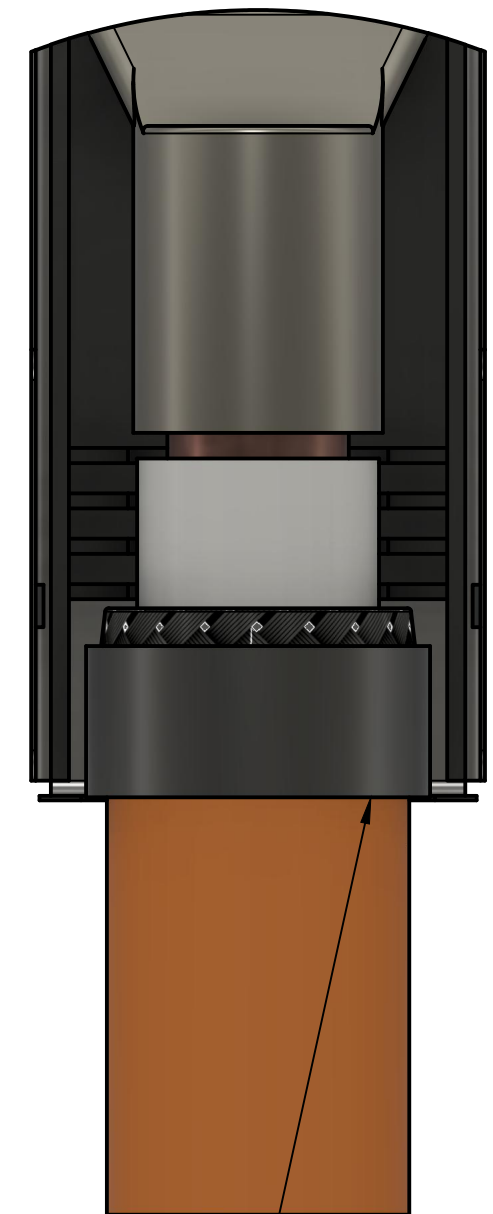
Step 9: Lower the Lug over the plastic post on the base cartridge, while holding grounding rings flush with the back edge of the cartridge

Step 10: Fit the upper cartridge case over the lug and onto the base.

Step 11: Cartridge can be fitted into the connector body. The rubber seal, plastic wedge and plastic cap can be fitted.



A (2:1)



Ensure grounding rings sit flush with the back edge of the cartridge

- Notes:
- Use wire strip tool for the outer insulation
 - Use sharp razor blade to cut white insulation
 - Use Flush cut snips to trim braid to length
 - Take care when using sharp tools
 - Ensure no stray braid fibres get crimped or touch HV lug

Scale: 1:1 Rework Instructions



Created By: Josh Bailes 27/10/2021

Title: 70mm2 Jonhon Connector Cartridge Cutting info

Project: Zero EV

Rev.	Date of issue	Sheet
01	27/10/2021	1/1