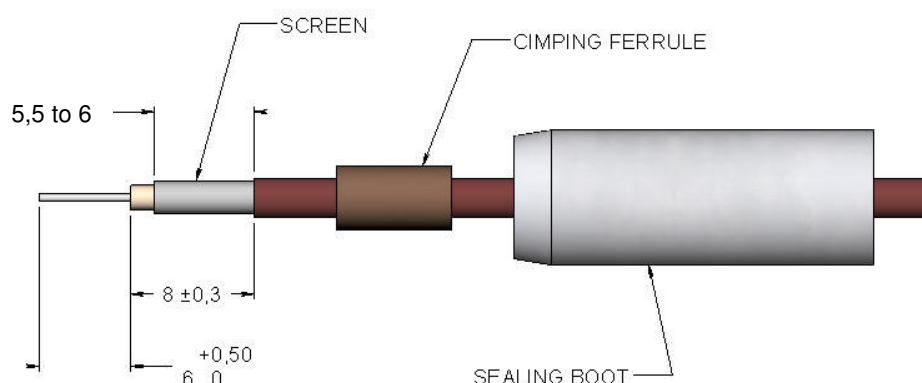


STEP 1 - STRIPPING

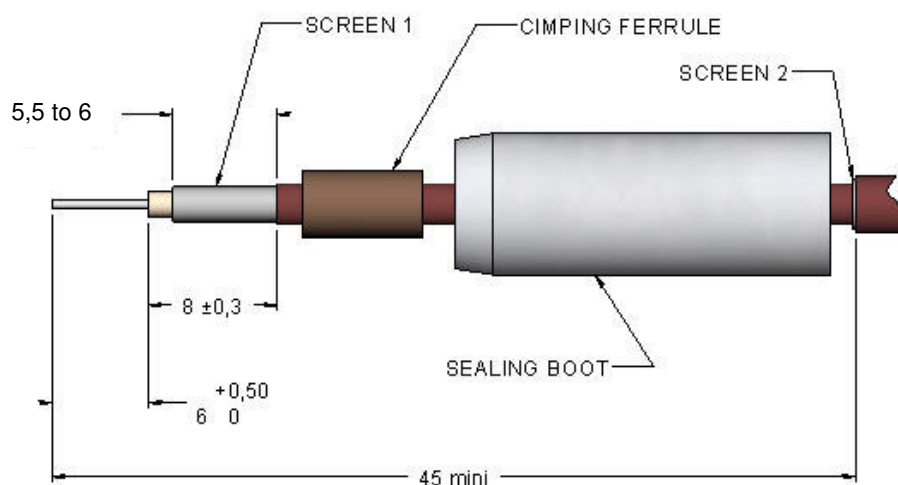
N61.112 DXY Cable:

- ✓ SLIDE THE SEALING BOOT OVER THE CABLE.
- ✓ STRIP CABLE TO DIMENSIONS SHOWN ABOVE. (Do not cut the screen during the outer jacket stripping operation)
- ✓ SLIDE THE CRIMPING FERRULE OVER THE CABLE.



N61.515 DTF Cable:

- ✓ STRIP OUTER JACKET and SCREEN 2.
- ✓ SLIDE THE SEALING BOOT OVER THE CABLE.
- ✓ STRIP CABLE TO DIMENSIONS SHOWN ABOVE (Do not cut the screen during the outer jacket stripping operation).
- ✓ SLIDE THE CRIMPING FERRULE OVER THE CABLE.

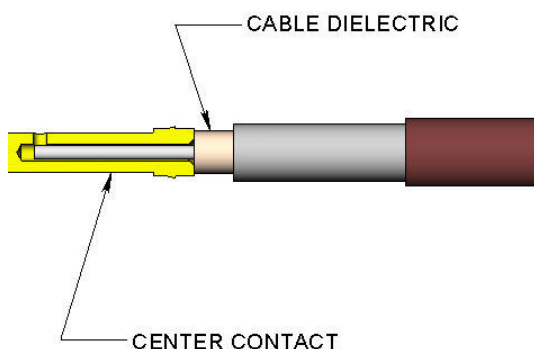


CREATION NAME : H. Perrin DATE : June 18, 2008 APPR. : L. Garcia	Nov. 05,2008	Daniels positioner P/N added (Central contact crimping)	Perrin H.	Garcia L.
	Sept. 30, 2008	Crimping tool in step 4 was F780057000 Hex. 3.40 mm	Perrin H.	Garcia L.
	Aug. 05, 2008	Length of screen 1 was 6 to 6,5 in step 1 – Selector was 4 in table step 2.	Perrin H.	Garcia L.
		Adding comments regarding the screen 1 stripping.		
	ISSUE	REVISIONS	NAME	APPROVED

STEP 2 – CENTRAL CONTACT ASSEMBLING

- ✓ SLIDE THE CENTER CONTACT BARREL OVER THE CABLE.
- ✓ CONTACT SHOULDER BUTTING AGAINST CABLE DIELECTRIC.
- ✓ CRIMP CENTER CONTACT USING :

CABLE	CRIMPING TOOL / SELECTOR	POSITIONER / TURRET
N61.112 DXY N61.515 DTF	M22520/2-01 RADIAL (282281) Selector 5	RADIAL 282 587 Daniels K1025S



STEP 3 – OUTER SUB-ASSEMBLY MOUNTING

- ✓ FLARE BRAID, INSERT CENTER CONTACT INTO THE OUTER CONTACT BODY and PUSH UNTIL IT SNAPS INTO THE INSULATOR.
- ✓ PLACE BRAID OVER KNURLED PART OF OUTER CONTACT SUB-ASSEMBLY.
- ✓ COMB THE BRAID

STEP 4 – SCREEN CRIMPING

- ✓ SLIDE FERRULE OVER BRAID UNTIL IT BUTTS AGAINST SHOULDER OF OUTER CONTACT SUB-ASSEMBLY.
- ✓ CRIMP FERRULE
Crimping tool M22520/5 – Die set: hex. 3,50 mm [.138 inches]

