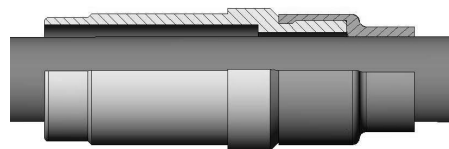
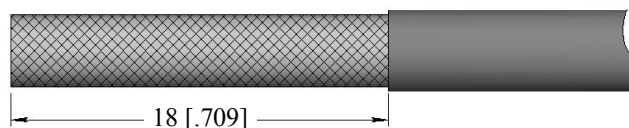
 RADIALL®	TECHNICAL DATA SHEET		RP 57759	
Series EPXB	CONCENTRIC TWINAX CONTACTS : 617052, 617152, 617052001, 617152001 ASSEMBLY INSTRUCTIONS FOR TENSOLITE 24473/03159X-2(LD) CABLES		Issue July 19 th ,2004	Page 1 / 3

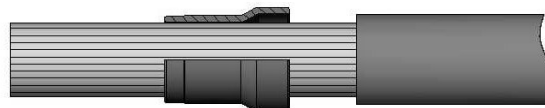
- 1- a. For environmental contact, slide the environmental sleeve over the cable before stripping.



- b. Strip cable as illustrated.



- c. Comb braids and slide the ferrule over the cable.

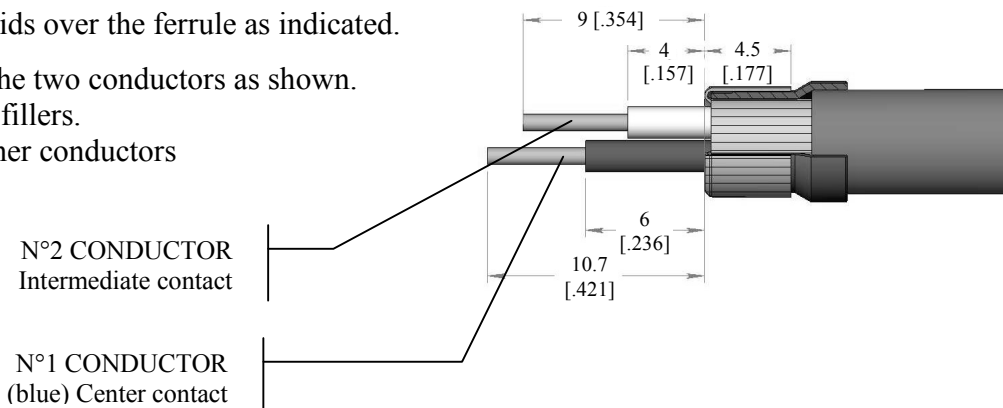


- 2- a. Fold back braids over the ferrule as indicated.

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.

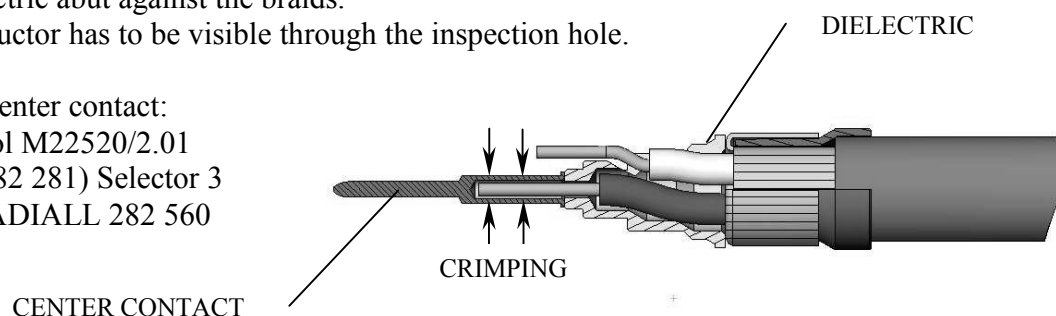
The first conductor has to be visible through the inspection hole.

- c. Crimp the center contact:

. Crimping tool M22520/2.01

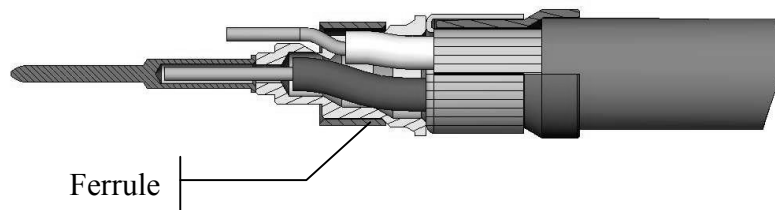
(RADIALL 282 281) Selector 3

. Positioner RADIALL 282 560

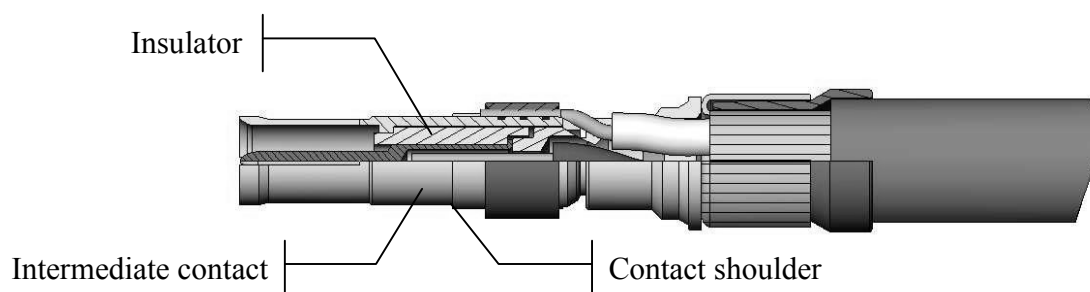


CREATION NAME : M.PESSARD DATE : 07/19/2004 APPR. L.GARCIA				
	ISSUE	REVISIONS	NAME	APPROVED

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

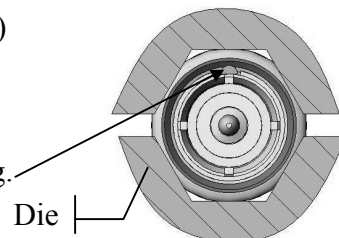


- 5- a. Slide the intermediate insulator over the crimped center contact. Then, introduce this sub-assembly into the intermediate contact.
- b. Put the 2nd conductor in the barrel slot of the intermediate contact. Slide back the ferrule over the intermediate contact barrel as indicated in the drawing below. The ferrule must not stick out from the contact shoulder.

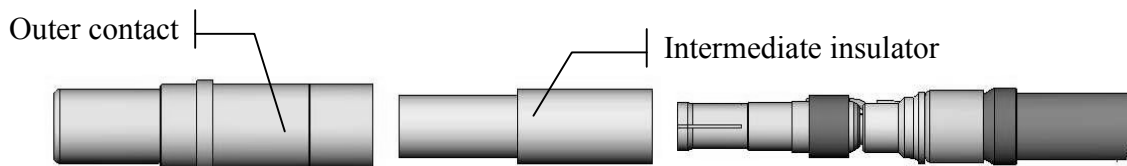


- c. Crimp the ferrule: .Crimping tool M22520/5.01 (RADIALL 282 293)
. Die M22520/5.05 (RADIALL 282 246).
Hex B ((4.5mm) .178in on flats)

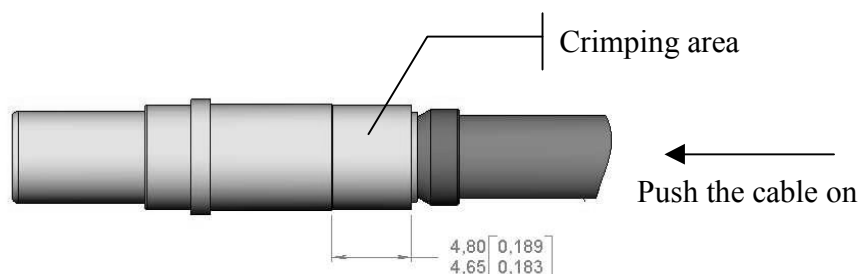
Be sure the 2nd conductor is in front of an hexagonal flat before crimping.



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



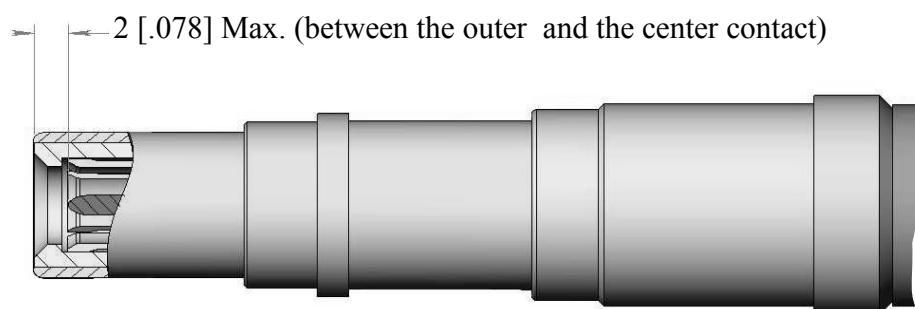
- b. Crimp the outer contact: . Crimping tool M22520/5.01 (RADIALL 282 293)
. Die M22520/5.05 (RADIALL 282 246). Hex A ((5.4mm) .213 on flats.)
- Press lightly the outer contact between dies in the indicated crimping area below.
In the same time, push the cable on to put all the components in right position.
Then close completely the dies.



7- For environmental contact, bring back the environmental sleeve on the contact outer body.

Inspection dimensions after assembly

A- Pin twinax contact:



B- Socket twinax contact:

