
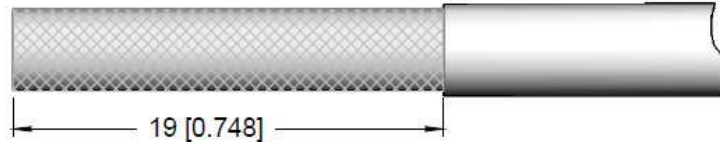


<b>Radiall</b> 		<b>TECHNICAL DATA SHEET</b>	<b>RP 3364</b>	
Series DSX RL MPX EPXB	CONCENTRIC TWINAX CONTACT ASSEMBLY INSTRUCTIONS		Issue Feb. 26, 2014	Page 1 / 4

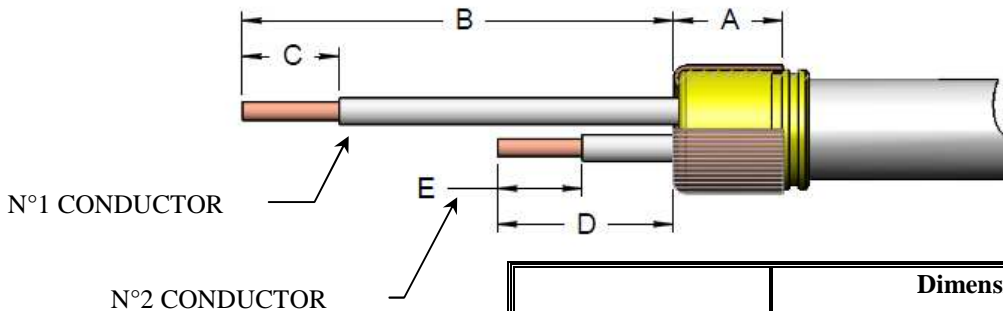
-FOR ENVIRONMENTAL APPLICATION, BEFORE STRIPPING, SLIDE SEALING BOOT OVER CABLE

-FOR NON ENVIRONMENTAL PIN CONTACTS (670150, 670151, 618160 AND 618161), SLIDE CENTERING BOOT OVER CABLE BEFORE STRIPPING

**STEP 1/**  
TRIM CABLE JACKET TO LENGTH INDICATED



- STEP 2/**
- SLIDE THE FERRULE OVER THE CABLE
  - FOR 7724Y3664 CHEMINAX CABLE THE INTERMEDIATE SHIELD SEPARATOR TAPE MUST BE REMOVED BEFORE COMB OUT THE BRAID
  - COMB THE BRAID
  - CUT THE HIGH IMMUNITY RIBBON IF ANY
  - FOLD BACK BRAID OVER THE FERRULE AS INDICATED
  - CUT BRAID AS SHOWN
  - CUT ROD FILLERS
  - STRIP THE TWO INNER CONDUCTORS



Cable Name	Dimensions mm(inch)				
	A	B	C	D	E
EN3375-004C (ASNE0479-WJ) Only with 616095005	4,50 (.177)	16,50 (.650) (.630)	4,80 (.189)	6,50 (.256)	3,80 (.150) (.138)
4,30 (.169) (.157)			6,00 (.236) (.216)		
All other cables			4,00 (.157)	5,50 (.216)	

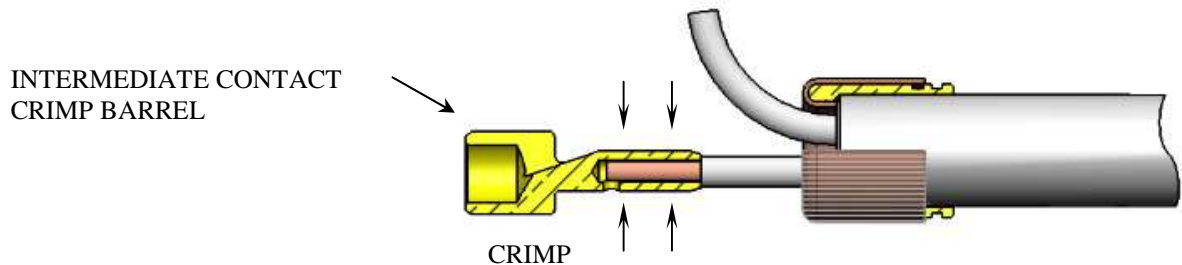
TABLE 1

<b>CREATION</b>	Feb. 26, 14	STEP 5 : added the insulator design "B" STEP 7 : added 618062 - 618062001 - 618162	Branjonneau V.	Dupuis V.
	June 27, 13	Mounting Instruction details broken down : Step 4 detailed & step 7 added	Pailot N.	Pessard M.
<b>NAME : MARIE</b>	June 14, 13	Crimping tool for outer body of quadrax contact for 7724Y3664 cable modified	Pailot N.	Pessard M.
	March 27, 13	Step 2 updated : specific note about 7724Y3664 cheminax cable added	Pailot N.	LeGloahec Y
<b>DATE : 01 12 86</b>	AUG 26, 10	ADDED EN3375-004C(ASNE0479-WJ) CABLE	MONDOT	BROCHET
	30/04/09	SUPPRESS 616 096 004 (see MICT 0300004) B MAX .097 (2,46) => .149 (3,78) ADDED 616 096 003 - 616 096 006 - 616 096 007 - 616 096 008	VALGRESY	BROCHET
<b>APPR. : /</b>	<b>ISSUE</b>	<b>REVISIONS</b>	<b>NAME</b>	<b>APPROVED</b>

**STEP 3/**

INTRODUCE THE N°2 CONDUCTOR IN THE INTERMEDIATE CONTACT CRIMP BARREL  
 CRIMP THE INTERMEDIATE CONTACT CRIMP BARREL WITH TOOLING BELOW :

CRIMPING TOOL M22520/2-01 (RADIALL 282281)  
 SELECTOR POSITION : (SEE TABLE 2)  
 POSITIONER RADIALL : (282574)

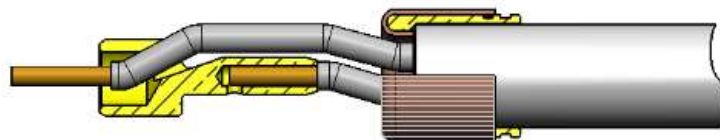


Cable Name	Selector Position
EN3375-004C (ASNE0479-WJ) Only with 616095005	N°7
All other cables	N°5

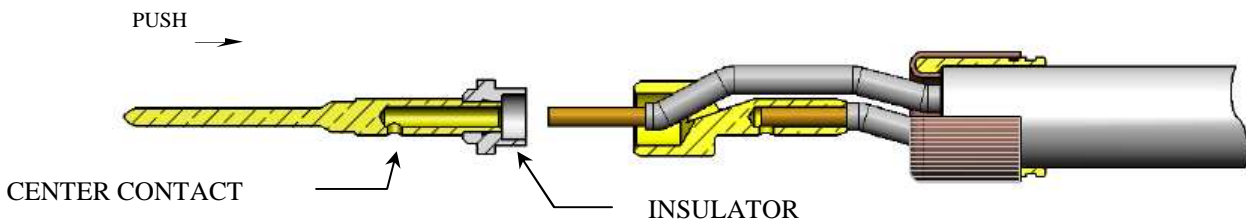
TABLE 2

**STEP 4/**

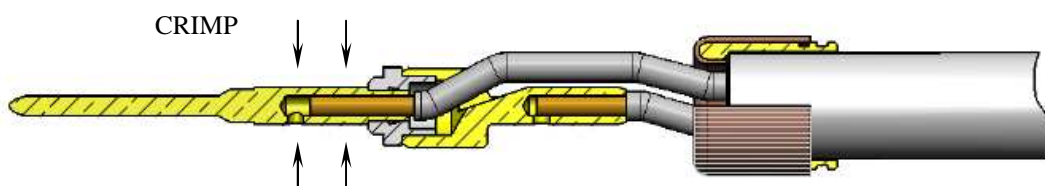
PUT THE N°1 CONDUCTOR INTO THE SLOT OF THE INTERMEDIATE CONTACT CRIMP POT



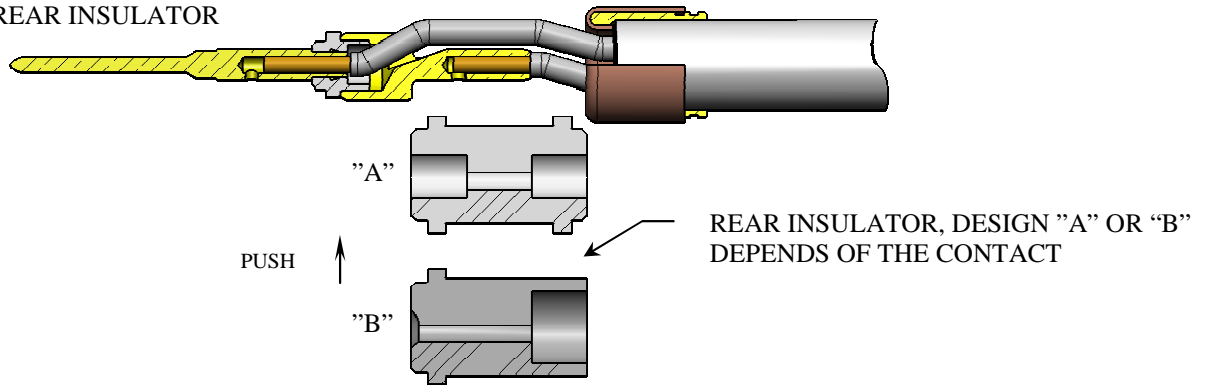
SLIDE THE CENTER CONTACT SUB-ASSEMBLY (center contact + insulator) OVER THE CONDUCTOR



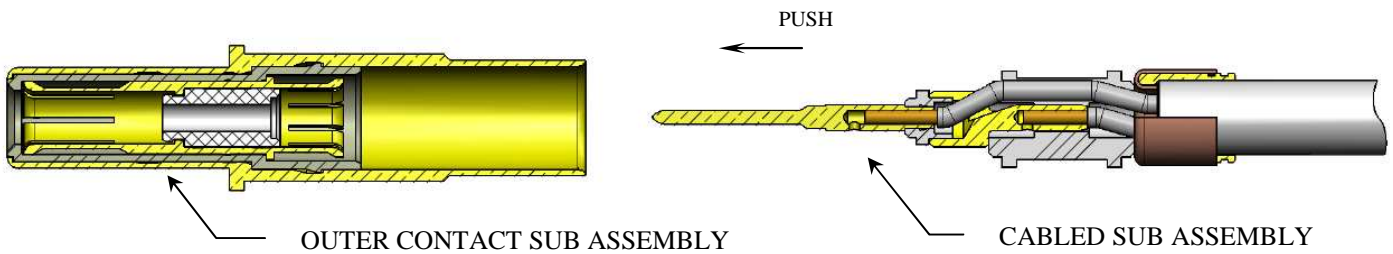
CRIMP THE CENTER CONTACT WITH TOOLING BELOW :  
 CRIMPING TOOL M22520/2-01 (RADIALL 282281)  
 SELECTOR POSITION : (SEE TABLE 2)  
 POSITIONER RADIALL : (282576)



**STEP 5/**  
INSTALL THE REAR INSULATOR

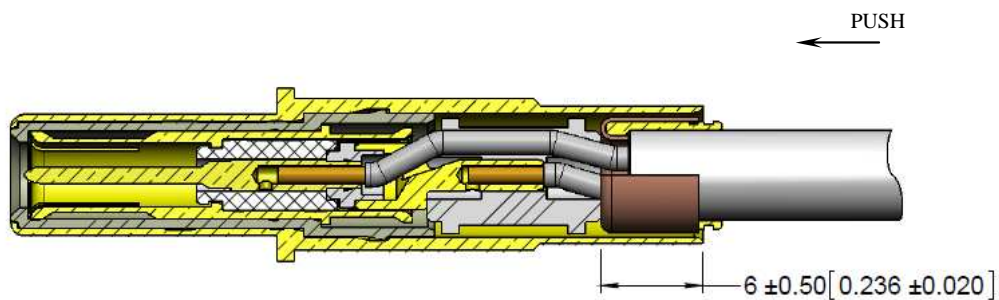


**STEP 6/**  
INTRODUCE THE CABLED SUB ASSEMBLY IN THE OUTER CONTACT SUB ASSEMBLY



CRIMP THE OUTER CONTACT BODY BARREL IN THE INDICATED CRIMPING AREA WITH TOOLING BELOW:  
CRIMPING TOOL M22520/5-01 (RADIALl 282293)

- FOR ALL CABLE EXEPT 7724Y3664  
DIE M22520/5-45 (RADIALl 282236) HEXAGONAL DIE CLOSURE "B" (5.54 [.218] ON FLATS)
- FOR 7724Y3664 CABLE  
DIE M22520/5-05 (RADIALl 282246) HEXAGONAL DIE CLOSURE "A" (5.41 [.213] ON FLATS)

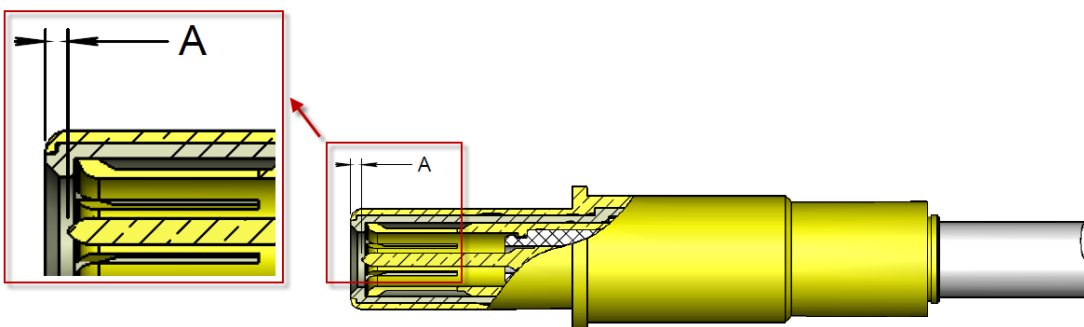


DURING THE CRIMPING OPERATION PUSH ON THE CABLE TO ENSURE THE DIMENSION "A" & "B" (specified in step 7)

**STEP 7/**  
INSPECTION DIMENSIONS AFTER ASSEMBLY

PART NUMBER		DIMENSIONS	
CONNECTOR	CONTACT	A MAX Inch (mm)	B MAX Inch (mm)
MIL-C-38999 SERIES 1,3 AND 4 RL	670050	.0208(0,53)	.009 (0,23)
	670051		
	670150		
	670151		
MIL-C-83527A PrEN3682 MPX	618060	.039 (1)	.0315(0,8)
	618061		
	618062 - 618062001		
	618160 - 618160002		
	618161		
MIL-C-81659B DSX	616095001	.149 (3,78)	.152 (3,86)
	616095005		
	616095009		
	616095028		
	616095030	.078 (1,97)	
	616096003		
	616096006		
	616096007		
	616096008		
	616195001	.033 (0,84)	
	616195009		
	616195030		
	616196003		
EPXB	617 065 024	.039 (1)	.0315(0,8)
	617 165 024		

A: DISTANCE BETWEEN THE END OF OUTER PIN CONTACT AND THE END OF THE CENTER PIN CONTACT



B: DISTANCE BETWEEN THE END OF OUTER SOCKET CONTACT AND THE END OF INTERMEDIATE PIN CONTACT

