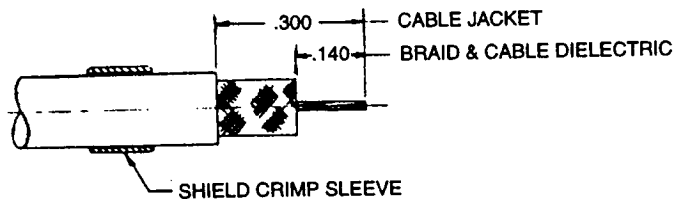


ASSEMBLY INSTRUCTIONS FOR SHIELDED CONTACTS

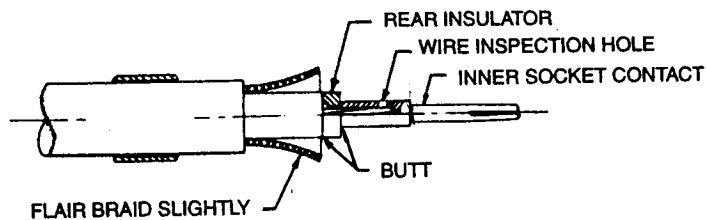
T3-4612-409-LD PIN CONTACT M39029/28-409

FIG. 1A



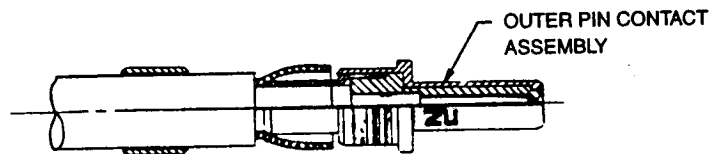
1. STRIP CABLE TO DIMENSIONS SHOWN. MAKE CUTS SQUARE AND SHARP, BEING CAREFUL NOT TO NICK BRAID OR CENTER CONDUCTOR.
2. SLIDE SHIELD CRIMP SLEEVE ONTO CABLE JACKET.

FIG. 2A



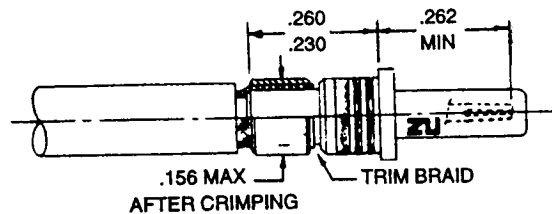
1. SLIDE REAR INSULATOR OVER CENTER CONDUCTOR OF CABLE.
2. SLIDE INNER SOCKET CONTACT OVER CENTER CONDUCTOR. CENTER CONDUCTOR MUST BE VISIBLE THRU THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT CABLE DIELECTRIC.
3. CRIMP INNER SOCKET CONTACT TO CENTER CONDUCTOR USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I. (See Opposite Side)

FIG. 3A



1. SLIDE OUTER PIN CONTACT ASSEMBLY OVER INNER SOCKET CONTACT AND UNDER CABLE BRAID UNTIL INNER SOCKET CONTACT IS FULLY BOTTOMED.

FIG. 4A

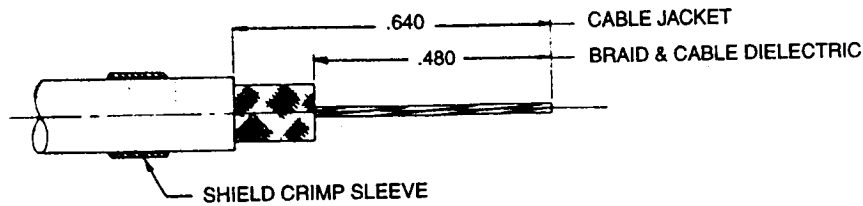


1. SLIDE SHIELD CRIMP SLEEVE OVER CABLE BRAID TO DIMENSION SHOWN.
2. TRIM EXCESS BRAID IN FRONT OF SHIELD CRIMP SLEEVE.
3. WITH ASSEMBLY FULLY BOTTOMED, CRIMP SHIELD CRIMP SLEEVE TO OUTER PIN CONTACT USING TOOL AND POSITIONER AS SHOWN IN TABLE I. (See Opposite Side). CONTACT WILL REQUIRE TWO CRIMPING OPERATIONS. AFTER FIRST CRIMP, ROTATE CONTACT 45° IN POSITIONER AND CRIMP AGAIN. AFTER SECOND CRIMP, THE DIAMETER OF THE SHIELD CRIMP SLEEVE MUST NOT EXCEED .156. INNER SOCKET CONTACT MUST BE LOCATED WITHIN DIMENSION SHOWN.

ASSEMBLY INSTRUCTIONS FOR SHIELDED CONTACTS

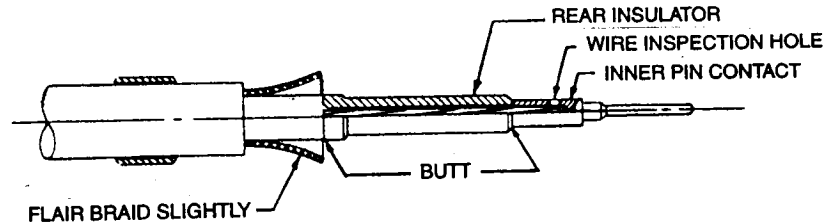
T3-4712-417-LD SOCKET CONTACT M39029/75-417

FIG. 1B



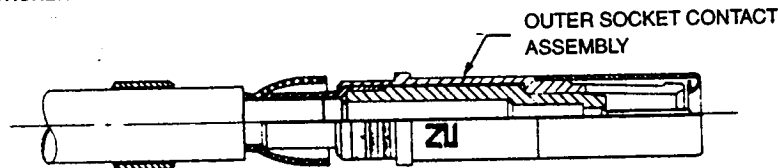
1. STRIP CABLE TO DIMENSIONS SHOWN. MAKE CUTS SQUARE AND SHARP, BEING CAREFUL NOT TO NICK BRAID OR CENTER CONDUCTOR.
2. SLIDE SHIELD CRIMP SLEEVE ONTO CABLE JACKET

FIG. 2B



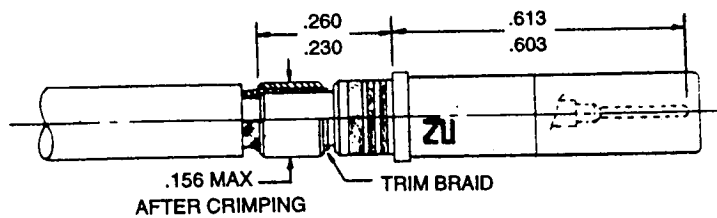
1. SLIDE REAR INSULATOR OVER CENTER CONDUCTOR OF CABLE.
2. SLIDE INNER PIN CONTACT OVER CENTER CONDUCTOR. CENTER CONDUCTOR MUST BE VISIBLE THRU THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT CABLE DIELECTRIC.
3. CRIMP INNER PIN CONTACT TO CENTER CONDUCTOR USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG. 3B



1. SLIDE OUTER SOCKET CONTACT ASSEMBLY OVER INNER PIN CONTACT AND UNDER CABLE BRAID UNTIL INNER PIN CONTACT IS FULLY BOTTOMED.

FIG. 4B



1. SLIDE SHIELD CRIMP SLEEVE OVER CABLE BRAID TO DIMENSION SHOWN.
2. TRIM EXCESS BRAID IN FRONT OF SHIELD CRIMP SLEEVE.
3. WITH ASSEMBLY FULLY BOTTOMED, CRIMP SHIELD CRIMP SLEEVE TO OUTER SOCKET CONTACT USING TOOL AND POSITIONER AS SHOWN IN TABLE I. CONTACT WILL REQUIRE TWO CRIMPING OPERATIONS. AFTER FIRST CRIMP, ROTATE CONTACT 45° IN POSITIONER AND CRIMP AGAIN. AFTER SECOND CRIMP, THE DIAMETER OF THE SHIELD CRIMP SLEEVE MUST NOT EXCEED .156. INNER PIN CONTACT MUST BE LOCATED WITHIN DIMENSION SHOWN.

TABLE I

INNER CONTACT		OUTER CONTACT		INSTALLING TOOL	REMOVAL TOOL
BASIC CRIMPING TOOL	POSITIONER	BASIC CRIMPING TOOL	POSITIONER		
M22520/2-01**	M22520/2-34**	M22520/31-01**	M22520/31-02**	M81969/8-09** OR M81969/14-04**	M81969/8-10** OR M81969/14-04**

TABLE II

COAXIAL CABLE ACCOMMODATED*
M17/095-RG180 RAYCHEM 9528A1318 MICRODOT 293-3922

* Other Cables may be used. Consult factory for recommended assembly instructions.
** Military Part Number