

Installation Instructions

- Slide piggyback grommet seal over the cable jacket.
- Slide the outer crimp bushing, flange end first, over the outer cable jacket secure crimp bushing in place with a piece of tape that can be removed later.
- Trim cable and jacket to .485 inches as shown.
- Strip cable outer shield to .200 inches from end of crimp bushing. Carefully form shield back over crimp bushing as evenly as possible. Do not comb out the shield strands.
- Trim the shield strands even to .015 inch max from front of crimp bushing forward flange.
- Slide insulator spacer bushing, flange end first, over the cable interlayer and butt firmly against the shield strands formed over the crimp bushing end.
- Slide the intermediate crimp bushing, flange end first, over the cable interlayer and firmly butt against the insulator spacer bushing.
- Strip cable interlayer ahead of intermediate crimp bushing. Use caution not to cut or nick the inner shield wire strands under the interlayer.
- Trim cable inner shield to .160 inches ahead of the intermediate crimp bushing end and carefully form strands back over crimp bushing as evenly as possible. Do not comb out the shield strands.
- Trim shield strands even to .015 inches from front of intermediate crimp bushing flange.
- Strip cable core .045 inches from shield formed over intermediate crimp bushing end. Do not cut or nick strands of cable center conductor when removing cable core insulation.
- Slide front insulator, large end first, over cable center conductor and cable core until insulator butts firmly against the cable shield that is formed over the intermediate crimp bushing end. Be sure all strands of the cable center conductor appear through the end of the front insulator and that no cable intermediate shield strands have entered the rear opening of the front insulator. (An electrical check at this time may be performed to insure electrical isolation. Also after step 13.)
- Trim fit the inner pin contact to the cable center conductor. The inner pin contact must butt against the end of the front insulator and the cable center conductor must be visible in the inner pin contact wire well inspection hole.
- Crimp inner pin contact to cable center conductor using tool part number M22520/2-01 and Daniels Mfg. Co. tool contact positioner part number M22520/2-37 "K709". The tool indenter selector setting shall be "4".
- Carefully slide the intermediate socket contact with its insulator installed, over the inner pin contact, front insulator and on over the intermediate crimp bushing and shield until the inner pin contact is firmly seated in the insulator recess of the intermediate socket contact assembly. A small gap may appear between the crimp bushing front flange and the intermediate contact end, due to contact and assembly tolerances.
- Crimp intermediate contact and bushing flange simultaneously using tool frame part number M22520/5-01 and die set part number M22520/5-05 closure "B" (.178 hex.) Observe the crimp area shown.
CAUTION: DO NOT PULL ON THIS ASSEMBLY AFTER CRIMPING.
- Slide outer pin contact with insulator already installed, over the crimped intermediate socket contact, spacer insulator bushing and shield formed over rear crimp bushing, until intermediate socket contact is fully seated in the outer contact insulator recess. A small gap may appear between the crimp bushing front flange and the outer pin contact end due to contact and assembly tolerances.
- Crimp the outer pin contact and crimp bushing simultaneously using tool frame part number M22520/5-01 and die set part number M22520/5-45 die closure "A" (.231 hex.) Observe the .150 - .180 crimp length shown. Cable braid not permissible on crimp bushing shoulder during crimping. Remove tape used to hold crimp bushing in position on cable during crimping.

CONTACT INSERTION INTO CONNECTOR

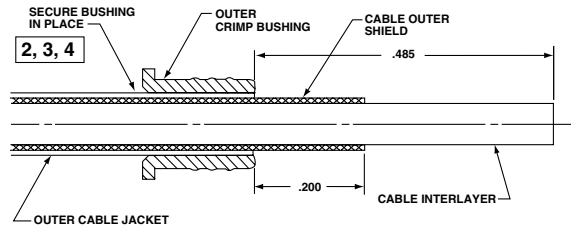
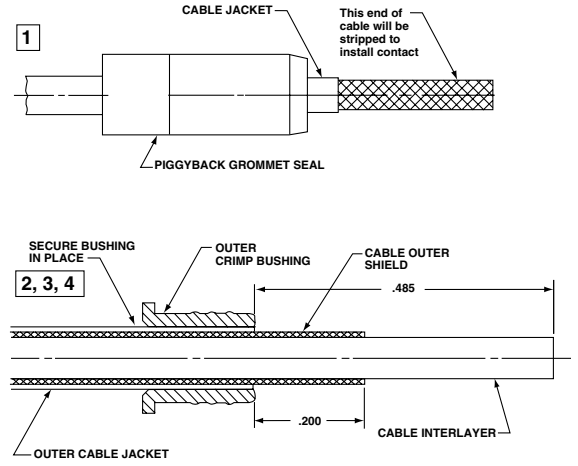
Contacts are inserted by hand. Slide the wire sealing member on the cable and over the crimped sleeve. Insert the contact/cable assembly into proper rear grommet hole. Contact must be aligned with hole and not inserted at an angle. Push forward until contact and wire sealing member is felt to snap into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

CONTACT REMOVAL FROM THE CONNECTOR

Remove wire sealing member from grommet. Position Amphenol removal tool part number 11-9170 or Daniels DRK-264-8 around cable and slide tool toward connector until tips enter rear grommet and come to a positive stop on contact. Grip cable and simultaneously remove tool, contact and cable.

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