

A1. See View A1

1. Assemble thermal fit sleeve over the cable outer jacket diameter to dimension shown.
2. Expose sleeve to a temperature of 275°F to 325°F until sleeve recovers and conforms to the cable outer jacket diameter.

A2. See View A2

1. Strip cable as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making the cuts.
2. Assemble ferrule back over the cable jacket and seat against thermal fit sleeve end.

B. 1. Flare shield back over ferrule and strip core insulation as shown.

C. 1. Assemble intermediate pin and inner socket modular assembly over both stripped inner conductors and wire insulation as shown and as follows:

- 1.1 Blue/Black insulated wire goes to the intermediate pin contact wire well.
- 1.2 Blue insulated wire goes to the inner socket contact wire well.
- 1.3 Trim fit both wire insulation lengths and both inner conductor lengths as required. Wire insulation must be inside conical lengths of the short rear insulator portion and the inner conductors must be visible in both wire wells inspection holes.

2. Simultaneously crimp intermediate pin contact and inner socket contact wire wells of the modular assembly using M22520/5-01 tool frame and "Daniels Y690" die set. The Module assembly to be crimped has a flat surface on one side for correct alignment in the Y690 die set.

D. 1. Slide the outer socket contact and insulator assembly over the crimped module assembly and over the shield that is formed back over the crimp ferrule. Module front shoulder must be fully seated in the outer socket contact insulator cavity as shown.

2. Crimp outer contact using a "Daniels GS208 Crimp Tool" and a "Daniels GP780 Positioner".

3. Crimp contact as follows:

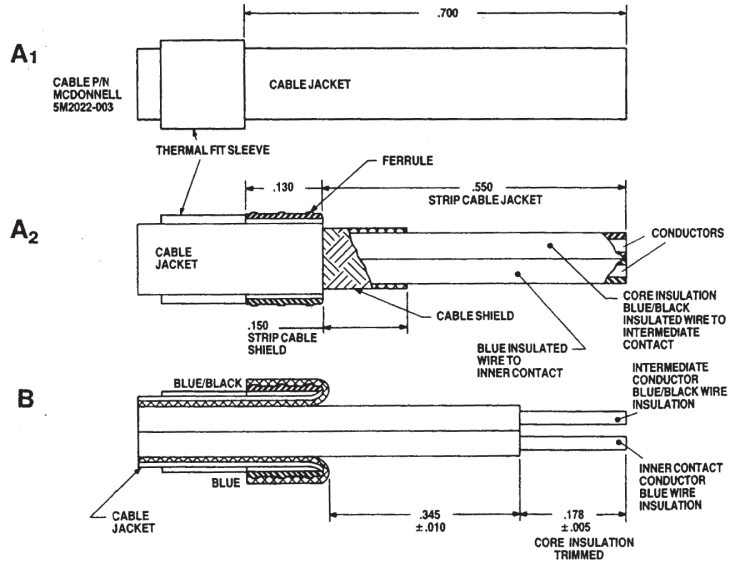
- Crimp once, rotate the contact 45°, and crimp a second time. After crimping the second time, the diameter over the crimped contact area must not be greater than .213 inches.

CONTACT INSERTION:

Using insertion tool Daniels DAK 264-10, insert contact assembly into the correct rear grommet hole, contact must be aligned with hole and not inserted at an angle. Push forward until the contact is felt to snap into position within the insert retention device. Remove tool.

CONTACT REMOVAL:

Position removal tool Daniels DRK 264-10, around cable jacket and slide tool down cable until tool tips enter rear grommet and come to a positive stop. Hold tool tip firmly against positive stop on contact. Grip cable and simultaneously remove tool, contact and cable.



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