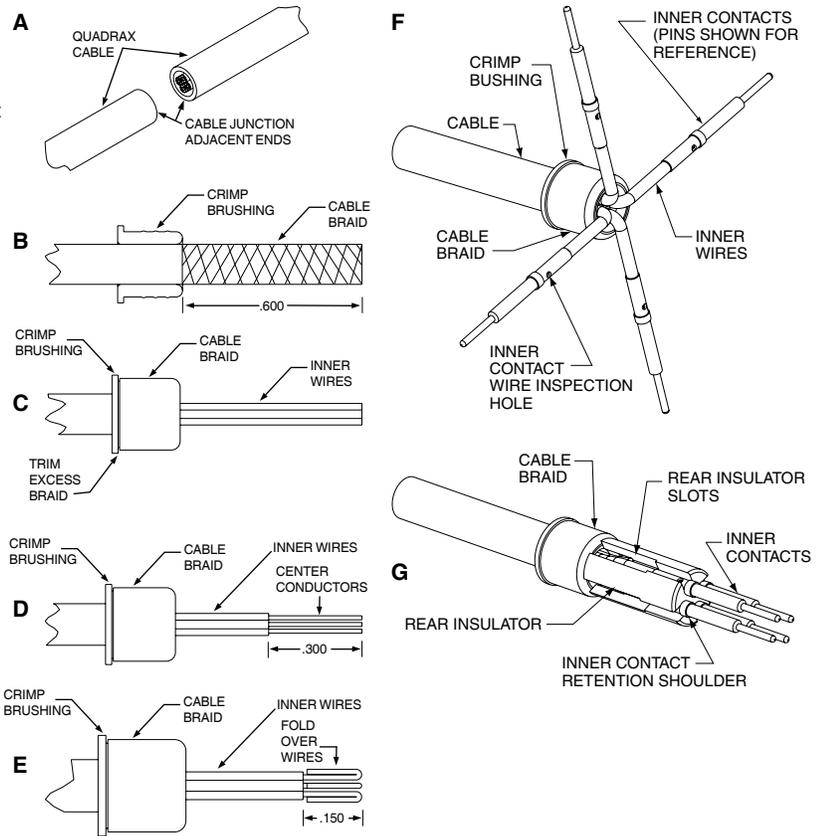


Transition Adapter, Jam Nut Receptacle, Quadrax
Transition Adapter, Jam Nut Receptacle, Quadrax High Speed
Installation Instructions

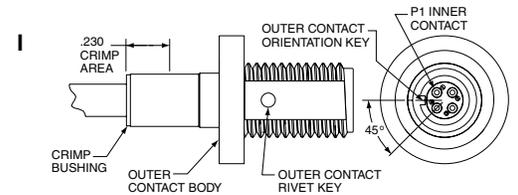
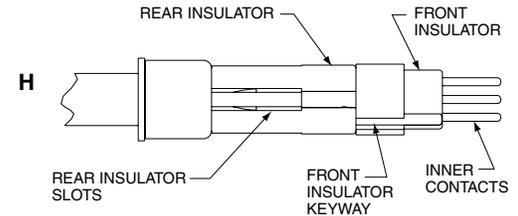
See table for quadrax cable recommended, tool selector settings, crimping tool, positioner and insertion/removal tool information.

- A 1. Cut cable for assembly of quadrax adapters.
 Note: Crossing of inner wires from their natural lie is required and care must be taken to avoid damaging wires.
- B 1. Strip cable jacket to expose outer braid for indicated length. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts.
 2. Slide crimp brushing, flange end first, over the outer cable jacket until front is flush with jacket cut edge. Secure in place with a piece of tape that can be removed later.
- C 1. Flair cable braid back over crimp brushing as illustrated to expose inner wires. Trim excess cable braid.
 2. Cut off any inner braids, wraps or cable fillers as close to outer cable braid as possible.
 3. Cut inner wires to dimension shown. All wires must be cut to equal length. It may be helpful to cut one wire to length. Then, one at a time, cut remaining wires to equal length as the first wire.
- D 1. Strip inner wires to expose center conductors as illustrated. All wires must be stripped to equal length.
- E 1. Fold over stripped wire as shown to buildup crimped wire diameter.
- 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. Repeat steps F2 and F3 until all inner contacts are crimped.
- G 1. Adjust location of inner wires such that the differential pairs are diagonally opposed. (see Suggested Wiring Table)
 2. Position rear insulator against cable braid as illustrated. Make certain insulator slots are aligned with splayed inner contact wires. One-by-one, position wired inner contacts inside the insulator slots as shown. The inner contact's retention shoulder must be positioned in front of the insulator's front surface as illustrated.

Transition Adapter, Jam Nut Receptacle, Quadrax

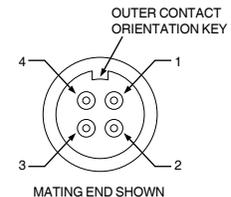


- H 1. With inner contacts positioned inside rear insulator slots, assemble front insulator over the inner contacts as shown. The front insulator must butt the rear insulator, and inner contact retention shoulders must enter front insulator bores.
 2. Observe the front insulator's keyway. When the inner pin assembly is held in the vertical position (with inner pin contacts on top), the inner pin contact with the insulator keyway to its right will be positioned at the P1 inner contact position shown in View I.
- I 1. Align front 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 contacts are aligned as shown (Ref. 45°).
 2. Crimp outer contact body in the area indicated using crimp tools listed in table below. (Remove tape used to hold crimp brushing in position on cable during assembly.)
 3. Assemble packing into the packing groove of the outer contact, then thread hex nut onto the outer contact body (not illustrated).



Differential Pair	Inner ID
1	1
	3
2	2
	4

Amphenol Part Number	Description	Quadrax Cable Recommended	Inner Crimp Tools		Outer Crimp Tools	
			Tool (Setting)	Positioner	Tool	Die Set (Location)
21-033837-081	Transition Adapter, Jam Nut Receptacle, Quadrax	W.L. Gore GSC-10-8273900	M22520/2-01 (4)	Daniels K709 (M22520/2-37)	M22520/5-01	M22520/5-45 (A)



Amphenol