

# Installation Instructions for Connection Technology:

## General Instructions

Electrical connections should only be made by qualified electricians.

Use personal protective equipment.

Check and ensure the absence of voltage, observe safety rules.

Work under voltage (AuS) should only be performed by specially trained personnel.

Choose suitable connection components (material, cross-section, conductor shape).

Use only approved tools.

Check connection components for suitability: cross-section, shape, material of the conductors.

Remove protrusions (screw remnants, press burrs).

Inspect components for damage before installation and before commissioning.

## 1. Screw Technology

Follow the manufacturer's installation instructions (stripping dimensions, centering parts, sequence, etc.).

Check the suitability of the connector for the conductor class.

Verify and adhere to the printed specifications: conductor cross-section & shape.

Observe the tightening torque (Nm) for set screws and shear-off screws.

## 2. Crimping Technology

Use only suitable tools & components.

Recommendation: DIN connectors/cable lugs + DIN crimping inserts.

Number of crimps & markings according to DIN or manufacturer's specifications.

### Stripping Dimensions:

- Without partition: half the connector length + crimp allowance.
- With partition: insertion depth + crimp allowance (for Al/Cu).

### The sequence of crimps must be strictly followed:

- Cable lug: first crimp on the connection side, then towards the cable.
- Connector: first crimp in the middle of the connector, then outwards towards the cables.
- Incorrect sequence → risk of cracking.



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