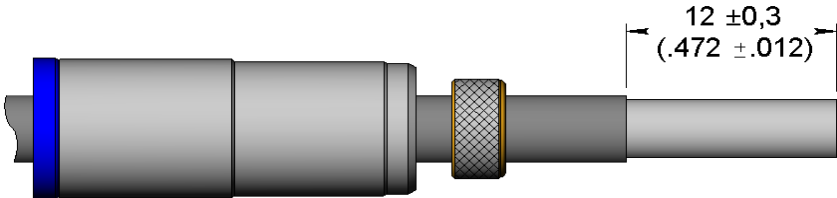
		<b>TECHNICAL DATA SHEET</b>		<b>RP08820</b>	
Series NSX BPX MPX	SIZE 8 CONCENTRIC TRIAX CONTACTS FOR TWINAX CABLES WIRING INSTRUCTIONS:			Issue 22 Sep. 16	Page 1 / 4

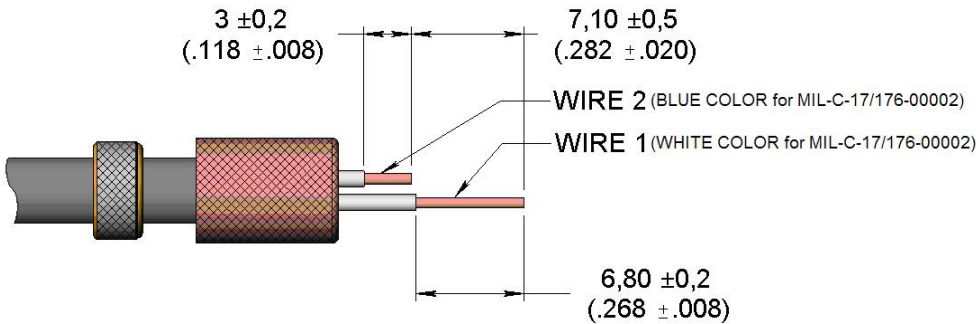
(FOR Raychem 10614 cable please see APPENDIX)

BEFORE STRIPPING, SLIDE ALIGNMENT BOOT OVER CABLE

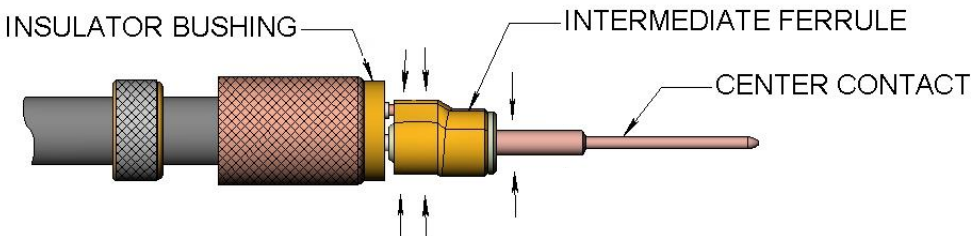
STEP 1/ SLIDE THE INNER FERRULE OVER CABLE  
TRIM CABLE JACKET TO LENGTH INDICATED



STEP 2/ PUSH THE SHIELD BRAID BACK AND OVER THE CABLE JACKET  
CUT ROD FILLER  
STRIP THE TWO INNER WIRES TO LENGTH INDICATED

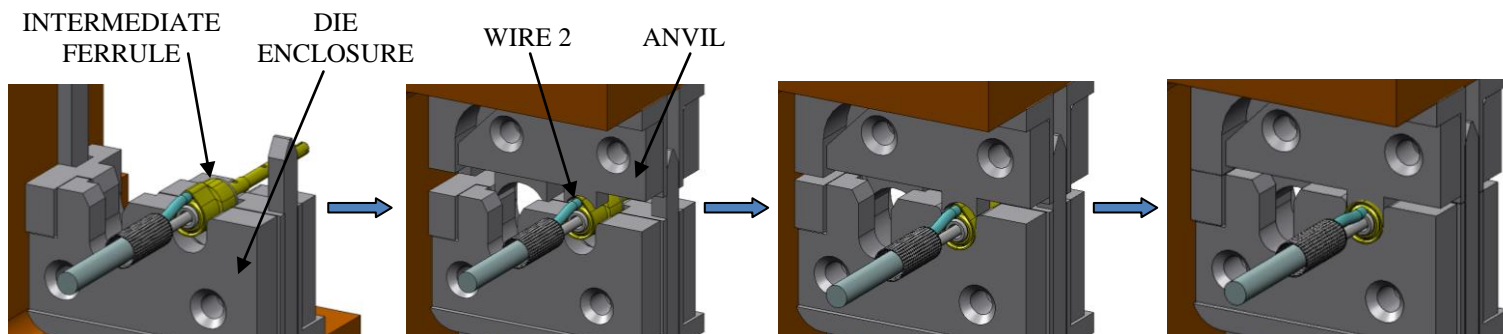


STEP 3/ PUT THE TWO WIRES IN THE INSULATOR BUSHING UNTIL IT BUTTS AGAINST THE SHIELD BRAID  
INTRODUCE THE WIRE 1 INTO THE CENTER CONTACT  
INTRODUCE THE WIRE 2 INTO THE INTERMEDIATE FERRULE  
CRIMP THE CENTER CONTACT AND THE INTERMEDIATE FERRULE USING :  
CRIMPING TOOL : M22520/5-01 (RADIAL P/N 282293)  
DIE : DANIELS Y793



<b>CREATION</b> NAME : MACARI DATE : May 02, 1994 APPR. : CARTESSE	Sep. 22, 2016	Added Radiall P/N 282293 for crimping tool M22520/5-01	Branjonneau	Legendre
	Jan. 20, 2016	Recommended crimping tools updated, and pictures added Outer contact : crimping area length $3 \pm 0,25 \rightarrow 4,06 \pm 0,25$	Branjonneau	Legendre
	Apr 30,2012	Step 3: "it's but" becomes "it butts"	Chevreau	Pessard
	May 05,2009	Added wire color for MIL-C-17/176-00002 cable	Legendre	Brochet
	Jan. 14,2009	Added crimping instructions for Raychem 10614 cable.	Legendre	Brochet
	<b>ISSUE</b>	<b>REVISIONS</b>	<b>NAME</b>	<b>APPROVED</b>

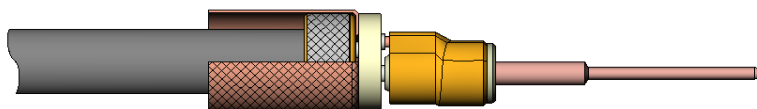
## CRIMPING STEPS :



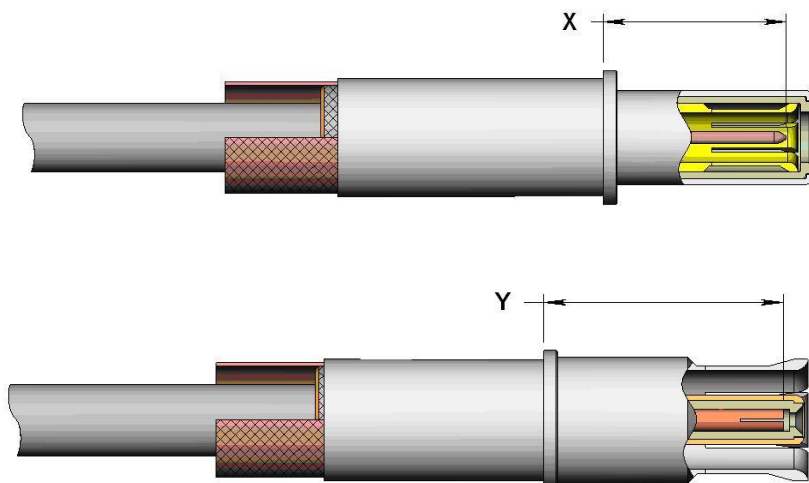
(The contact assembly is simplified for clarity)

BE SURE THE WIRE 2 IS FACING THE ANVIL BEFORE CRIMPING.

STEP 4/ PUSH THE SHIELD TERMINATION FERRULE FORWARD AND UNDER THE BRAID UNTIL IT IS AGAINST THE INSULATOR BUSHING



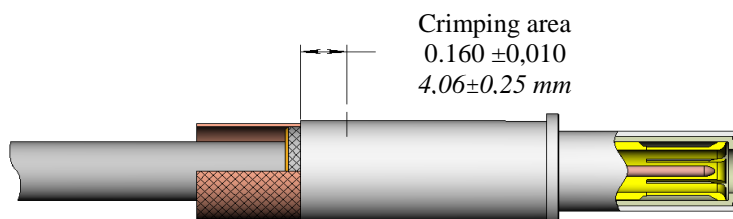
STEP 5/ PUT THE CABLE/CENTER CONTACT ASSEMBLY IN THE REAR OF THE OUTER CONTACT  
INSPECTION DIMENSIONS AFTER ASSEMBLY BEFORE CRIMPING



Ref	X
619 165	14,43(.568)
619 169 001	13,28(.523)
619 169 003	
618 180	12,07 MIN
618 180 001	(.475)

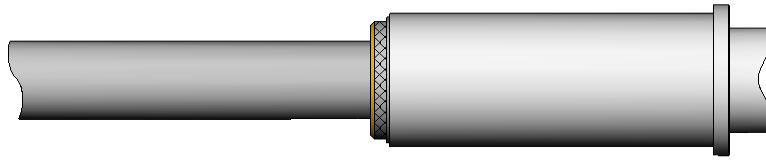
Ref	Y
619 065	13,20 MIN
619 069 001	(.520)
619 037 003	

STEP 6/ CRIMP THE OUTER CONTACT IN THE INDICATED CRIMPING AREA USING  
CRIMPING TOOL : M22520/5-01 (RADIAL P/N 282293)  
DIE : DANIELS Y793



DURING THE CRIMPING OPERATION PUSH ON THE FERRULE

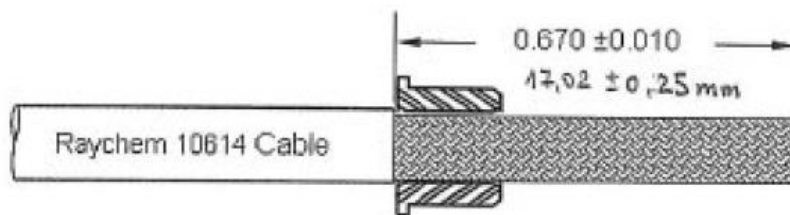
STEP 7/ CUT AROUND THE BRAID SO THAT THE BRAID IS FLUSH WITH THE SURFACE OF THE OUTER CONTACT



## **APPENDIX :**

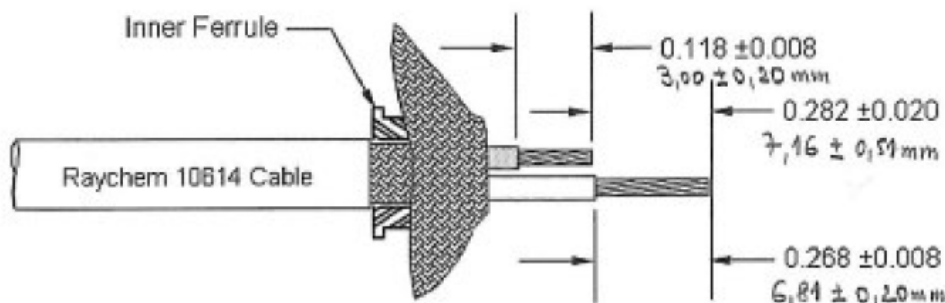
### **Assembly of Radiall P/N 619069001 and 619169001 triaxial contacts :**

**A** – Radiall P/N 619069001, socket contacts, and P/N 619169001, pin contacts, use the same assembly processes and have the same tooling requirements. Prior to stripping the cable, slide the sealing boot over the cable. The contact is designed for use on MIL-C-17/176-20000 differential twinaxial cable. However, when used of Raychem 10614 twinaxial cable the cable jacket will not fit through the inner ferrule so the cable stripping method must be modified. For Raychem 10614 cable, strip the cable jacket first as shown in *figure 1*. Then fold the outer shield back over the jacket and remove the MuMetal layer back to the cable jacket. Then fold the outer shield back over the inner shield and smooth it down as tight as possible over the inner shield (The two shield braids may be combed out to facilitate the installation of the inner ferrule). Slide the inner ferrule, flange or large end first, onto the cable and up against the cable jacket.



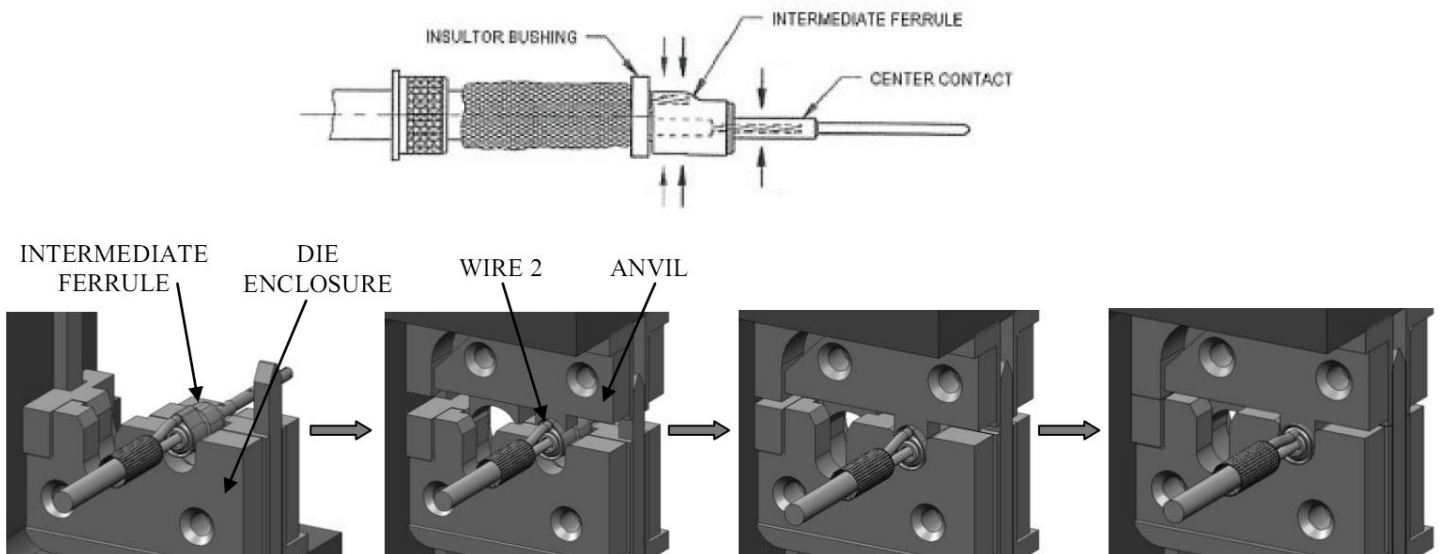
*Figure 1*

**B** – For Raychem 10614 cable, fold the cable shields back and over the inner ferrule. If filler rods are used, trim them back even with the end of the inner ferrule. Cut and strip the two inner wires to the length shown in *figure 2*. From this point forward, the two cable termination methods are the same.

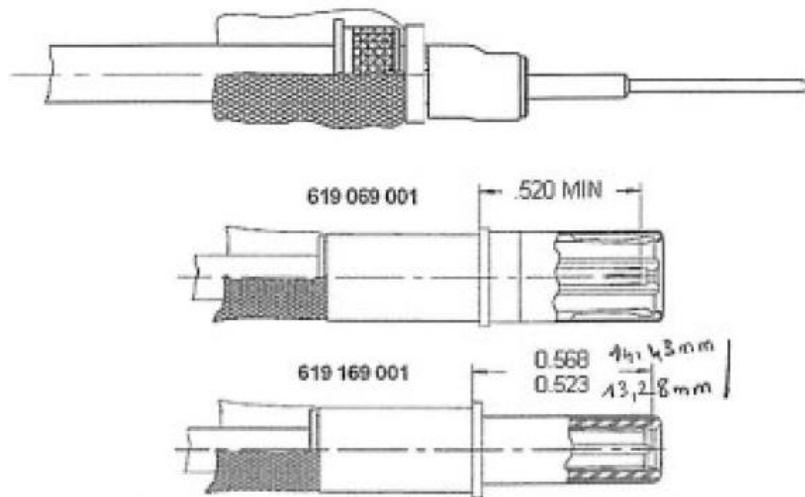


*Figure 2*

**C** – Insert the two conductors into the insulation bushing until the bushing butts up against the shield braid. Insert the center conductor into the center contact and the outer conductor into the intermediate ferrule. Crimp the center contact and intermediate ferrule using an M22520/5-01 (RADIALl P/N 282293) hand crimp tool frame with a die set DANIELS Y793. Ensure the outer conductor is placed in a position facing the die anvil. See *figure 3* (P/N 619169001 pin contact shown for clarity).

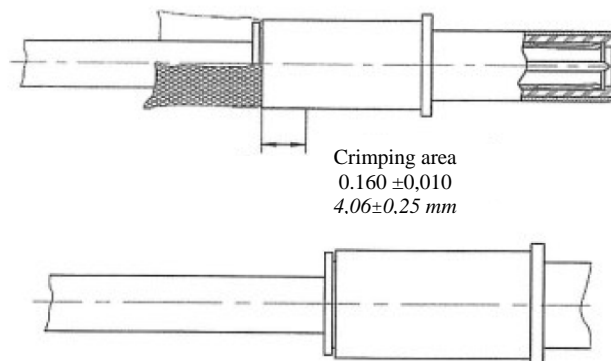


**D** – Push the shield termination ferrule forward and under the braid until it is butted against the insulation bushing. Install the cable/center contact assembly into the rear of the outer contact. The two shield braids may be combed out to facilitate the installation of the outer contact. See *figure 4*. Prior to crimping, inspect to make sure the center contact installs into the outer contact to the dimensions as shown in *figure 4*.



*Figure 4*

**E** – Crimp the outer contact in the indicated area using M22520/5-01 (RADIAL P/N 282293) hand crimp tool frame with a die set DANIELS Y793. During the crimping operation, push on the ferrule to keep it located within the outer contact. After crimping, cut around the shield braid so the braid is flush with the surface of the outer contact. See *figure 5*. Slide the seal boot back down over the back of the contact assembly.



*Figure 5*