Assembly Instructions

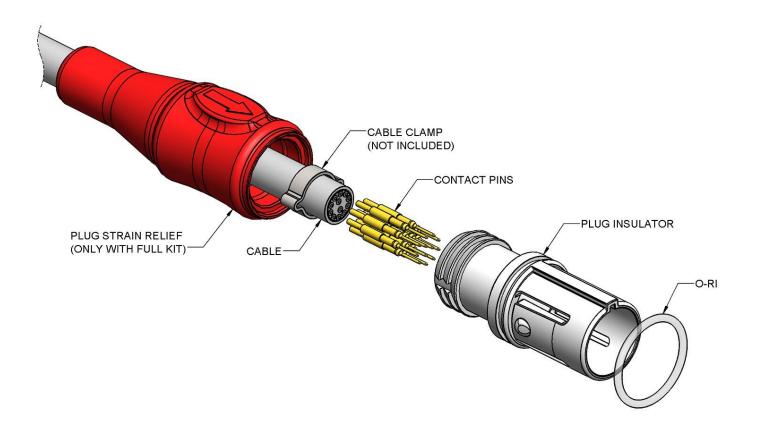## HyperGrip® Disposable Plug

April 2022

Do Not Discard, Deliver to Manufacturing.
No Descartar, Entregar A Fabricación.
Instructions De Montage, Ne Pas Jeter.
Bitte nicht wegwerfen, bitte an die produktion weiter liefern.

Assembly Instructions

Disposable HG Plug Kits

Disposable HG Plug	
Disposable HG2 Plug Full Kit	800-1012659-0XX
Disposable HG4 Plug Full Kit	800-1005739-0XX
Disposable HG2 Plug Kit without Strain Relief Boot	800-1012659-1XX
Disposable HG4 Plug Kit without Strain Relief Boot	800-1005739-1XX

Step 1: Slide strain relief boot (Full Kit), and cable clamp (not included*) onto cable as depicted below

Note: Components depicted in images are representative of Disposable HG2 Plug; Assembly of Disposable HG4 Plug follows the same process
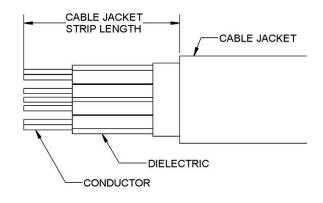
Crimp Termination Instructions
Step 2:

Trim and strip cable to length

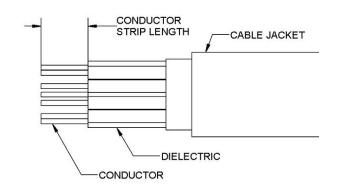Trim 18.0-19.0 mm of cable jacket (Disposable HG2)

Trim 19.0-20.0 mm of cable jacket (Disposable HG4)

Step 3:

Strip wire to expose 5.0 mm of conductor (Disposable HG2)

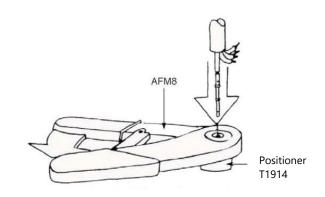Strip wire to expose 4.0 mm of conductor (Disposable HG4)

Step 4:

Insert conductor into contact crimp barrel

Step 5:

Insert contact into position as shown

Crimp the contact

AFM8

Positioner T1914

Step 6:

Insert contact into plug insulator

Step 7:

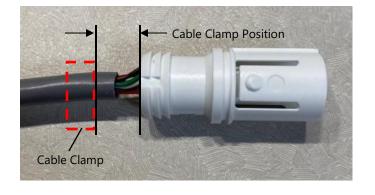Push in contact with Insertion Tool #T2080

Step 8 (Optional):

Suitable cable clamp can be installed to provide additional cable retention force and strain relief

Cable clamp band width 3 mm (MAX)

Positioned and tighten cable clamp 8 mm from the back of insulator as shown

Cable Clamp Position

Cable Clamp

Step 9 (Optional):

Fill rear insulator cup with appropriate silicone RTV or epoxy

Fill potting compound until the cup is full, or at least half-full

This step is recommended d for Ingress Protection rating IPx4

Step 10 (Full Kit, Optional):

Apply beads of silicone RTV or epoxy all the way around the ridges

This step is recommended for Ingress Protection rating IPx4

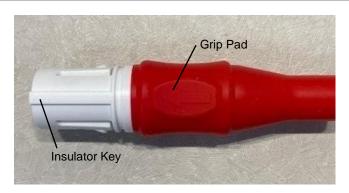Apply silicone/epoxy around the ridges

Step 11 (Full Kit):

Slide strain relief boot along the cable

Press strain relief boot onto insulator

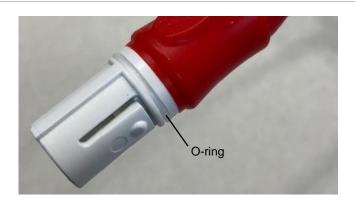

Step 12 (Full Kit):

Align grip pad to insulator key

Grip Pad

Insulator Key

Step 13:

Install O-ring (recommended for IPx4 sealing when mate to receptacle)

Rest plug assembly in an appropriate position and let potting compound cured before usage

O-ring

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