

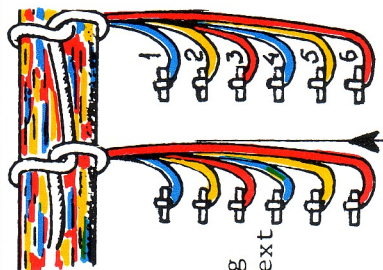


CORRECT WIRING

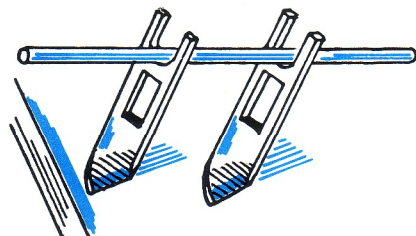
connected wire

The wire must be pressed into the hole in the tag.

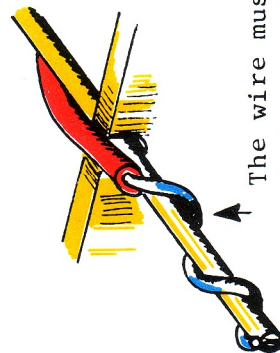
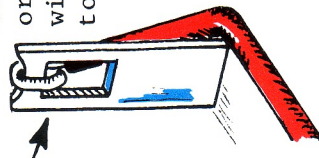
The wires are connected in order, starting with the tag next to the cable.



The lacing is placed over the gap between the tag groups.



Acceptable way of bare wire connection.

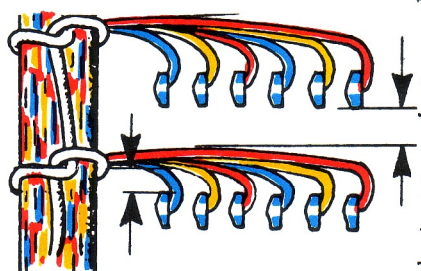


The wire must have a satisfactory mechanical locking, i.e. be securely clamped or wrapped.

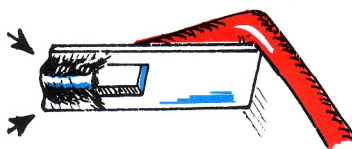


connected and soldered wire

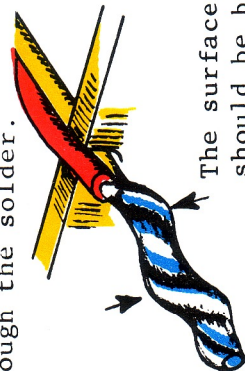
The solder must flow out properly on both sides of the wire.



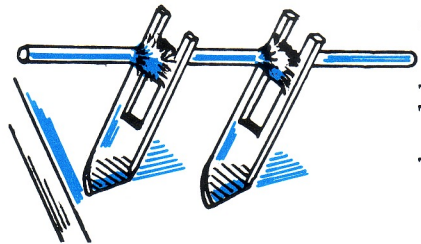
Distance between wires and tags should be min. 1 mm.



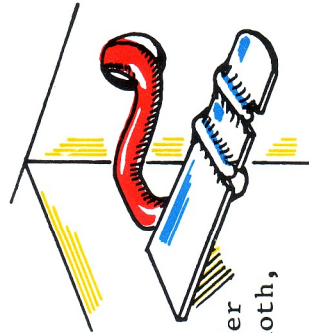
The contours of the wire must be visible through the solder.



The surface of the solder should be bright and smooth, not granular.



There should not be a marked boundary line between solder, tag and wire.



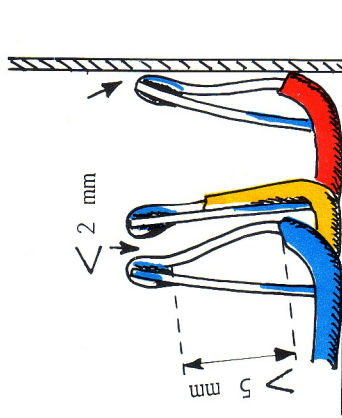


INCORRECT WIRING

X/I 1531-141 Ue 2 (2)

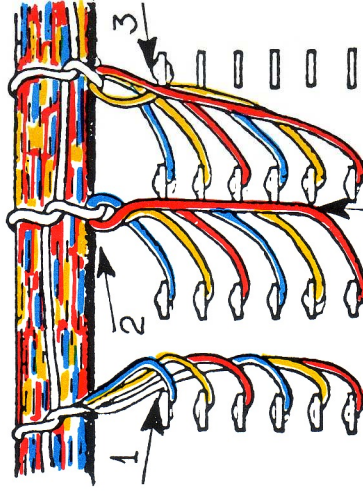
Fault type A

Tags or bare wires are too close or in touch with each other, frame or cover. Too long stripping. Safety distance ≥ 2 mm.



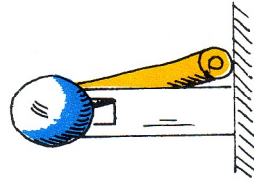
Fault type B

1. Wires are connected in wrong order.
2. Lacing in wrong position, over the tag group.
3. Wires are in touch with other tags.



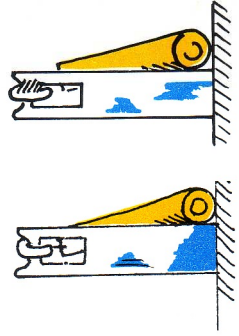
Fault type E

Dry soldering. Bad wetting, too little heat, dirty surfaces, too much solder.



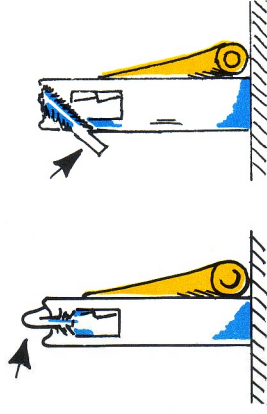
Fault type F

Not soldered or incomplete soldering.



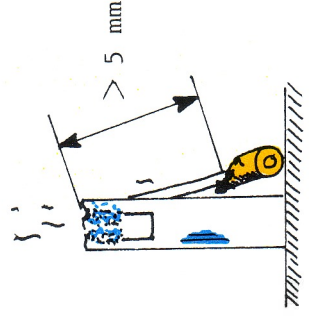
Fault type C

Wire in wrong position, outside the tag or not properly clamped around top of tag.



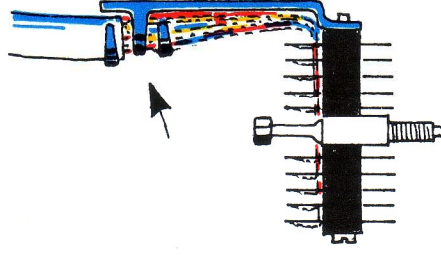
Fault type G

Burnt insulation, too much heat.



Fault type D

Cable or wires badly fixed to bracket, frame, upright etc. Wires press against metal.



Fault type H

Tags in electrical contact, soldered together, or connected by a solder splash.

