21-033469-031 (PLUG)

Transition Adapter, Plug, Quadrax
Type High Speed, to Board
Installation Instructions

See table on reverse side for quadrax cable recommended, tool selector settings, crimping tool, positioner and insertion/removal tool information.

A 1. Cut cable for assembly of transition adapter plug.
Note: Crossing of inner wires from their natural lie position is not permissible.

B 1. Strip cable jacket to expose cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts.

C 1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.

D 1. Flair cable braid back over crimp bushing as illustrated to expose inner wire pairs. Trim excess cable braid.
2. Cut inner wire pairs with foils in place to dimension shown. All wires must be cut to equal length. It may be helpful to cut one wire pair to length. Then, cut remaining wire pair to equal length as the first wire pair.

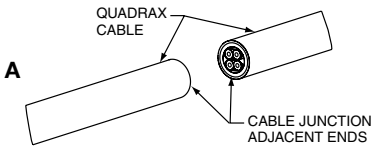
E 1. Strip individual differential pair foil shields as close to flaired cable braid as possible.
2. Strip inner wires to expose center conductors as illustrated. All wires must be stripped to equal length.

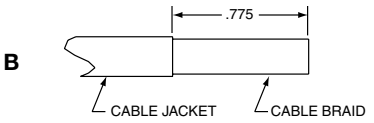
F 1. Carefully splay inner wires perpendicular to the axis of the cable as illustrated.
2. Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through the contact's wire inspection hole, to make certain conductor is properly positioned.
3. Crimp inner contact to center conductor using crimp tools listed in table on back. Repeat steps F2 and F3 until all inner contacts are crimped.

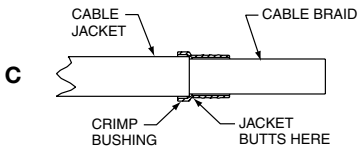
Continued on back

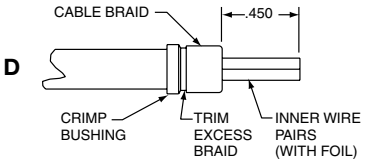
L-2119-DP **FSCM77820**
September 2015

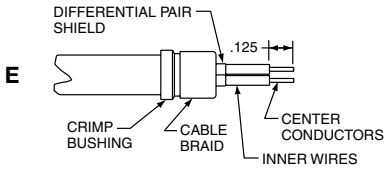
21-033469-031 (PLUG)

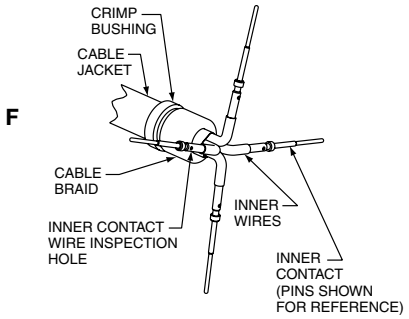








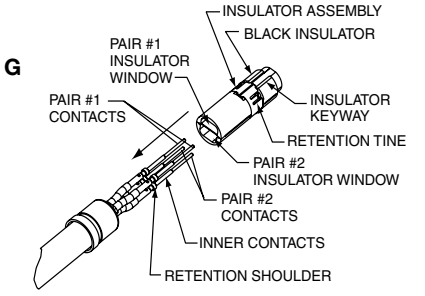


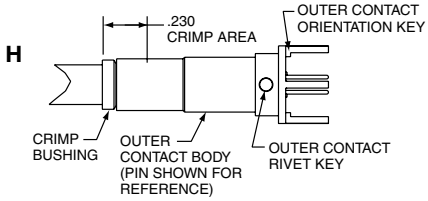


21-033469-031 (PLUG)

G 1. Observe the black insulator's keyway. When the inner pin assembly is held in the vertical position (with inner pin contacts on top), the inner pin contact with the black insulator keyway to its right will be positioned adjacent to and in alignment with the outer contact's orientation key (for inner socket contacts, the black insulator keyway should be positioned to the left of the inner socket desired adjacent to and in alignment with the outer contact's orientation key).
2. With inner contacts in their approximate final locations (pair #1 contacts aligned with pair #1 insulator window, pair #2 contacts aligned with pair #2 insulator window with the inner contacts approimately lined up with contact cavities), assemble front insulator over the inner contacts as shown, being careful to guide the inner contacts through the insulators. The insulator must butt the crimp ferrule, and inner contact retention shoulders must click in front of the retention tines (Inner contacts will lock in place).

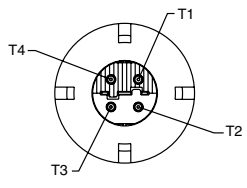
H 1. Align black insulator keyway with the outer contact's rivet key. Slide the inner contact assembly inside the outer contact body until fully seated. Observe the mating end of the assembly to make certain inner contacts #1 & #3 are in vertical alignment with the outer contact's orientation key.
2. Crimp outer contact body in the area indicated using crimp tools listed in table below..





Amphenol Part Number	Description	Quadrax Cable Recommended	Inner Crimp Tools		Outer Crimp Tools	
			Tool (Setting)	Positioner	Tool	Die Set (Location)
21-033469-031	Quadrax Transition Adapter Plug (100 Ohm)	Thermax 1536-224 (100 Ohm)	M22520/2-01 (4)	Daniels K1777	M22520/5-01	M22520/5-45 (A) or Daniels Y1999 (A)

SUGGESTED INNER CONTACT NUMBERING
(PCB TAIL END SHOWN)



Amphenol Suggested Wiring		
Differential Pair	Inner ID	Wire Color
1	T1	Red
	T4	Blue
2	T2	Yellow
	T3	Green

Amphenol
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