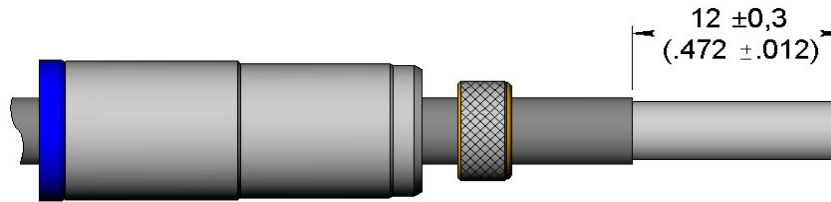
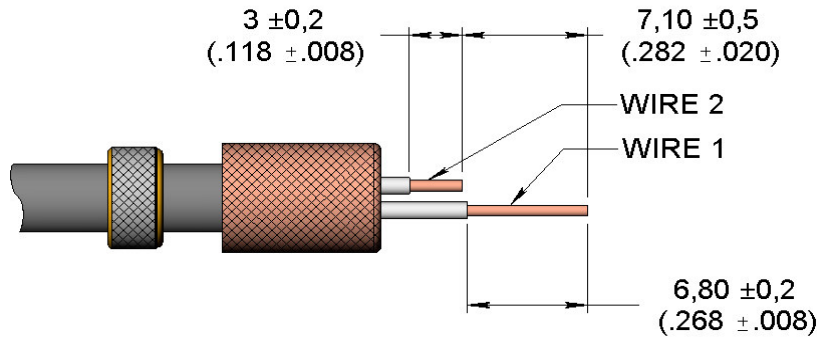
	<b>RADIALL</b> ®	<b>TECHNICAL DATA SHEET</b>	<b>MI CT 0200002</b>	
Series EPXB	SIZE 8 CONCENTRIC TWINAX CONTACTS WIRING INSTRUCTIONS: 617065 AND 617165 FOR WHITMOR W-2675-1575 CABLE 617065021 AND 617165021 FOR TENSOLITE 24463/9P025X-2(LD) (S280W502-001)		Issue March 25, 2005	Page 1 / 2

BEFORE STRIPPING, SLIDE ALIGNMENT BOOT OVER CABLE

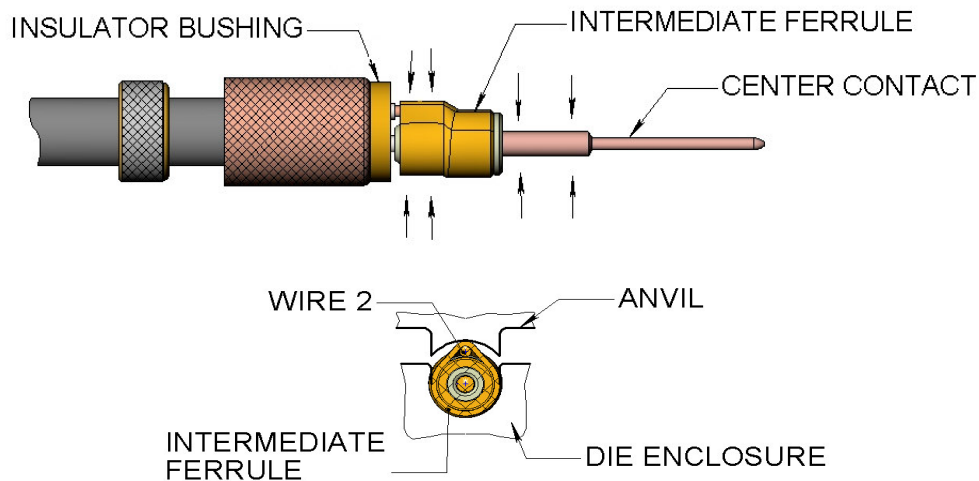
STEP 1/ SLIDE THE INNER FERRULE OVER CABLE  
TRIM CABLE JACKET TO LENGTH INDICATED



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'S BUT 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  
DIE : M22520/5-104 (DANIELS Y692)  
OR DANIELS Y793 OR Y793A  
(USE DIE DANIELS Y692 OR Y793 IN PREFERENCE TO Y793A)

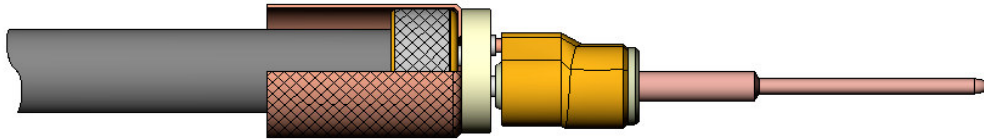


<b>CREATION</b> NAME : ARNAULT F DATE : Jan. 28, 2005 APPR. : L.Garcia				
	Mar.25,2005	617065021 and 617165021 added.	L.Garcia	M.Pessard
	Mar. 4, 2005	Crimping die for outer contact was M22520/5-13.	L.Garcia	F.Arnault
	<b>ISSUE</b>	<b>REVISIONS</b>	<b>NAME</b>	<b>APPROVED</b>

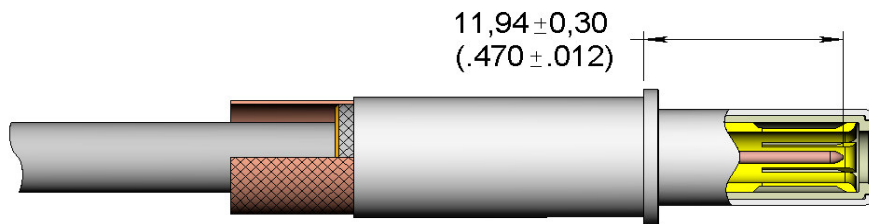
MICT0200002

BE SURE THE WIRE 2 IS FACING THE ANVIL

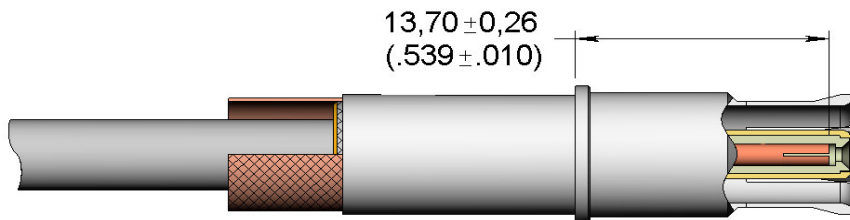
STEP 4/ PUSH THE SHIELD TERMINATION FERRULE FORWARD AND UNDER THE BRAID UNTIL IT IS AGAINST THE INSULATOR BUSHING



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

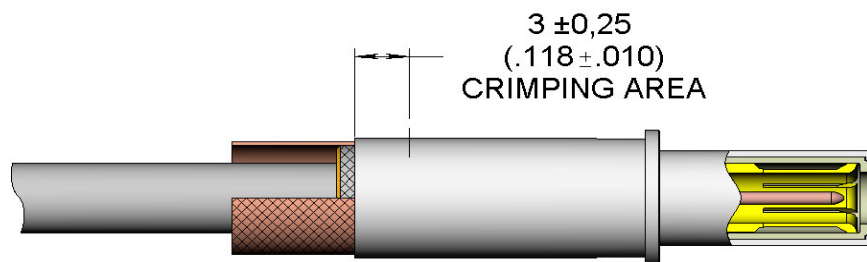


617 165 and 617165021



617 065 and 617065021

STEP 6/ CRIMP THE OUTER CONTACT IN THE INDICATED CRIMPING AREA USING  
CRIMPING TOOL : M22520/5-01  
DIE : M22520/5-104 (DANIELS Y692)  
OR DANIELS Y793 OR Y793A



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

