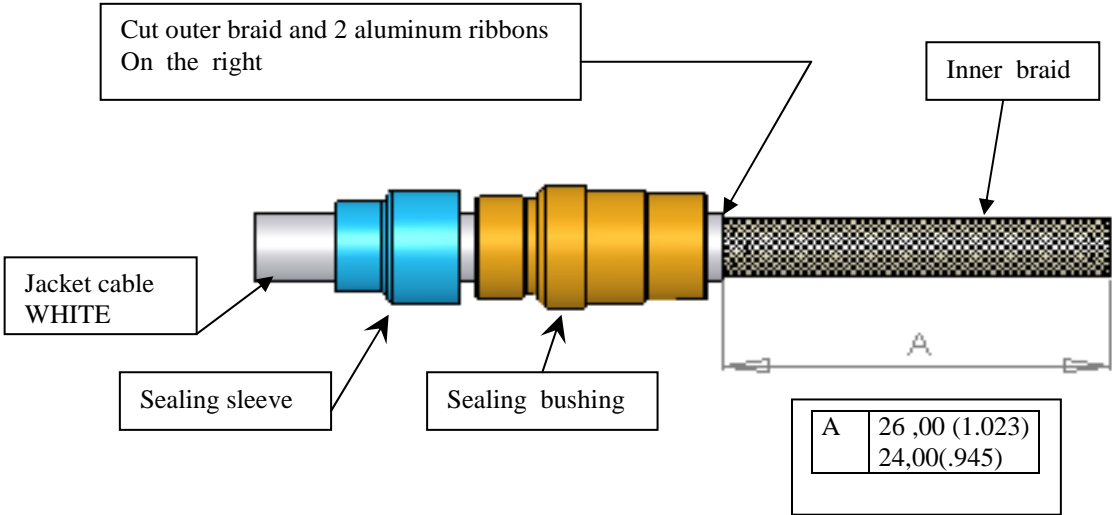


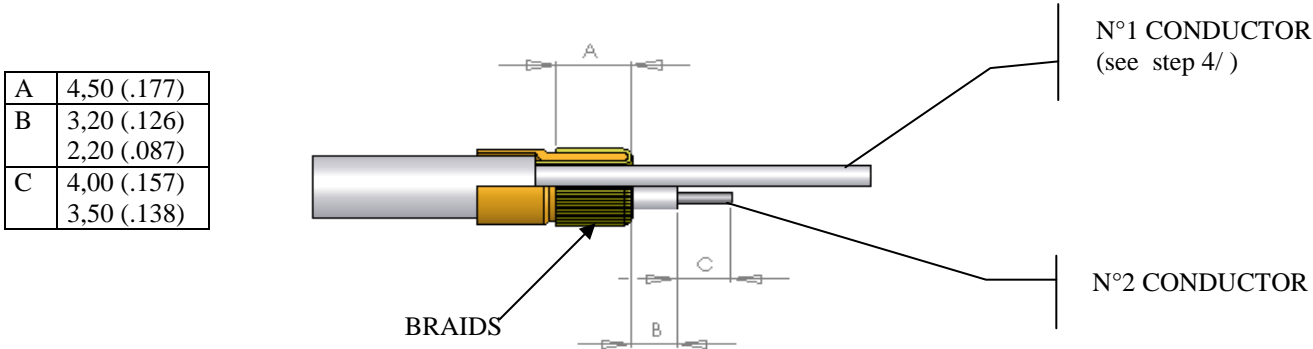
		TECHNICAL DATA SHEET	MICT0300003	
Series DSX	CONCENTRIC TWINAX CONTACT 616096017 ASSEMBLY INSTRUCTIONS FOR F2709/9 CABLE		Issue 14 APRI 2005	Page 1/4

FOR ENVIRONMENTAL APPLICATION, BEFORE STRIPPING, SLIDE SEALING SLEEVE AND SEALING BUSHING OVER CABLE

STEP 1/
TRIM CABLE JACKET TO LENGTH INDICATED



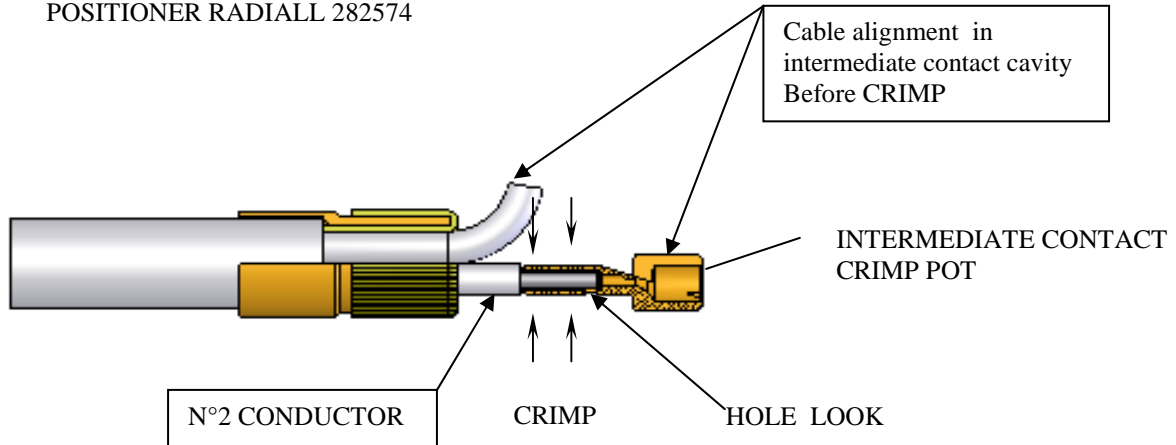
STEP 2/
SLIDE THE FERRULE OVER THE CABLE. CUT THE HIGH IMMUNITY RIBBON IF ANY
FOLD BACK BRAID OR BRAIDS OVER THE FERRULE AS INDICATED
CUT BRAID OR BRAIDS AS SHOWN
CUT ROD FILLERS
STRIP THE N°2 CONDUCTOR (WARNING : COLOR POLARIZATION PER INDICATE)



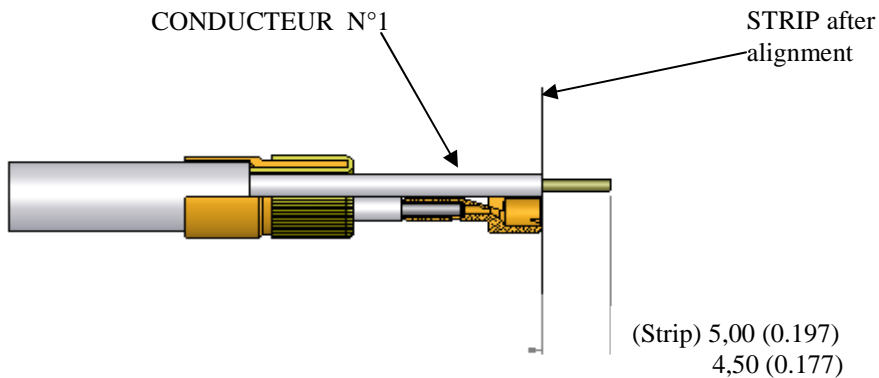
CREATION				
NAME : B.GOMBERT	14/04/05	Selector position 6 was 7 ;CHANGE DRAWING	B Gombert	C.Lahoreau
DATE : 29/09/04	05JAN05	Was RP57839 ; revision per wish Customer	B.Gombert	C.Lahoreau
APPR. : L.LAHOREAU	ISSUE	REVISIONS	NAME	APPROVED

STEP3/

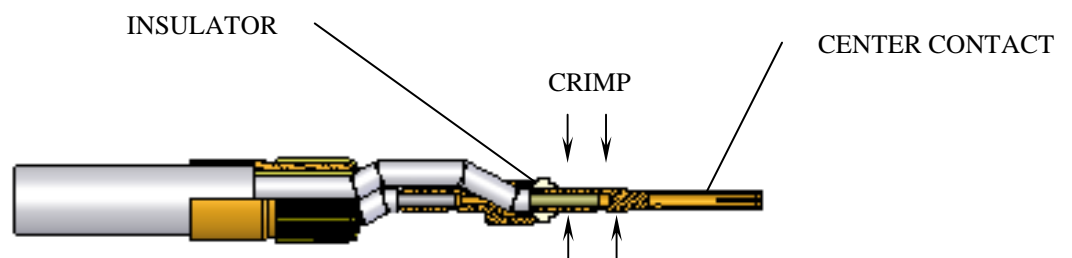
INTRODUCE THE N°2 CONDUCTOR INTO THE INTERMEDIATE CONTACT CRIMP POT
CRIMP THE INTERMEDIATE CONTACT CRIMP POT
CRIMPING TOOL M22520/2-01 (RADIAL 282281)
SELECTOR POSITION 6
POSITIONER RADIAL 282574

**STEP 4/**

STRIP THE N°1 CONDUCTOR

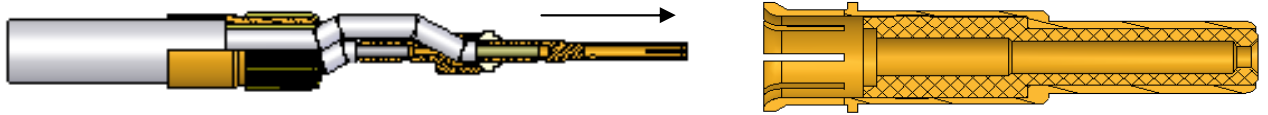
**STEP 5/**

PUT THE N°1 CONDUCTOR IN THE SLOT OF THE INTERMEDIATE CONTACT CRIMP POT
SLIDE THE CENTER CONTACT OVER THE CONDUCTOR
CRIMP THE CENTER CONTACT
CRIMPING TOOL M22520/2-01 (RADIAL 282281)
SELECTOR POSITION 6
POSITIONER RADIAL 282576



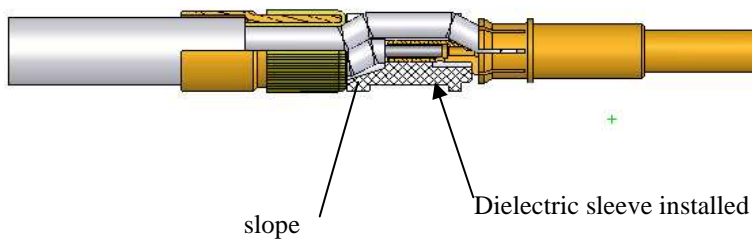
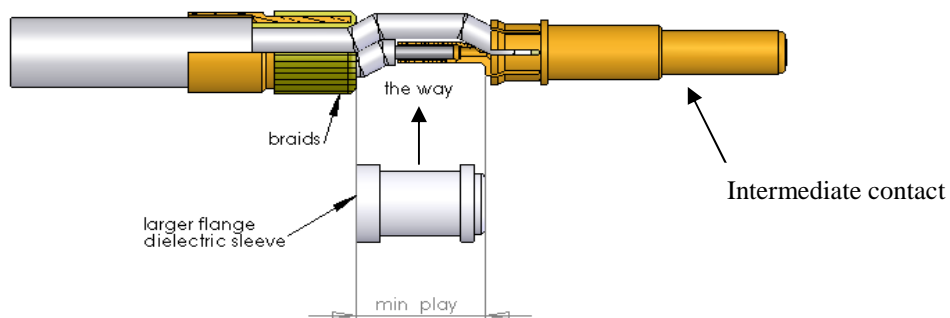
STEP 6/

INTRODUCE THIS CABLE ASSEMBLY INTO THE INTERMEDIATE CONTACT SUB-ASSEMBLY



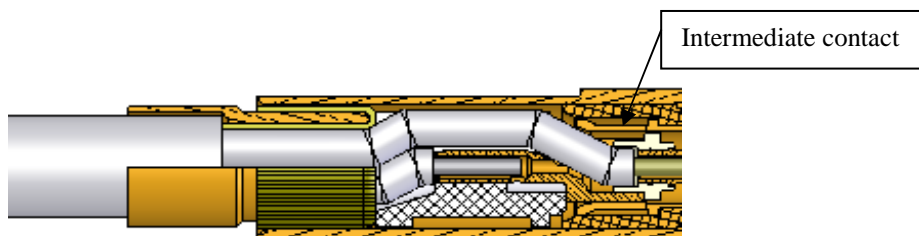
STEP 7/

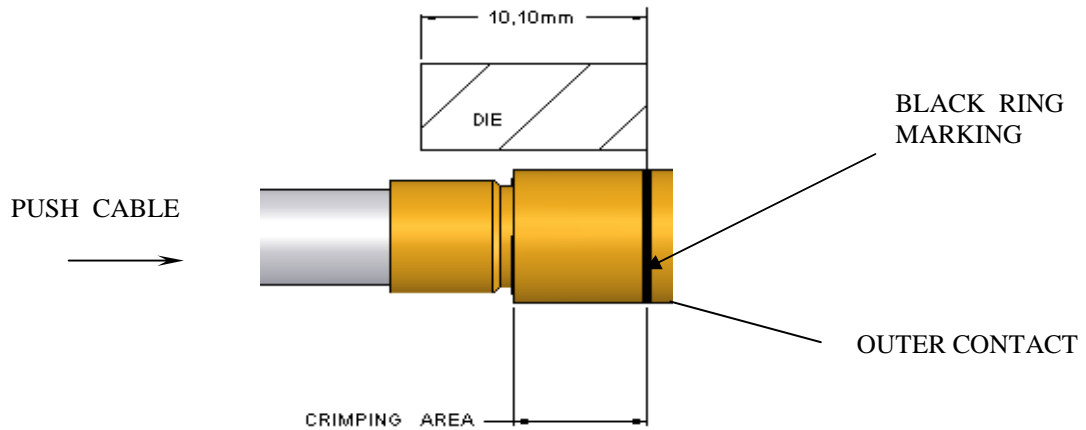
INSTALL THE DIELECTRIC SLEEVE



STEP 8/

INTRODUCE THIS CABLE ASSEMBLY INTO THE CONTACT BODY SUB-ASSEMBLY



STEP 9/**CRIMP THE OUTER CONTACT BODY BARREL IN THE INDICATED CRIMPING AREA****CRIMPING TOOL M22520/5-01 (RADIAL 282293)****DIE M22520/5-45 (RADIAL 282236) HEXAGONAL DIE CLOSURE B (.218 ON FLATS)****DURING THE CRIMPING OPERATION PUSH ON THE CABLE****INSPECTION DIMENSIONS AFTER ASSEMBLY (SEE 616096017 IN PAGE ½)****FOR INFORMATION****CONCENTRIC TWINAX 616096017 INSTALLED IN INSERT FOR ENVIRONMENTAL APPLICATION**