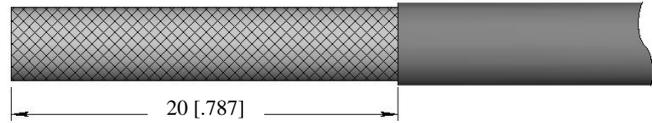
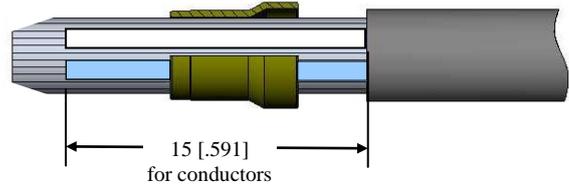


Series EPXB	CONCENTRIC #12 TWINAX CONTACT : 617190012 and 617090012 ASSEMBLY INSTRUCTIONS FOR MIL-C-17/176-00002 CABLES	Issue Oct 02, 2014	Page 1 / 2
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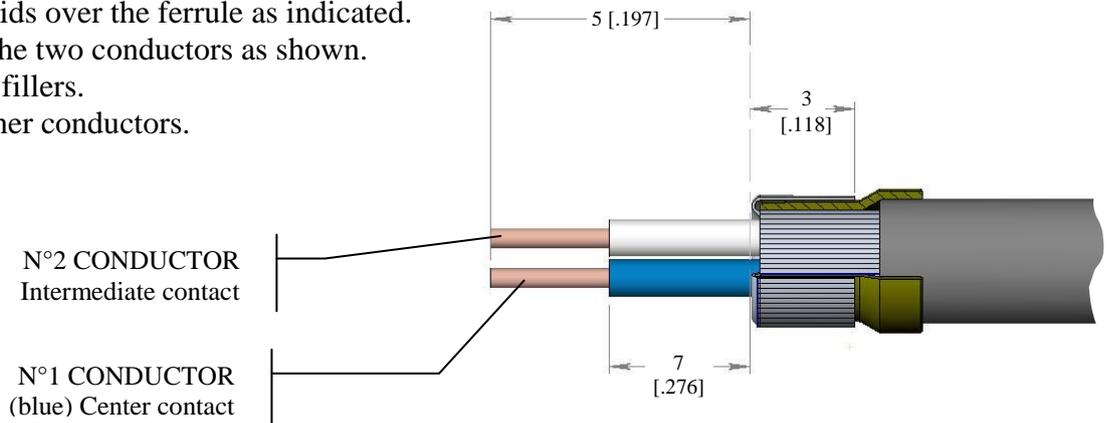
1- a. Strip cable as illustrated.



b. Comb braids and fold back them over the cable then cut the two inner conductors as shown on the right.
Comb and twist braids as shown and slide the ferrule over the cable.



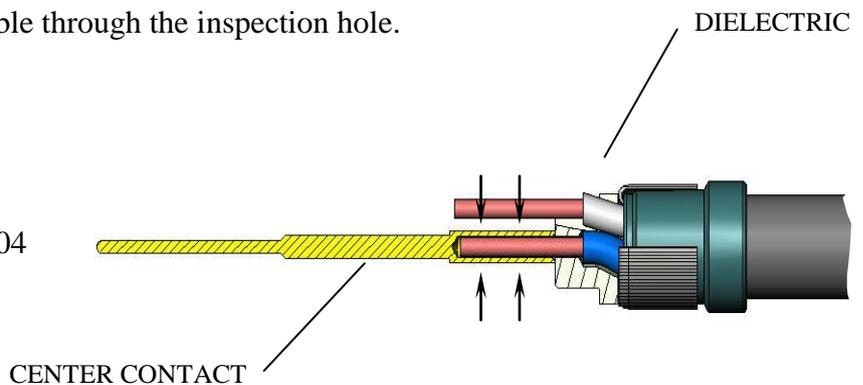
2- a. Fold back braids over the ferrule as indicated. Cut braids and the two conductors as shown. Cut the two rod fillers. Strip the two inner conductors.



3- a. Pass the first conductor through the dielectric. The second conductor coming in the slot.

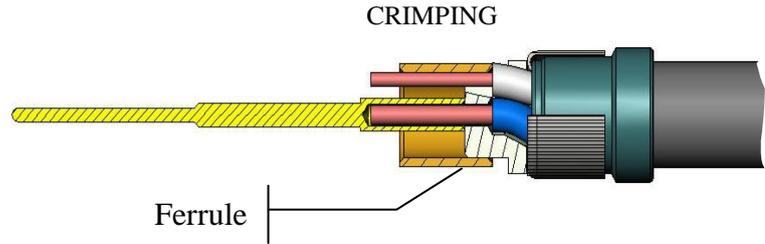
b. Insert the first conductor into the center contact until the dielectric abut against the braids. The first conductor has to be visible through the inspection hole.

c. Crimp the center contact:
 . Crimping tool M22520/2.01 (RADIALL 282 281) Selector 3
 . Positioner RADIALL 282 581 004



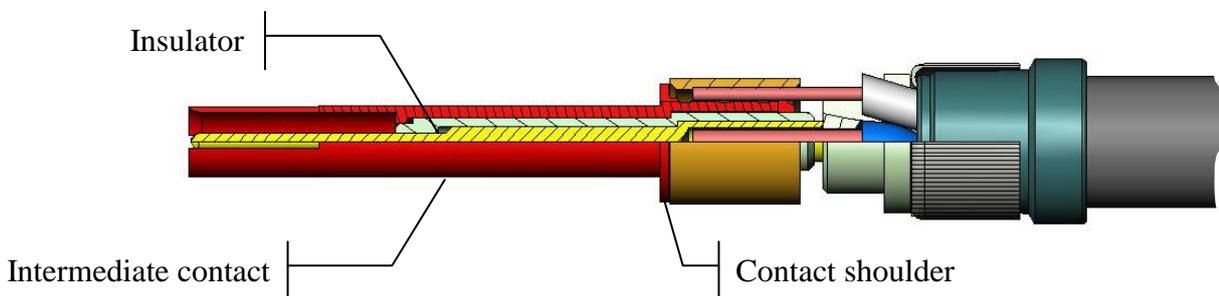
CREATION NAME : M.PESSARD DATE : 10/01/2004 APPR. L.GARCIA	Oct 02, 14	Mistake on quotation corrected	YON P.	VIEIRA D.
	June 21, 11	Mistake on quotation	J. RIBIERE	
	Jan 26, 05	MICT0200000 was RP57802. Step 1.a and 7 deleted.	M.PESSARD	L.GARCIA
	ISSUE	REVISIONS	NAME	APPROVED

4- Slide the ferrule over the dielectric to pass the second conductor between the ferrule and the dielectric as illustrated on the right.



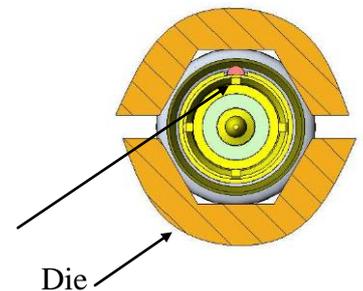
5- a. Slide the intermediate insulator over the crimped center contact. Then, introduce this sub-assembly into the intermediate contact.

b. Put the 2nd conductor in the barrel slot of the intermediate contact. Slide back the ferrule over the intermediate contact barrel as indicated in the drawing below. The second conductor must not stick out from the contact shoulder.

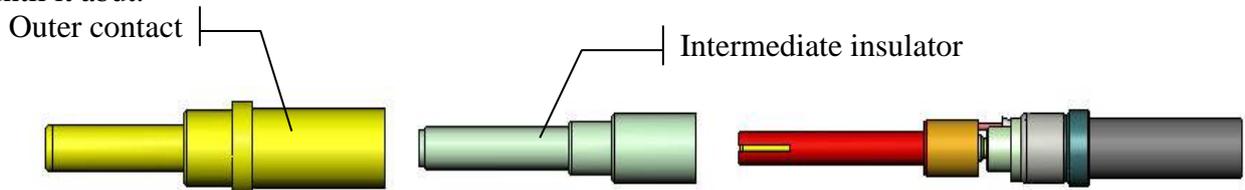


c. Crimp the ferrule: .Crimping tool M22520/5.01 (RADIALL 282 293)
 . Die M22520/5.03 (RADIALL 282 235 003).
 Hex B (2.67mm (.105in) on flats)

Be sure the 2nd conductor is in front of an hexagonal flat before crimping.



6- a. Introduce the intermediate contact into the intermediate insulator, then into the contact outer body until it abut.



b. Crimp the outer contact: . Crimping tool M22520/31.01 (RADIALL 282 297)
 . Positioner RADIALL 282 581 005

Press lightly the outer contact between dies in the indicated crimping area below.
 In the same time, push the cable on and on the ferrule to put all the components in right position.
 Then close completely the dies.

