
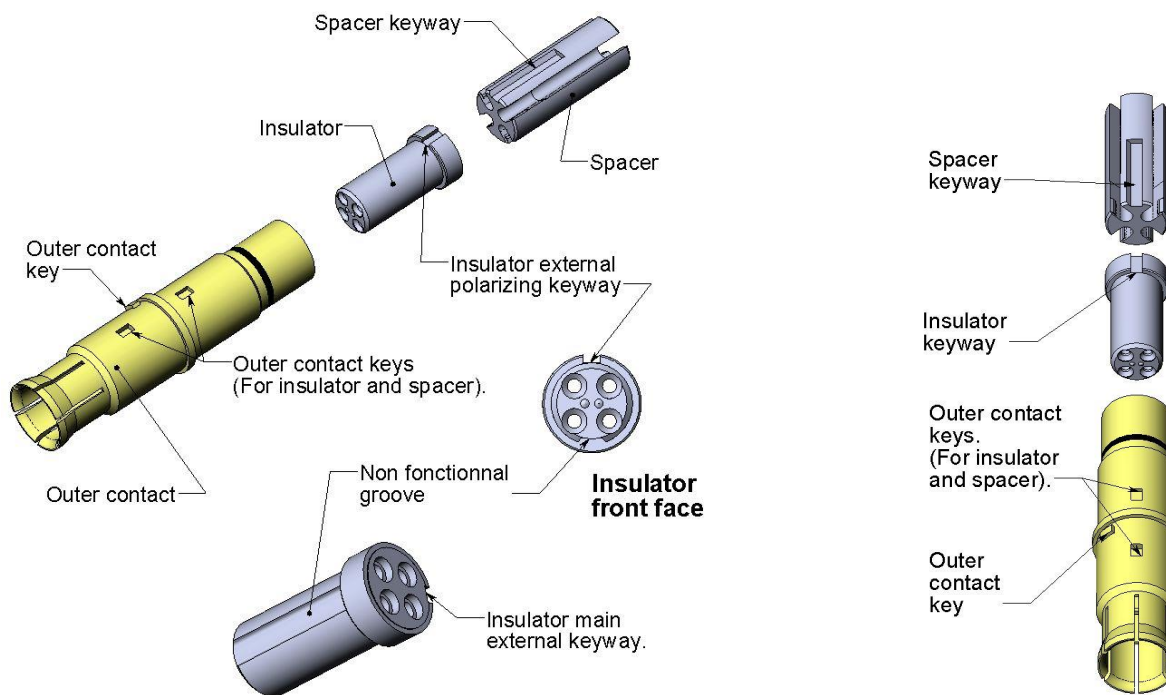


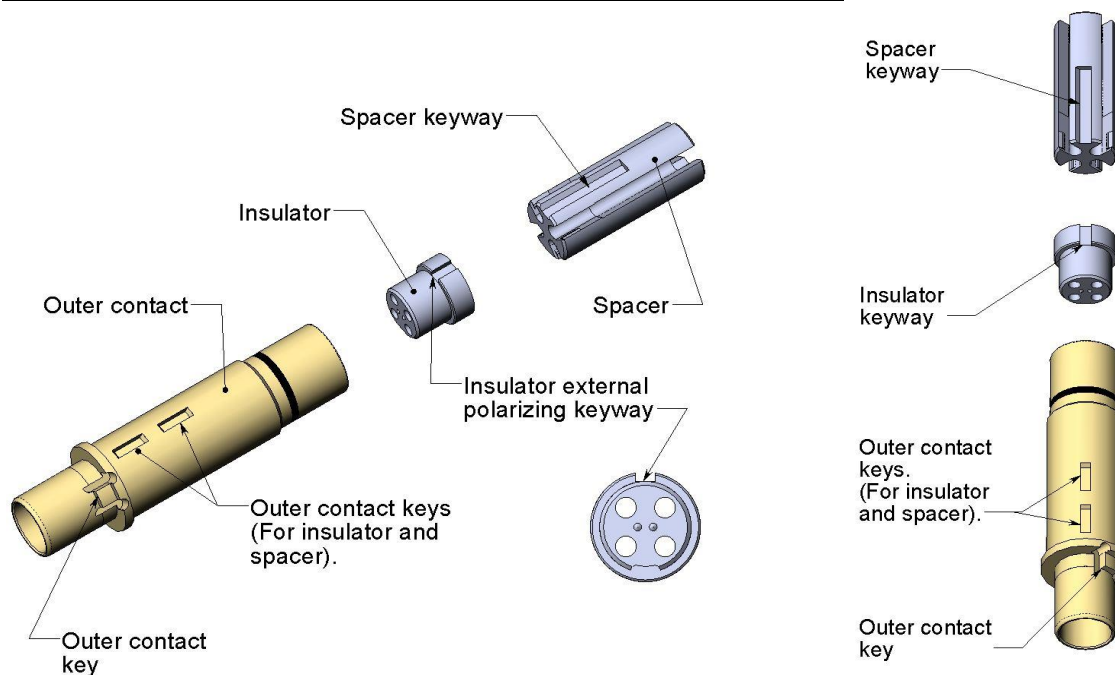
Radiall 		TECHNICAL DATA SHEET		RP 58866	
Series 670	SIZE 8 QUADRAX CONTACTS WIRING INSTRUCTIONS Cables: TENSOLITE NF24Q100 / NF26Q100 or ABS1503KD24 or GSC01 81869-01			Issue Feb. 22, 2016	Page 1/4

OVERVIEW, PRODUCT DESCRIPTION

Socket contact



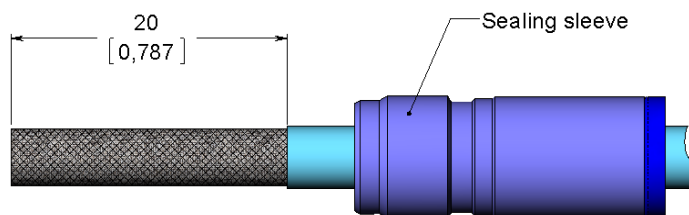
Pin contact



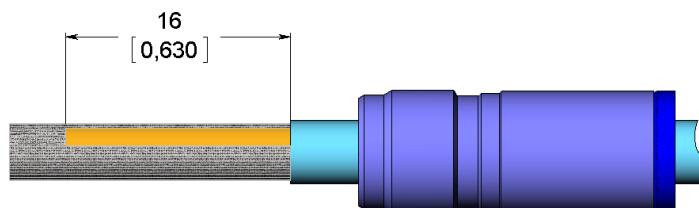
CREATION NAME : B VAN DEN DATE : AUG -19-2005 APPR. :	Feb. 22, 2016	Chapter 4: Stripping lengths was 3,25/3,75 and 13,50/14,00	Perrin H.	Opin X.
	Sept. 09, 2015	Sheet 2: Note added in §1 – Sheet 4: Chapter 10 added	Perrin H.	Le Gloahec Y.
	May 07, 2012	Cable "NF26Q100 added – Sealing sleeve modified	Perrin H.	Pessard M.
	July 12, 2011	Cable "GSC01 81869-01 cable type	Perrin H.	Pessard M.
	July 07, 2011	View of pin contact added on sheet 1 – Note on § 1 cancelled. Drawings reviewed – ABS1503 cable type added on title	Perrin H.	Opin X.
	May 11, 2011	§ 0/ Overview added	Perrin H.	Lahoreau C.
	ISSUE	REVISIONS	NAME	APPROVED

WIRING INSTRUCTIONS

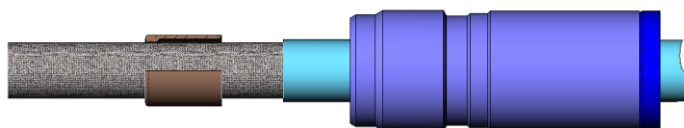
- 1/** Slide the sealing sleeve over the cable and strip the outer jacket as illustrated.
NOTE: Isopropyl alcohol is allowed to make easier the boot to slide on the cable.



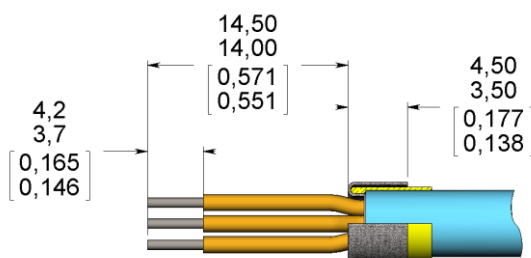
- 2/** Comb the braid and cut the 4 inner conductors to length indicated in order to be able to twist the braid.



- 3/** Slide the shield crimp sleeve over the braid against the sheath end cut. First, twist the braid end to facilitate the sliding of the shield crimp sleeve.

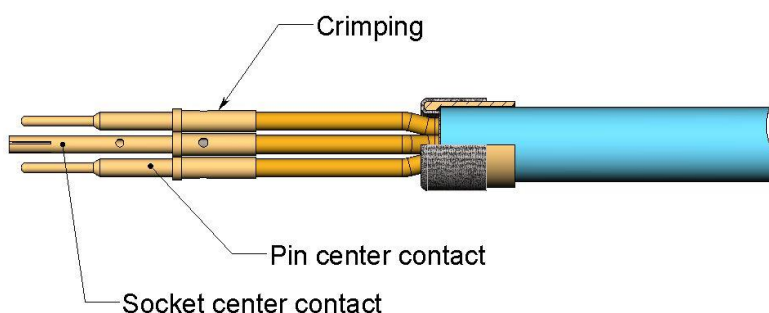


- 4/** Fold back the braid over the shield crimp sleeve and cut the flat shield braid. Then cut the braid and the 4 conductors as shown:

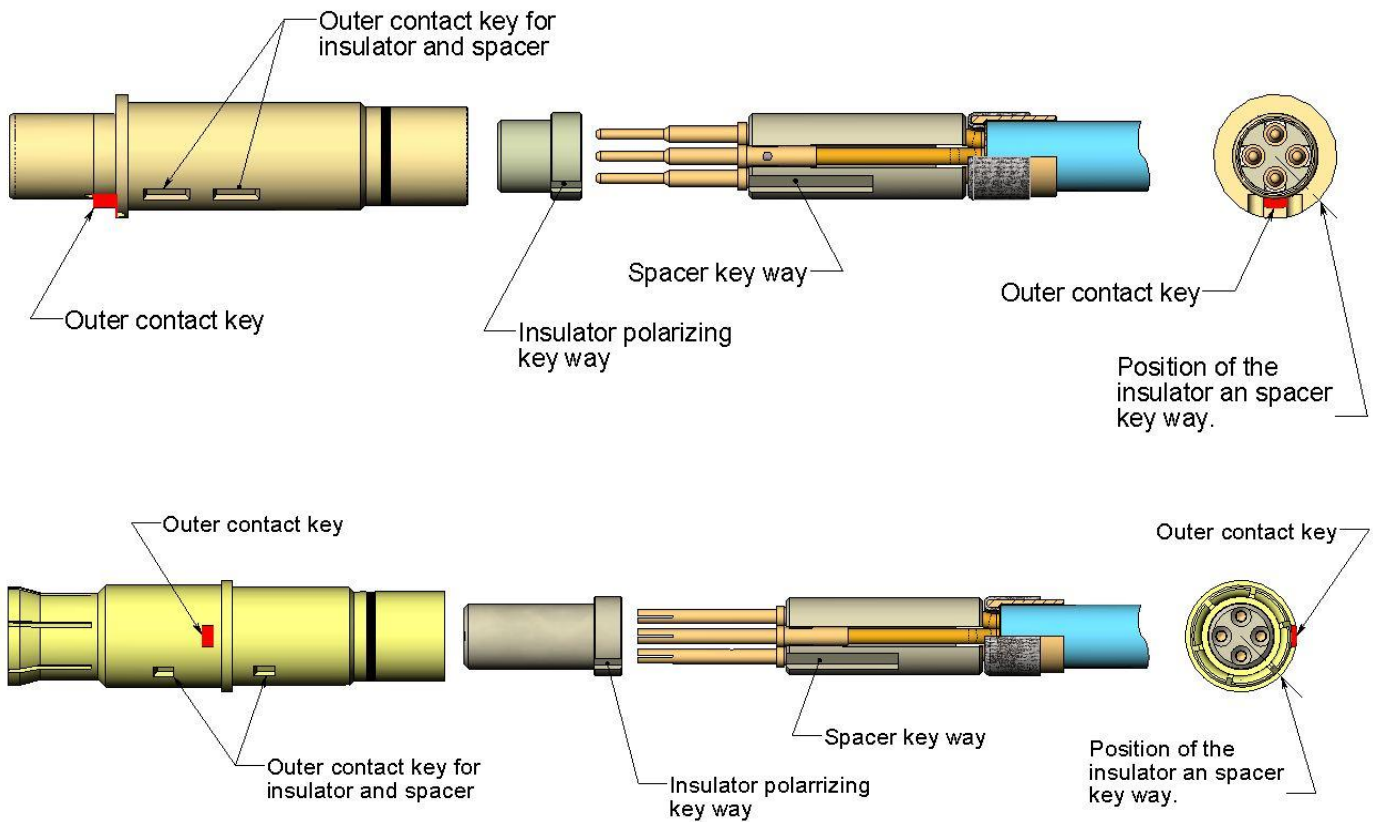


- 5/** Slide the center contacts on the conductors:
- 4 pin center contacts on the quadrax pin contact P/N 670 175 xxx
 - 4 socket center contacts on the quadrax socket contact P/N 670 075 xxx

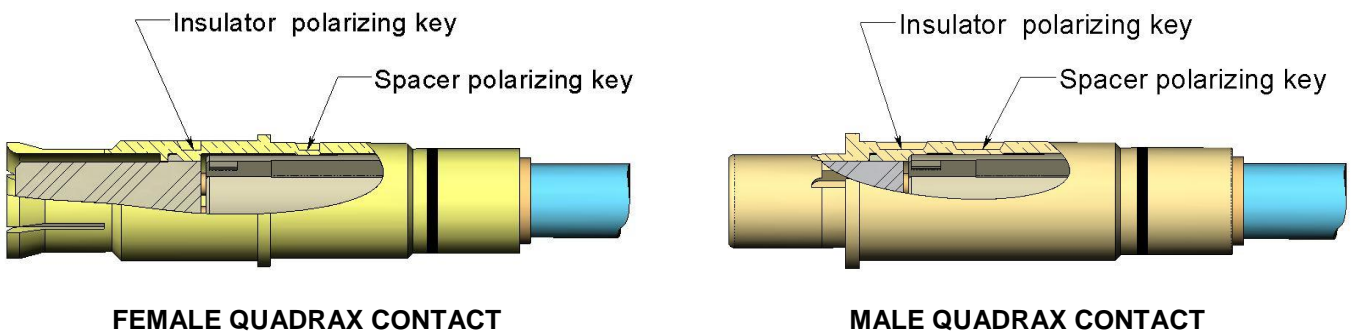
- 6/** Crimp the center contacts.
Crimping tool : M22520/2-01 (RADIAL 282 281) selector 5
Positioner : DANIELS K 709 (RADIAL 282 581 010)



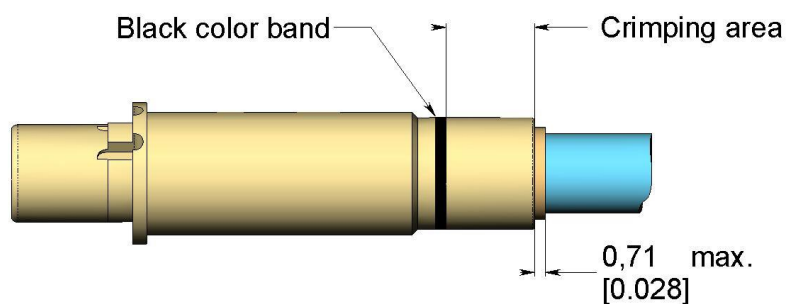
- 7/** Put in place the 4 conductors into the slots of the spacer.
Then, slide the insulator over the contacts making the polarizing keys coincident



- 8/** The male and female outer contact bodies have an insulator polarizing key.
The insulator and the spacer have a polarizing keyway.
Then, introduce the sub-assembly into the outer contact body making the polarizing keys coincident.



- 9/** Crimp the outer contact body in the indicated area.
Crimping tool : M22520/5-01 (RADIALl 282 293)
Die : M22520/5-45 (RADIALl 282 236) -Hex die closure B (.218 on flats).



- 10/** After the contact assembly is installed into the connector, push the intermediate seal boot and the seal boot over the crimp barrel of the contact until it bottoms.