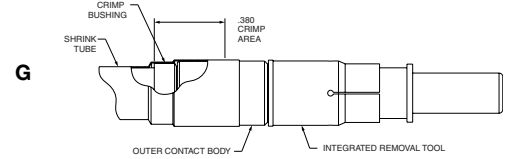
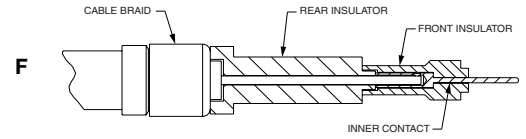
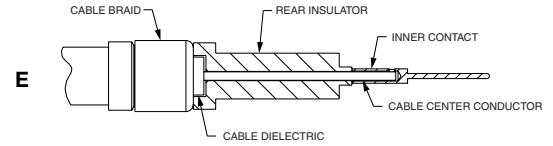
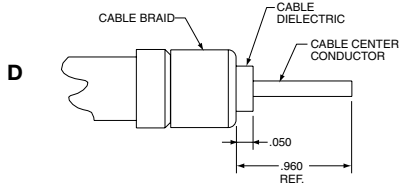
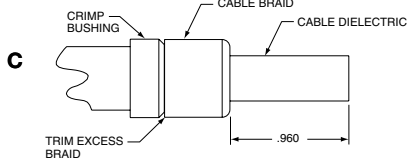
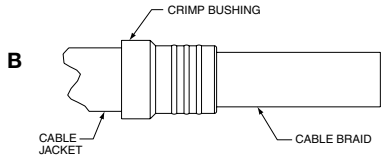
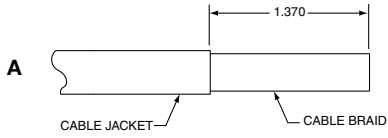


See table on reverse side for coaxial cable recommended, crimping tool and positioner information.

- A** 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. Hot wire stripping is recommended.
- B** 1. Slide crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.
- C** 1. Flair cable braid back over crimp bushing as illustrated to expose cable dielectric. Trim excess cable braid.
2. Cut away any inner braids and/or wraps as close to outer cable braid as possible.
3. Cut cable dielectric to dimension shown.
- D** 1. Strip cable dielectric to expose center conductor as illustrated.
- E** 1. Slide rear insulator, large diameter end first, over cable center conductor and dielectric until it butts the cable braid as shown.
- F** 1. Assemble the inner contact over the center conductor until it butts the rear insulator, as shown (trim the cable center conductor if necessary).
2. Remove the inner contact & tin the cable center conductor using a 47.5 watt soldering iron (inner contact wire well may also be tinned). Solder the center conductor into the inner contact wire well. A pin vice can be used to hold the inner contact.
- G** 1. Slide the front insulator over the inner contact until the inner contact shoulder butts the inside shoulder of the front insulator. A small gap between the front insulator and rear insulator is permissible.
2. Crimp the outer contact body & crimp bushing in the area indicated using crimp tool listed in table on back.
3. Position shrink tube over outer contact body as shown. Tube must not cover integrated removal tool. Shrink tubing in place to provide rear end sealing. For improved sealing, apply adhesive to outside rear surface of outer contact body prior to shrinking tubing.



PART NO.	COAXIAL CABLE ACCOMMODATED	TOOLS	
		SHIELD CRIMP SLEEVE	
		BASIC CRIMPING TOOL	DIE
21-033592-051	Belden 1694A	M22520/5-01	Daniels Y2039

CONTACT INSERTION INTO CONNECTOR

Contacts are inserted by hand. Insert the contact/cable assembly into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact is felt to snap into position within the insert. Gently tug on the cable to assure retention.

CONTACT REMOVAL FROM THE CONNECTOR

Slide the integrated removal tool towards connector until tool comes to a positive stop on the contact. Grip cable and simultaneously remove contact and cable.