

## Insertion Tool CIT

### Hand insertion tool



Type of insulator	Description	Order No.	Outer insulation Ø
SS 2P + R to SS 10P + R SSF 8, 9, 10P	CITG-SS-1	121086-3025	1,8-2,8
SSF 2, 3, 4P	CIT-SSF-1	121086-3203	1,8-2,8
MSS 2, 3, 4P+R	CIT-MSS-1	121086-3023	1,4-1,8

### Insertion tip



Type of insulator	Description	Order No.	Outer insulation Ø
SS 2P + R to SS 10P + R SSF 8, 9, 10P	CITG-SS-1-TIP	121586-0076	1,8-2,8
SSF 2, 3, 4P	CIT-SSF-1-TIP	121086-3202	1,8-2,8
MSS 2, 3, 4P+R	CIT-MSS-1-TIP	121586-0074	1,4-1,8

Handle

Order number: 204-8501-002

### Contact holder tip



Type of insulator	Order No.	Outer insulation Ø
SS 2P + R to SS 10P + R SSF 8, 9, 10P	317-8666-005	1,8-2,8
SSF 2, 3, 4P	317-8666-007	1,8-2,8
MSS 2, 3, 4P+R	317-8666-002	1,4-1,8

Guiding pins have to be used for socket contacts. They are not necessary for Mini SURE-SEAL.

Order number: 317-8588-000

Approved lubricating fluid

Isopropyl alcohol

Cleaning solvent (e.g. HAKU 424, Chem. Fabrik Kluthe, Heidelberg, Germany)

## Wiring Instructions

*Note: Insert accessories (e. g. Boot) prior to assembly.*

### Stripping lengths

For jacketed cables the following stripping lengths have to be adhered to.

No. of contacts	min. stripping lengths mm
2, 3, 4	40
5, 6, 7	45
8, 9, 10	50

### Insertion contacts

SURE-SEAL connectors have a one-piece connector body made of rubber. Contacts are inserted from the rear side. They may only be inserted with the approved tools (refer to page 19-23).

Plug or receptacle must be sprayed with lubricating fluid before contact insertion.

### Approved lubricating fluid

Manual insertion

Isopropyl alcohol  
 Cleaning solvent HAKU 1025-975 or HAKU 1025-800, Chem. Werke Kluthe Gottlieb-Daimler Straße 12, 69115 Heidelberg

Semi-automatic insertion

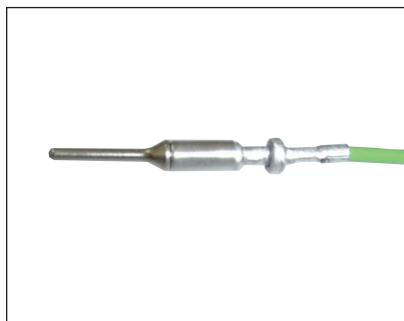
CBITG...and CBITS...Hellerine (HellermanTyton, Grosser Moorweg 45, 25436 Tomesch) for sprayer.

### With hand insertion tools

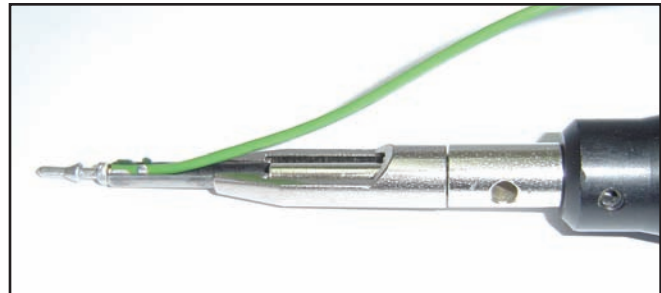
Fasten supports (table, vice etc.)

An inclined position is recommended for easier assembly.

- Dip insulator in lubricating fluid and shake off excess fluid.
- Open fixing clip and place connector body into support block (refer to page 20).
- Insert cable resp. single wires into accessories (e. g. boot).
- Pay attention to correct sequence and position
- Install guiding pin 317-8588-000 (does not apply to Mini SURE-SEAL) in socket contact.



- Place contact in hand insertion tool. The contact shoulder has to touch the front side of the contact tip.

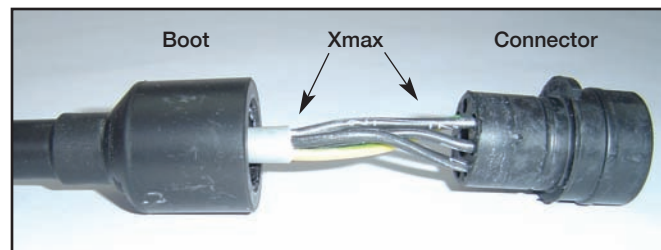


- Insert contact into the connector until it snaps in by applying constant pressure. Note: Make sure that the contact and tool are inserted parallel to the insulator axis. Do not tilt!

*Note: Socket or pin contacts have to be inserted into the correct contact cavity.*

- Remove guiding pins from the socket contacts!
- Mount accessories.
- Remove the terminated connector from support after insertion of all contacts and check correct fit and position of the contacts in the insulator.

### Usage of jacketed cable with boot



No. of contacts	X max.
2, 3, 4	22
5, 6, 7	26

Dimensions shown in mm  
 Specifications and dimensions subject to change

[www.ittcannon.com](http://www.ittcannon.com)

## Wiring Instructions

### With CHPZ-240 hand lever insertion press

Mount correct support block and insertion tip to CHPZ-240 insertion press (refer to page 22).

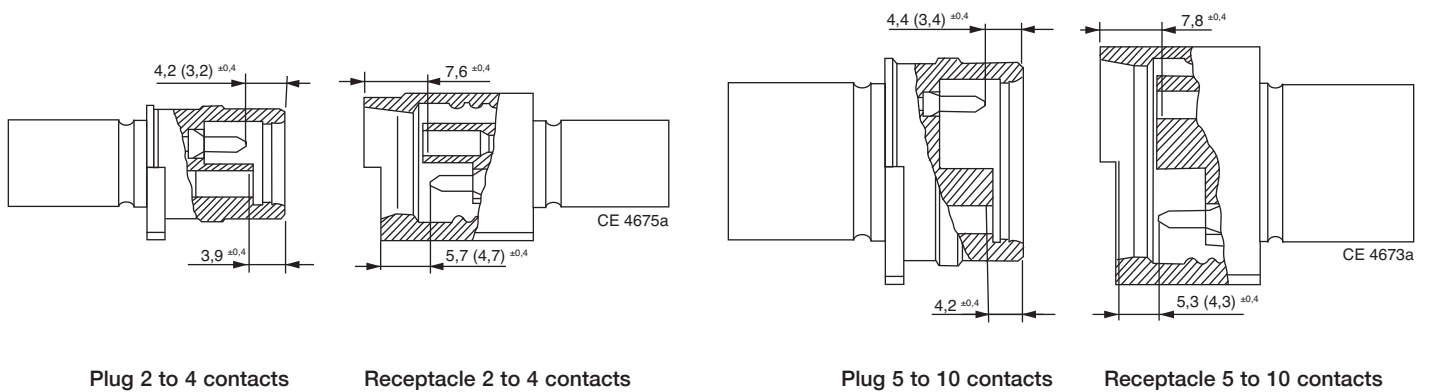
- Dip connector body into lubricating fluid and shake off excess fluid. Open fixing clip and place connector body in support block (refer to page 20).
- Insert wire into accessories. Pay attention to correct sequence and position (refer to illustration page 25).
- Insert guiding pins 317-8588-000 (only for Standard SURE-SEAL) into socket contacts (refer to illustration page 25).
- Place contact into insertion tip. Contact shoulder has to be flush with lower edge of the contact tip.

- Adjust height of hand lever press: For first insertion loosen stop at the upper end of the press. Move down lever slowly and steadily and adjust stop until contact is in the correct position (refer to page 21). Tighten stop. This adjustment may be used for both socket and pin contacts. After this adjustment the lever is simply pressed until stop is reached. Remove terminated connector from support after all contacts are inserted.

- Check fit and position of contacts in insulator.
- Remove guiding pins from socket contacts.
- Assemble accessories.

**For Assembly Machines CBITG and CBITS**  
refer to separate operating instructions

## Standard SURE-SEAL



Different dimensions for machined contacts are given in paranthesis.

## Mini SURE-SEAL

