

Contact, Pin, Concentric Twinax, Type ARINC 600  
Installation Instructions

1. Assemble crimp bushing, large diameter first, over cable jacket. Strip cable jacket and remove shields as shown. Do not nick or cut shield strands when removing cable jacket.
2. Flair outer shields (Round & Flat) as shown. Cut off filler rods as close to outer shields as possible. Strip inner wires as shown. Do not nick or cut inner wire strands when removing insulation.
3. Assemble insulating bushing over inner wires as shown until bushing butts cable shields as shown. Make certain no cable shield strands enter the bushing opening.
4. Insert cable inner wires into inner/intermediate assembly wire wells (longer inner wire into inner contact wire well & shorter inner wire into raised opening of the intermediate contact wire well). The longer wire insulation should bottom against the inner shoulder of the inner wire well opening & inner wire strands must be visible through the inspection hole of the inner contact. The shorter wire insulation should butt against the raised opening of the intermediate contact wire well.
5. Crimp inner contact using Daniels AFM-2 Crimp Tool (selector setting 6) & K116 Positioner. Crimp the intermediate contact raised wire well using M22520/5-01 Crimp Tool & Daniels Y797 Die Set (Location A). After crimping, the inner and intermediate contact wire wells should be as shown (REF .168 & .062 MAX). Slide crimp bushing forward, under cable shield as shown. Trim cable shield strands even with bushing shoulder as shown (must not extend past or overlap bushing shoulder).
6. Slide outer contact assembly over inner contact assembly until it bottoms against bushing shoulder. A small gap at the bushing shoulder may occur. Crimp outer contact assembly & bushing with M22520/5-01 Crimp Tool & Daniels Die Set Y797 (Location B).

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