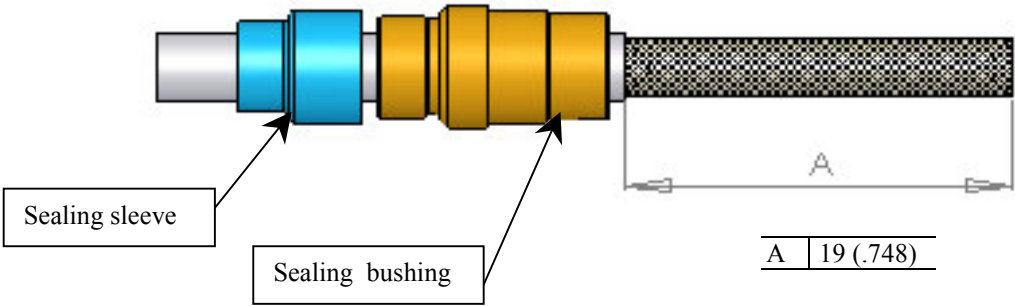
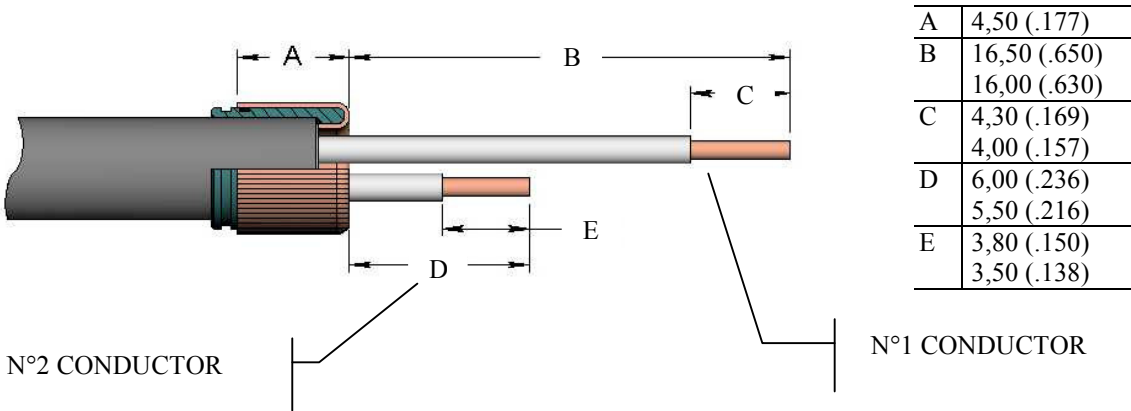


FOR ENVIRONMENTAL APPLICATION, BEFORE STRIPPING, SLIDE SEALING SLEEVE AND SEALING BUSHING OVER CABLE (EXEPT : 616096102)

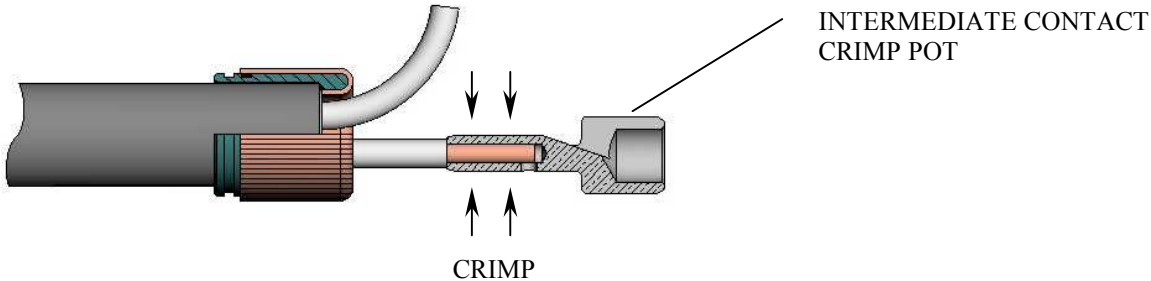
STEP 1/
TRIM CABLE JACKET TO LENGTH INDICATED



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 TWO INNER CONDUCTORS



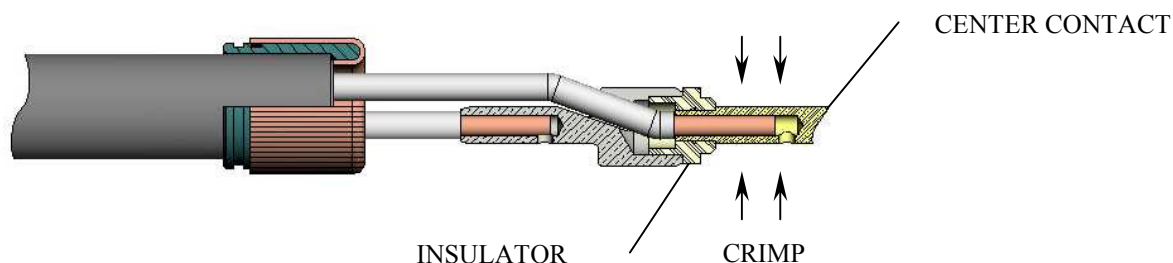
STEP 3/
INTRODUCE THE N°2 CONDUCTOR INTO THE INTERMEDIATE CONTACT CRIMP POT
CRIMP THE INTERMEDIATE CONTACT CRIMP POT
CRIMPING TOOL M22520/2-01 (RADIAL 282281)
SELECTOR POSITION 5
POSITIONER RADIAL 282574



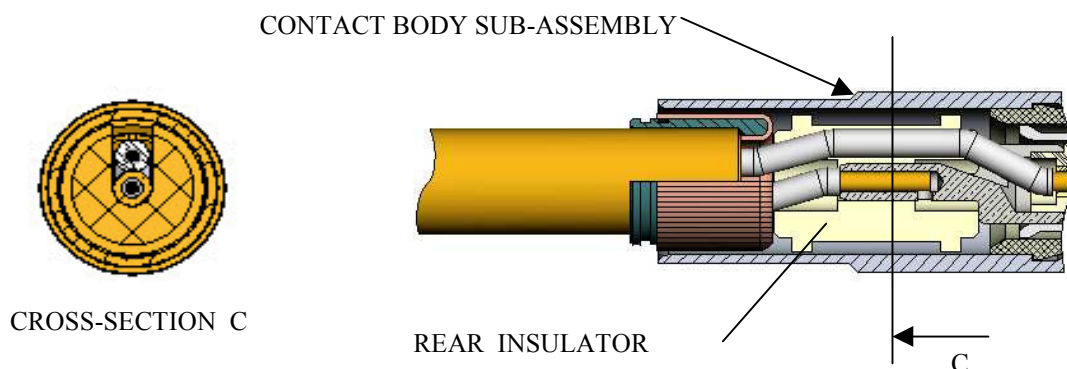
CREATION				
NAME : B.GOMBERT				
DATE : 10/JUN/05				
APPR. : L.LAHOREAU	ISSUE	REVISIONS	NAME	APPROVED

STEP 4/

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 5
 POSITIONER RADIAL 282576

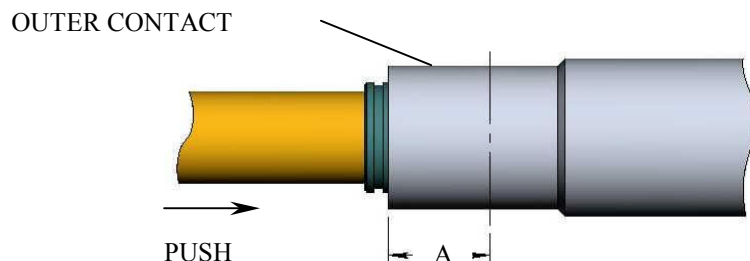

STEP 5/

INSTALL THE REAR INSULATOR
 INTRODUCE THIS CABLE ASSEMBLY INTO THE CONTACT BODY SUB-ASSEMBLY


STEP 6/

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)

(NOTA : THE TOOL M22520/5-05 (RADIAL 282246) HEXAGONAL DIE CLOSURE A (.213 ON FLATS)
 CAN BE USED AS AN ALTERNATE BUT REQUIRES 100% VISUAL INSPECTION OF CRIMPING
 BARREL FOR CRACKS AFTER CRIMPING.)



CRIMPING AREA	
A	6,50 (.256)
	5,50 (.216)

DURING THE CRIMPING OPERATION PUSH ON THE CABLE

INSPECTION DIMENSIONS AFTER ASSEMBLY (SEE 616096004 IN PAGE 2/2 or
 616096102 IN PAGE 2/2)