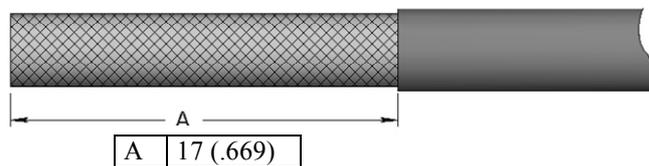
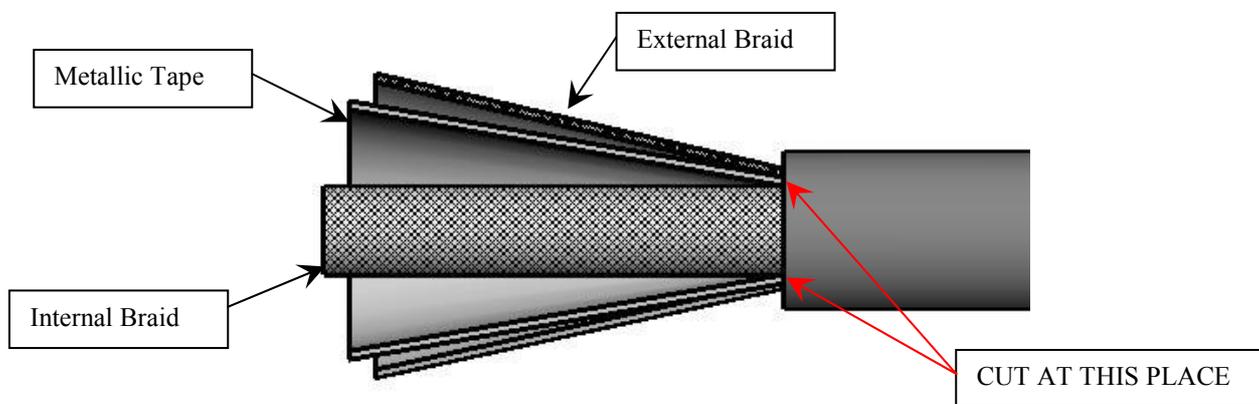


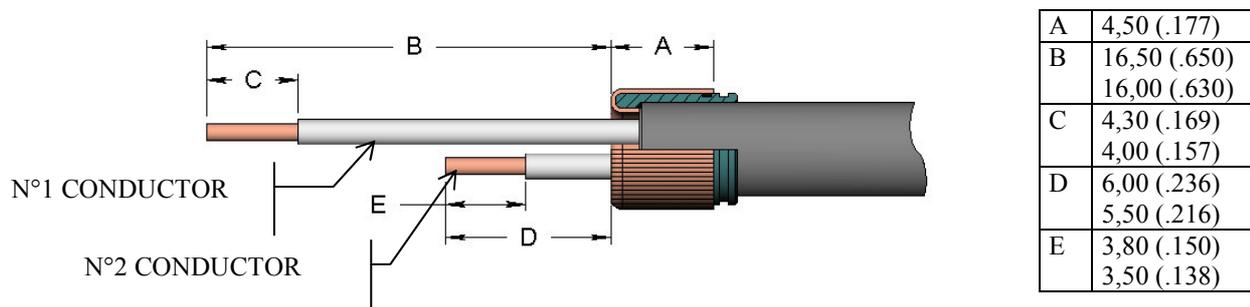
STEP 1/  
TRIM CABLE JACKET TO LENGTH INDICATED



STEP 2/  
**FOR RAYCHEM 10614-24 CABLE ONLY**  
BEFORE SLIDE THE FERRULE OVER THE CABLE AND STEP 3/, CUT THE EXTERNAL BRAID AND THE METALLIC TAPE LIKE THE PICTURE TO REMOVE ALL OF THEM.



STEP 3/  
SLIDE THE FERRULE OVER THE CABLE. CUT THE HIGH IMMUNITY RIBBON IF ANY  
FOLD BACK COMBED BRAID OR BRAIDS OVER THE FERRULE AS INDICATED  
CUT BRAID OR BRAIDS AS SHOWN  
CUT ROD FILLERS  
STRIP THE TWO INNER CONDUCTORS

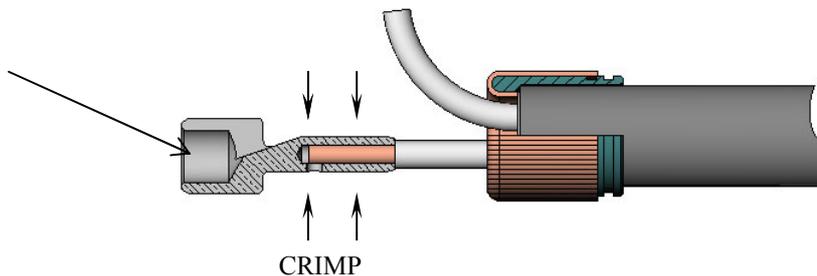


STEP 4/  
INTRODUCE THE N°2 CONDUCTOR INTO THE INTERMEDIATE CONTACT CRIMP POT

<b>CREATION</b>				
<b>PEN: M020004028A</b>	JAN 08, 08	REDRAWN, ADDED RAYCHEM 10614-24 CABLE ON	MONDOT	BROCHET
<b>M040009364A</b>		STEP2/		
<b>NAME : GOMBERT</b>	17/08/04	ADD 616095026	GOMBERT	LAHOREAU
<b>DATE : 08 OCT. 02</b>	<b>ISSUE</b>	<b>REVISIONS</b>	<b>NAME</b>	<b>APPROVED</b>
<b>APPR. : JP. MACARI</b>				

CRIMP THE INTERMEDIATE CONTACT CRIMP POT  
 CRIMPING TOOL M22520/2-01 (RADIALL 282281)  
 SELECTOR POSITION 7  
 POSITIONER RADIALL 282574

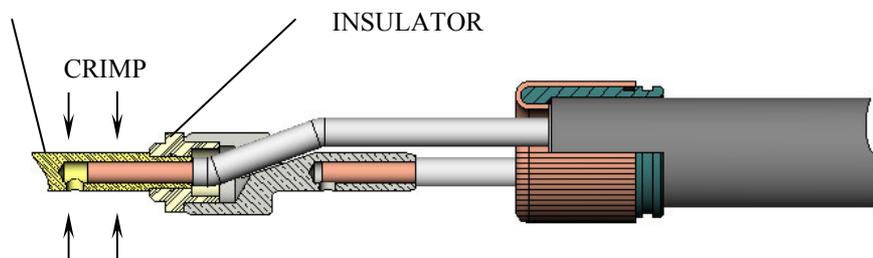
INTERMEDIATE CONTACT  
 CRIMP POT



STEP 5/

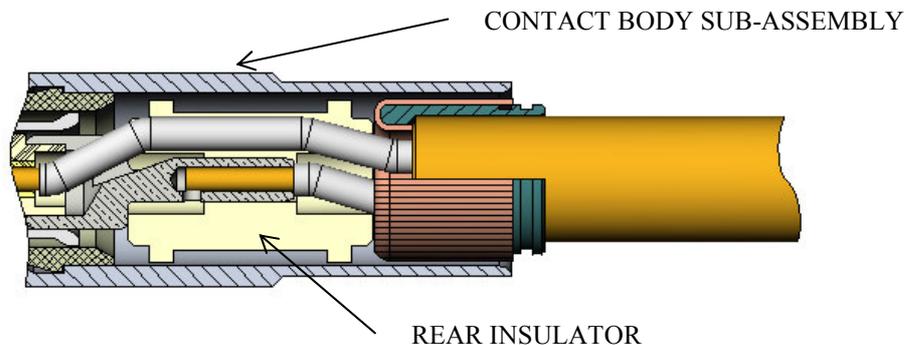
PUT THE N°1 CONDUCTOR IN THE SLOT OF THE INTERMEDIATE CONTACT CRIMP POT  
 SLIDE THE CENTER CONTACT OVER THE CONDUCTOR  
 CRIMP THE CENTER CONTACT  
 CRIMPING TOOL M22520/2-01 (RADIALL 282281)  
 SELECTOR POSITION 7  
 POSITIONER RADIALL 282576

CENTER CONTACT



STEP 6/

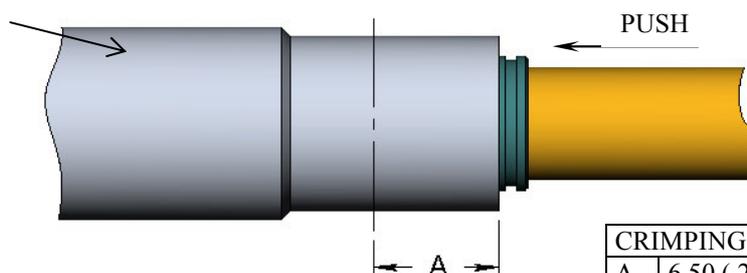
INSTALL THE REAR INSULATOR  
 INTRODUCE THIS CABLE ASSEMBLY INTO THE CONTACT BODY SUB-ASSEMBLY



STEP 7/

CRIMP THE OUTER CONTACT BODY BARREL IN THE INDICATED CRIMPING AREA  
 CRIMPING TOOL M22520/5-01 (RADIALL 282293)  
 DIE M22520/5-45 (RADIALL 282236) HEXAGONAL DIE CLOSURE B (.218 ON FLATS)

OUTER CONTACT



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

DURING THE CRIMPING OPERATION PUSH ON THE CABLE