77501-29 REVISIONS

SYM	ZONE	DESCRIPTION	DATE	APPROVED
G		REDRAWN WITHOUT CHANGE	1-8-73	
H		(G-H) ECD DOCUMENT NOS. INCORPORATED CHANGED FSCM NO. TO 77820. ECN:	11-10-73 Prescott	

CAT 12-093-6

CONTACT ASSEMBLY PART NUMBER	CONTACT SIZE	FERRULE TYPE	CRIMP TOOLS: CENTER CONTACT CRIMP TOOLS: CRIMP TOOL	TOOL SETTING	CRIMP TOOL	TOOL SETTING	CRIMP TOOL POSITIONER	FERRULE OUTER BODY CRIMP TOOL	HEX DIE DIM ACROSS FLATS +.002: FERRULE CRIMP	OUTER BODY CRIMP	STRIPPING DIMENSION: A ± 1/64	B +1/32 -0	RAYCHEM 48-950	RAYCHEM 48-502	MICRODOT 250-4070	MICRODOT 293-3922	RG 187 A/U RG 179 B/U	RG 188 A/U	RG 180 A/U RG 195 A/U	RG 178 A/U	RG 196 A/U	REVERE (SEE NOTE 1) WA9546-23	GC-18K-I-22S	EQUIVALENT ECD PART NUMBER
348-100-6000P-XX	12	I	294-297 (MS3198-1)	3	294-268 (M22520/2-01)	2	294-1816-01	294-525		.138	7/32	5/32					X							21-33400-541
348-100-6000P-XX	12	I		4		3												X						21-33400-541
348-100-6000S-XX	12	I		3		2											X							21-33401-541
348-100-6000S-XX	12	I		4		3												X						21-33401-541
348-100-6001P-XX	12	I		3		2							X											21-33400-542
348-100-6001S-XX	12	I		3		2							X											21-33401-542
348-100-6002P-XX	12	II		3		2			.118							X			X					21-33400-543
348-100-6002S-XX	12	II		3		2			.118							X			X					21-33401-543
348-100-6003P-XX	12	II		6		5			.118						X									
348-100-6003S-XX	12	II		6		5			.118						X									
348-100-6004P-XX	12	I		7		6								X										
348-100-6004S-XX	12	I		7		6					7/32	5/32		X										
348-100-6005P-XX	12	I		3		2					35/64	7/32					X							
348-100-6005S-XX	12	I		4		3												X						21-33403-541
348-100-6006S-XX	12	I		3		2							X											21-33403-542
348-100-6007S-XX	12	II		3		2			.118							X			X					21-33403-543
348-100-6008S-XX	12	II		6		5			.118						X									
348-100-6009S-XX	12	I		7		6				.138	35/64	7/32		X										21-33403-545
348-100-6010P-XX	16	II		2		2	294-1817-01	294-532	.068	.091	7/32	5/32									X			21-33400-561
348-100-6010S-XX	16	II		2		2			.068	.091	7/32	5/32									X			
348-100-6011S-XX	16	II		2		2			.068	.091	35/64	7/32									X			21-33403-561
348-100-6012P-XX	12	I		6		5	294-1816-01	294-525		.138	7/32	5/32										X		21-33400-546
348-100-6012S-XX	12	I		6		5				.138	35/64	7/32										X		21-33401-546
348-100-6013S-XX	12	I		6		5				.138	7/32	5/32										X		
348-100-6014P-XX	16		SEE INDIVIDUAL CUSTOMER INSPECTION DRAWING FOR ASSEMBLY PROCEDURE																			X		21-33400-562
348-100-6014S-XX	16																					X		
348-100-6015S-XX	16																					X		21-33403-562
348-100-6016P-XX	12																							21-33400-547
348-100-6016S-XX	12																							
348-100-6017S-XX	12																							21-33403-547
348-100-6018P-XX	16	II	294-297 (MS3198-1)	7	294-268 (M22520/2-01)	6	294-1817-01	294-532	.068	.091	7/32	5/32											X	
348-100-6018S-XX	16	II		7		6			.068	.091	7/32	5/32											X	
348-100-6019S-XX	16	II		7		6			.068	.091	35/64	7/32											X	
348-100-6020P-XX	12	II		6		5	294-1816-01	294-525	.118	.138	7/32	5/32										X	X	
348-100-6020S-XX	12	II		6		5			.118	.138	7/32	5/32										X	X	
348-100-6021S-XX	12	II		6		5			.118	.138	35/64	7/32										X	X	

NOTE 1: THIS NO. IDENTIFIES 2 CONDUCTOR INSTRUMENT CABLE ONLY THE SHIELDED CABLE TO BE CRIMPED AS SHOWN IN THE TABLE.

DWG. NO. 123-1514

ITEM NO.	PART OR IDENTIFYING NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION

LIST OF MATERIALS OR PARTS LIST

DRAWN	B. RUYTER	1-4-73
CHECKED	W.K.	1-4-73
APPROVED		1-4-73
EPA/DOR	AI-50-348-26392	9-29-69
ENGINEERING RELEASE No.	10030	1-21-70
INDUSTRIAL ENGRG APPD.		
DESIGN ACTIVITY APPD.		

FINAL ASSEMBLY | NEXT USED ON

MATERIAL

FINISH

AMPHENOL CONNECTOR DIVISION
BUNKER RAMO CORPORATION
BROADVIEW, ILLINOIS 60153

TITLE: CABLE ASSEMBLY PROCEDURE FOR 348 SERIES SHIELDED CONTACTS

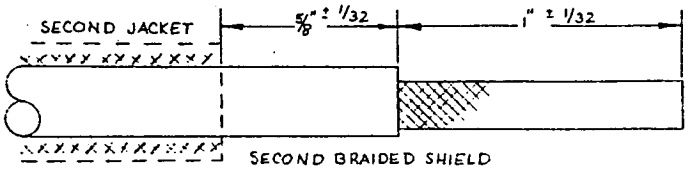
DWG SIZE	CODE IDENT NO.	DRAWING NO.	REV.
D	02660	10-801945	H

SCALE NONE | WT: EST. | ACT. | SHEET 1 OF

STEP 1

Ⓐ STRIP COAXIAL CABLE JACKET BACK 1 INCH

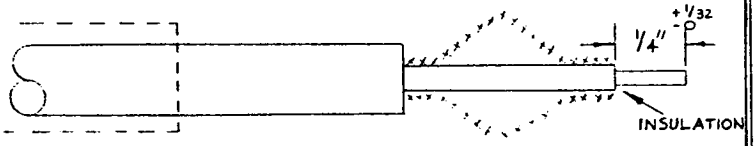
Ⓑ IN THE CASES WHERE TRIAXIAL CABLES ARE USED THE SECOND JACKET & BRAIDED SHIELD MUST BE STRIPPED AN ADD'L 5/8 INCH



CAUTION: DO NOT CUT INTO BRAIDED SHIELD.

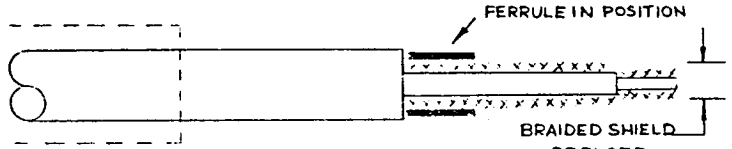
STEP 2

Ⓐ SLIDE BRAIDED SHIELD BACK AND TRIM INSULATION 1/4 INCH



Ⓑ SLIDE BRAIDED SHIELD FORWARD & ROLL BETWEEN FINGERS TO REDUCE DIAMETER.

Ⓒ SLIDE FERRULE OVER BRAIDED SHIELD UNTIL IT RESTS AGAINST THE CABLE JACKET.



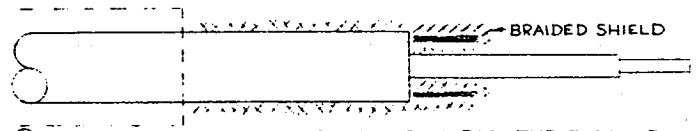
FOR CABLES USING THE FERRULE TYPE I

Ⓓ₁ NO CRIMPING NECESSARY

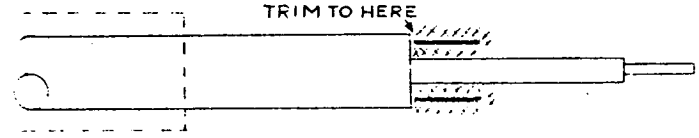
FOR CABLES USING THE FERRULE TYPE II

Ⓓ₂ CRIMP FERRULE USING "A" HEX IN CRIMPING TOOL.

Ⓔ COMB OUT THE BRAID AND FOLD BACK OVER THE FERRULE

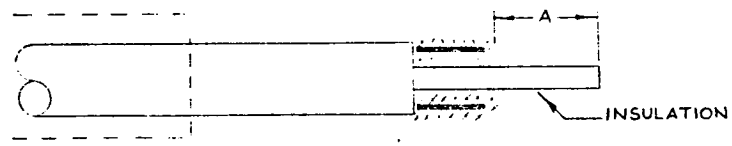


Ⓕ TRIM EXCESS BRAIDED SHIELD EXTENDING PAST THE FERRULE

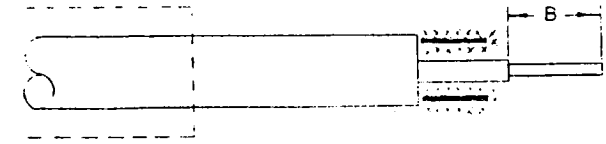


STEP 3

Ⓐ CUT INNER CONDUCTER AND INSULATION TO DIMENSIONS SHOWN IN COLUMN "A" OF TABLE.



Ⓑ STRIP INSULATION FROM INNER CONDUCTOR TO DIMENSIONS SHOWN IN COLUMN "B" OF TABLE



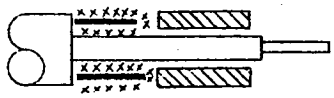
STEP 4

FOR LONG SOCKET CONTACTS WHICH REQUIRE A SLEEVE BETWEEN THE INNER FERRULE AND CONTACT & INSULATOR SUB-ASSEMBLY.

Ⓐ AMPHENOL CONTACT ASSEMBLY NO. 348-100-6007S-XX EQUIVALENT ECD NO. 21-33403-543

INSTALL SLEEVE OVER INSULATION

BUTT INSULATOR SLEEVE AS SHOWN



Ⓑ RESTORE CENTER CONDUCTOR TO ORIGINAL LAY AND INSTALL CONTACT & INSULATOR SUB-ASSEMBLY FIGURES 1-4 ILLUSTRATE THE VARIOUS TYPES OF SUB-ASSEMBLIES.

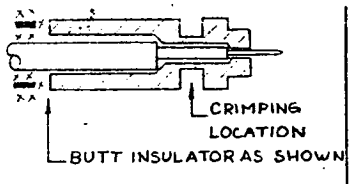


FIGURE 1
LONG SOCKET CONTACT WITHOUT SLEEVE.

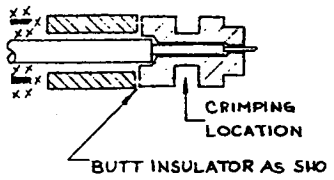


FIGURE 2
LONG SOCKET CONTACT WITH SLEEV

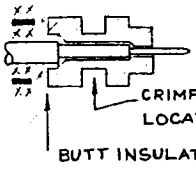


FIGURE 3
SHORT SOCKET CONTACT

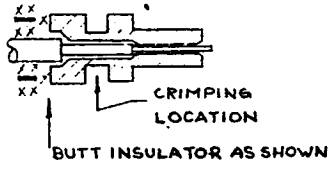
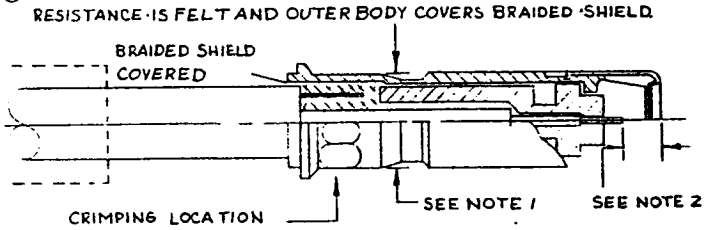


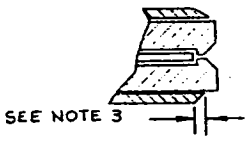
FIGURE 4
ALL PIN CONTACTS

Ⓒ CRIMP CENTER CONTACT THRU INSULATOR WITH CRIMPING TOOL AND LOCATOR LISTED IN TABLE.

STEP 5

Ⓐ INSERT CRIMPED SUB-ASSEMBLY INTO CONTACT BODY UNTIL SOLID RESISTANCE IS FELT AND OUTER BODY COVERS BRAIDED SHIELD.





Ⓑ CRIMP OUTER BODY USING THE "B" HEX IN CRIMPING TOOL.

NOTES:

1. THIS DIM. MUST NOT EXCEED: .163 FOR SIZE 12 CONTACTS .114 FOR SIZE 16 CONTACTS
2. SOCKET CONTACT - THE DISTANCE BETWEEN THE TIP OF THE CENTER PIN CONTACT AND THE END OF THE SOCKET OUTER BODY MUST BE WITHIN .020/.000.
3. PIN CONTACT - THE DISTANCE BETWEEN THE TIP OF THE CENTER SOCKET CONTACT AND THE END OF THE PIN OUTER BODY MUST NOT EXCEED .046.