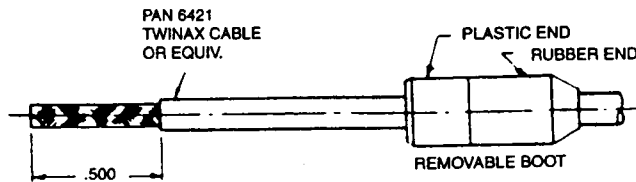


ASSEMBLY INSTRUCTIONS FOR TWINAX CONTACTS

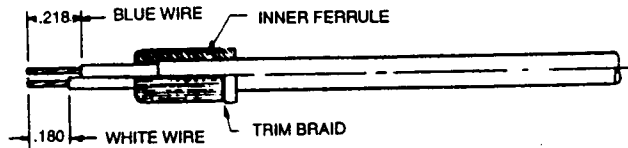
PIN	SOCKET
BA-46TA08-LD	BA-47TA08-LD

FIG.1



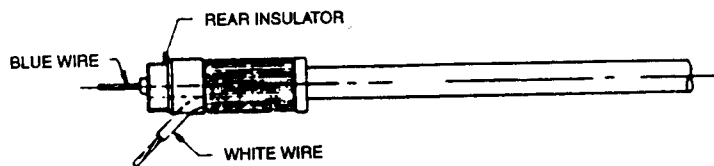
1. SLIDE REMOVABLE BOOT (SUPPLIED WITH CONNECTOR) ONTO CABLE AS SHOWN.
2. STRIP OUTER JACKET TO DIMENSION SHOWN (.500). MAKE CUT SQUARE AND SHARP, BEING CAREFUL NOT TO NICK OUTER BRAID.

FIG.2



1. SLIDE INNER FERRULE OVER OUTER AND INNER BRAIDS UNTIL CABLE JACKET TOUCHES INNER SHOULDER OF FERRULE.
2. COMB OUT OUTER AND INNER BRAIDS AND FOLD BACK BRAIDS UNIFORMLY AROUND INNER FERRULE. TRIM EXCESS BRAID LENGTH IF REQUIRED.
3. CUT OFF TWO FILLERS FLUSH WITH FRONT OF INNER FERRULE, AND STRIP WIRES AS SHOWN (.218 BLUE WIRE & .180 WHITE WIRE). MAKE CUTS SQUARE AND SHARP, BEING CAREFUL NOT TO NICK CONDUCTORS.

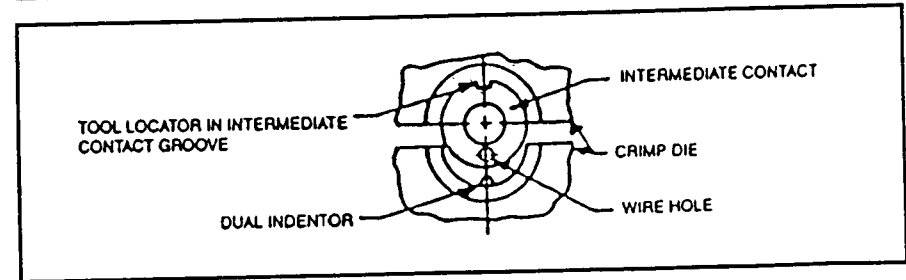
FIG.3



1. BEND WHITE WIRE OUTWARD AND INSTALL BLUE WIRE THRU CENTER HOLE OF REAR INSULATOR.

TABLE I

	CENTER CONTACT TOOLING		INTERMEDIATE CONTACT TOOLING and OUTER BODY CRIMP TOOLING	
	Basic Crimping Tool	Contact Positioner	Basic Crimping Tool	Crimp Die
Military Part No.	M22520/2-01	None	M22520/5-01	None
Daniels Part No.		K709		Y631



(Pyle-National) Form No. PN-1003 8/94

AMPHENOL CORPORATION
Amphenol Aerospace
 607-563-5011
 40-60 Delaware Avenue
 Sidney, New York 13838-1395

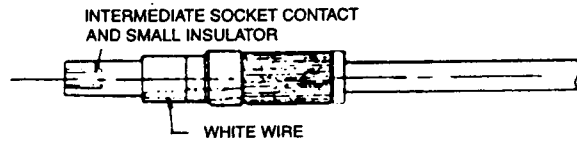
PIN CONTACT

FIG 4A



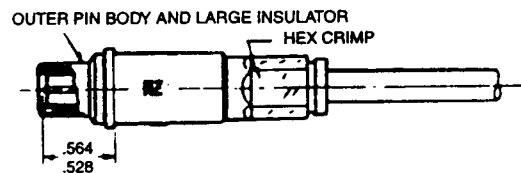
1. SLIDE CENTER PIN CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER PIN CONTACT TO BLUE WIRE USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG 5A



1. SLIDE INTERMEDIATE SOCKET CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER PIN CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

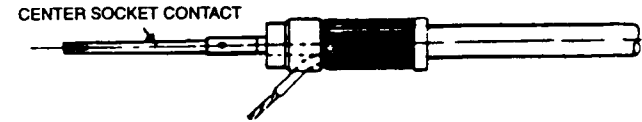
FIG 6A



1. SLIDE OUTER PIN BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE SOCKET CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, CENTER PIN CONTACT MUST BE LOCATED WITHIN DIMENSION SHOWN.
3. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONNECTOR CAVITY UNTIL FIRMLY SEATED.

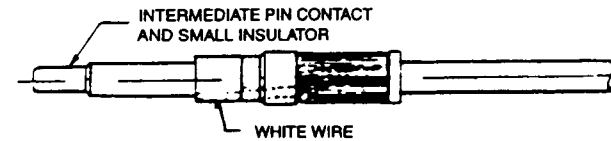
SOCKET CONTACT

FIG 4B



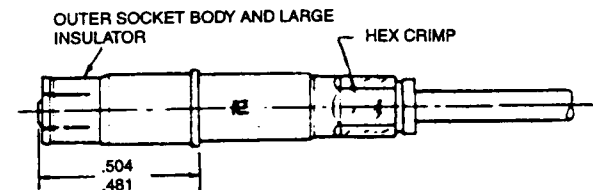
1. SLIDE CENTER SOCKET CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER SOCKET CONTACT TO BLUE WIRE USING CRIMP TOOL AND POSITIONER AS SHOWN IN TABLE I.

FIG 5B



1. SLIDE INTERMEDIATE PIN CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER SOCKET CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

FIG 6B



1. SLIDE OUTER SOCKET BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE PIN CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, INTERMEDIATE PIN CONTACT MUST BE LOCATED WITHIN DIMENSION SHOWN.
3. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONNECTOR CAVITY UNTIL FIRMLY SEATED.