

6	FEMALE PILOT PIN CRIMP CAL.4	899.SP2FP04	2	19
5	IP2X PHASE PIN CAL.10	899.SP2MC10	4	
4	4+E IP2X PHASE MALE PIN	899.SP2SI4	1	
3	CABLE TERMINAL TO SCREW 50-70 <sup>2</sup>	899.SP2FE770S		29
	CABLE TERMINAL TO CRIMP OR SOLDER 70 <sup>2</sup>	899.SP2FE70		29
2	SOCKET CASING		1	
1	EARTH FEMALE CONTACT CAL.10	899.SP2FE10	1	
Ind	Description	Reference	Cont.	Strip. A

PRODUCT REFERENCE

899.AS2DE450V  
899.AS2DE470

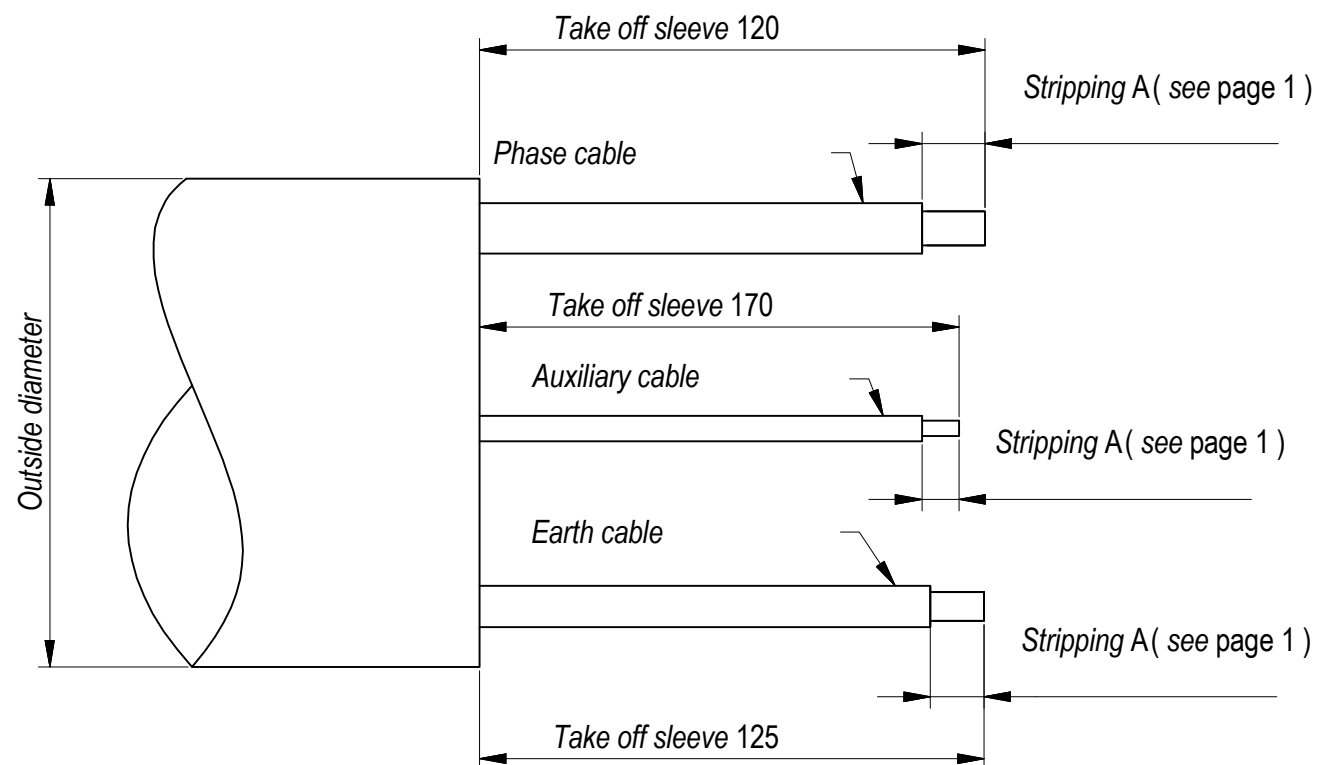
**SCAME**  
S.p.A.  
PARRE - (Bergamo)  
zp90982-21-2\_mp39410

## ASSEMBLY INSTRUCTIONS

- 1- PREPARE THE CABLES AS SCHEME BELOW.
- 2- CRIMP OR SOLDER CABLE TERMINALS (3) ON PHASE CABLES AND EARTH CABLE [ TOOL Nr 6 AND 7 ], FOR CABLE TERMINALS TO SCREW (3) [ TOOL Nr 4 ].
- 3- UNSCREW FLANGE (2.1) [ TOOL Nr 3 ] THEN SLIDE IT OVER THE CABLE WITH SHOULDER SIDE TO THE FRONT. SLIDE SEAL (2.2) OVER THE CABLE TOO.
- 4- ENGAGE EARTH CONTACT (1) IN THE HOLE OF EARTH EAR IN THE MIDDLE OF SOCKET CASING (2).
- 5- PLACE CABLE TERMINAL (3) OF EARTH CABLE AT THE BACKSIDE OF EARTH CONTACT (1), SCREW CONTACT, WHEN CABLE TERMINAL HEXAGON TOUCH EARTH EAR OF SOCKET CASING (2), PUSH IT INSIDE OF EARTH EAR TO BLOCK IT, THEN TIGHTEN CONTACT (1) ( TORQUE 4Nm ) [ TOOL Nr 1 AND 2 ].
- 6- REMOVE SCREWS OF CONTACTS (6) [ TOOL Nr 5 ], INTRODUCE CONTACTS IN FRONT OF IP2X PHASE MALE PIN (4). INTRODUCE PILOT CABLES IN BACKSIDE OF CONTACTS AND PUT SCREW IN CONTACTS THEN TIGHTEN [ TOOL Nr 5 ].
- 7- INTRODUCE EACH CABLE TERMINAL (3) AT THE BACKSIDE OF IP2X PHASE MALE PIN (4), HEXAGON OF CABLE TERMINAL MUST CORRESPOND WITH HEXAGON INSIDE OF THE IP2X PHASE MALE PIN, THEN SCREW CONTACTS (5) IN THE FRONT OF IP2X PHASE MALE PIN ( TORQUE 4Nm ) [ TOOL Nr 1 AND 2 ].
- 8- INTRODUCE IP2X PHASE MALE PIN (4) IN THE SOCKET CASING (2) AND FIX FLANGE (2.1) [ TOOL Nr 3 ].
- 9- PLACE SEAL (2.1) AT THE BACKSIDE OF SOCKET CASING (2).

### LIST OF TOOLS \*

- 1- TORQUE WRENCH FACOM REF. J.306A50
- 2- SOCKETS FACOM : 3/8" Nr14 REF: J.14  
3/8" Nr12 REF: J.12LA
- 3- ANGLED SOCKET WRENCH OR OPEN END WRENCH 10mm
- 4- ALLEN KEY Nr 4  
Nr 3
- 5- FLAT SCREWDRIVER Nr 3
- 6- CRIMPING TOOL KLAUKE HK 120 U
- 7- KLAUKE CRIMPING JAW: 70° REF: HNFF 13/70



\* TOOL REFERENCES ARE ONLY RECOMMENDED AND GIVEN AS EXAMPLES. TOOLS ARE NOT PROVIDED OR IMPOSED BY SCAME.