



C-LX/SR-2M-M90 Slip Ring Assembly Instructions

C-LX/SR-2M-M90

All soldering should be done by a qualified technician to IPC-610(H) Class 2 standards.

Parts list:

- (1) Mercotac Rotating Connector, Model # 630. 6 Conductor, 250V connector.
- (2) Mercotac Connector Boots P/N: 57630.
- (1) CE-LX5-4M, Lynx Cable from RJG Inc.
- (1) Molex Crimp Tool P/N: 640030100.
- (10) Connector Crimps. They come in the Mercotac hardware bag.

- 1) Cut the 13' Lynx cable 3' from the female connector end.
- 2) Push the 3' cable section through a rubber boot so that the cut end of the cable exits the wide end of the boot. Next slide a plastic ring on to the cable, male end of ring towards the boot.



- 3) Slide a 3" piece of $\frac{3}{4}$ " heat shrink on the cable.

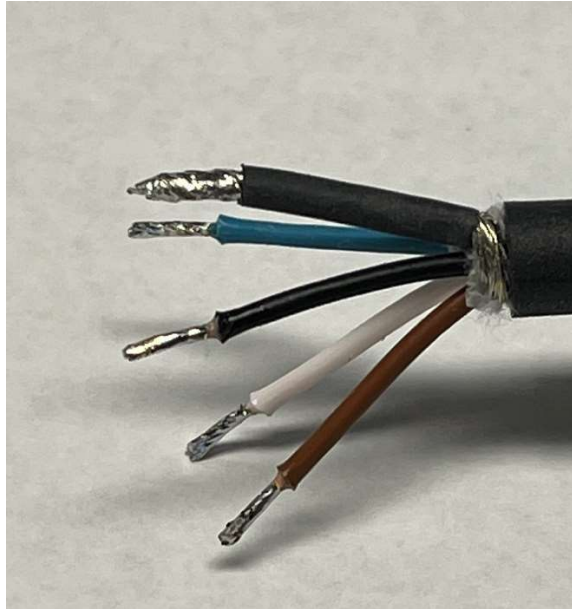




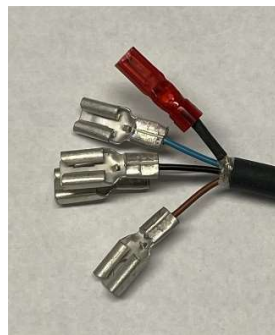
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- 4) Strip the cable $\frac{3}{4}$ ". Strip each wire $\frac{1}{4}$ "; tin all wires including the shield. Put a piece of $\frac{1}{8}$ " heat shrink on the shield leaving $\frac{1}{4}$ " of the wire bare.



- 5) Crimp the straight SILVER lugs to the BLACK, WHITE, BLUE, and BROWN wires, crimp a small RED lug to the shield. Use Molex crimp tool #640030100 and crimp using the **Red** 22-18 slot.



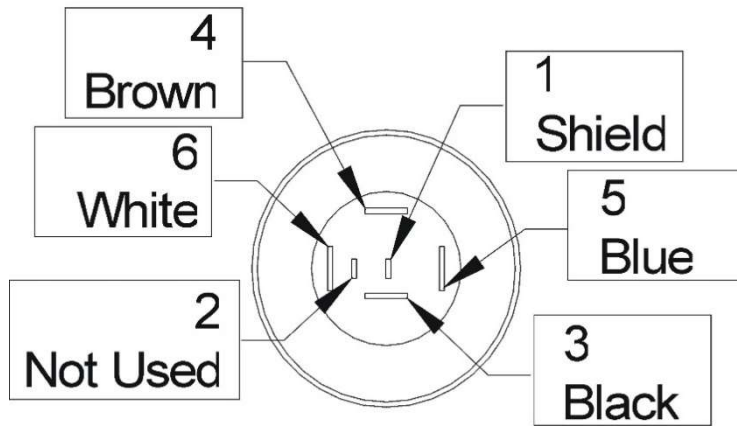
- 6) Shrink a $\frac{3}{4}$ " piece of $\frac{3}{8}$ " heat shrink on each of the metal lugs. Align the ends of the heat-shrink with the ends of the metal lugs before shrinking.

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7) Slide lugs on the connector on the end that does not spin. Reference Figure 1.



Wire Color	Pin
Black	3
Brown	4
Blue	5
White	6
Shield	1
N.C.	2

Figure 1.

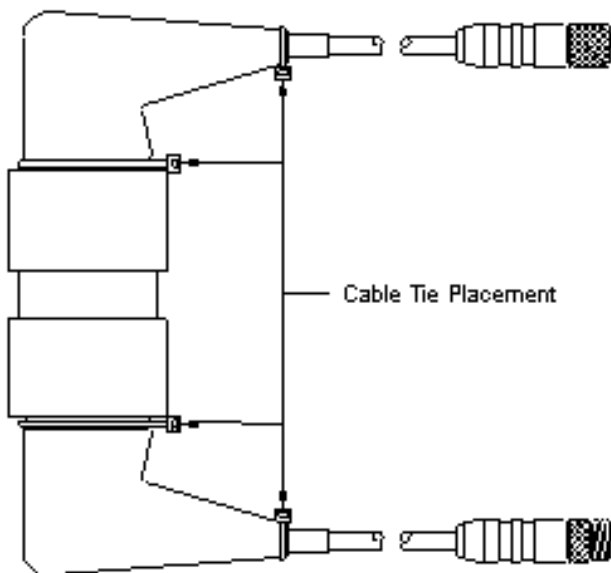
8) Slide the plastic ring over the connector. Slide heat shrink up and shrink. Slide the edge of the boot over the male part of the ring. Tighten the setscrew using a 1/16" hex wrench.

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- 9) Repeat steps 2-8 using the 10' piece of cable with the male connector. Attach it to the spinning side of the connector.
- 10) Attach the boots to the rings using a cable tie over the boot edge into the groove around the male end of the ring.



- 11) Attach (2) cable ties over the edge of the rubber boots.