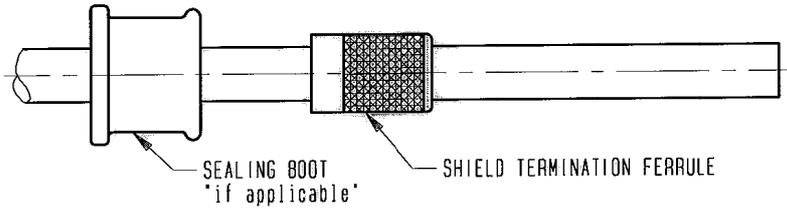
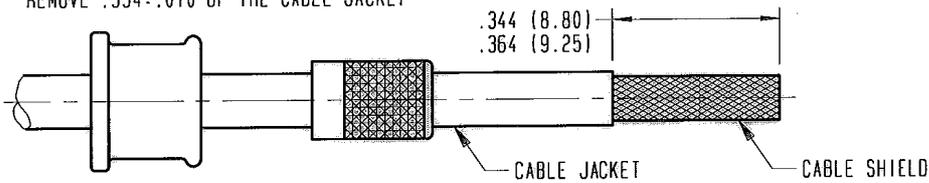




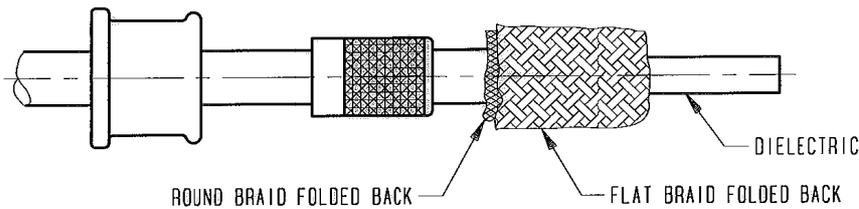
STEP 1
PUT THE SEALING BOOT AND THE SHIELD TERMINATION FERRULE OVER THE COAX CABLE



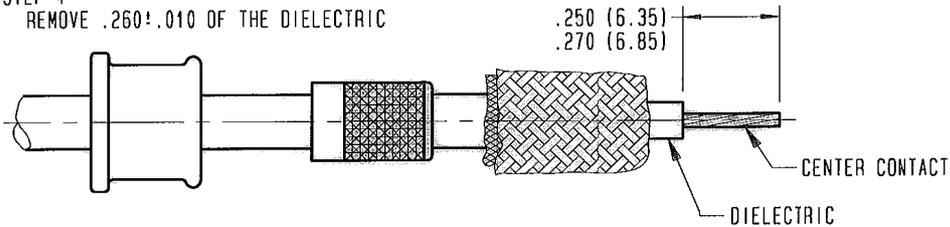
STEP 2
REMOVE .354±.010 OF THE CABLE JACKET



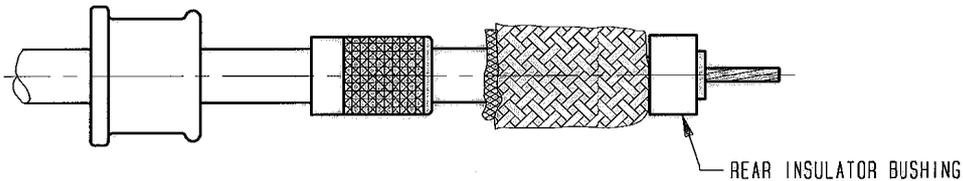
STEP 3
FOLD THE ROUND BRAID AND THE FLAT BRAID BACK OVER THE CABLE JACKET
IF NECESSARY, SEPARATE THE STRANDS OF THE FLAT BRAID AND MAKE THE STRANDS STRAIGHT BEFORE YOU FOLD THEM BACK



STEP 4
REMOVE .260±.010 OF THE DIELECTRIC



STEP 5
PUT THE REAR INSULATION BUSHING OVER THE CENTER CONDUCTOR
PUSH THE REAR INSULATION BUSHING UNTIL IT TOUCHES THE SHIELD BRAIDS



This information is given as an indication in the continual goal to improve our products, we reserve the right to make any modifications judged necessary.

4112-9610

CREATION

PEN: .

NOM: JP MACARI

DATE: 03 JAN 94

APPR: .

Apr. 22, 16

Add tolerances dimensions

Branjonneau

Legendre

04-10-95

CRIMP AREA .400 WAS .600

MOKHTARI

.

CHANGE OF THE FERRULE SHAPE

ADDED CRIMP AREA

09-02-94

STEP 2 .354±.010 WAS .410±.020

JP MACARI

STEP 4 .260±.010 WAS .240±.020

Issue

Revisions

Name

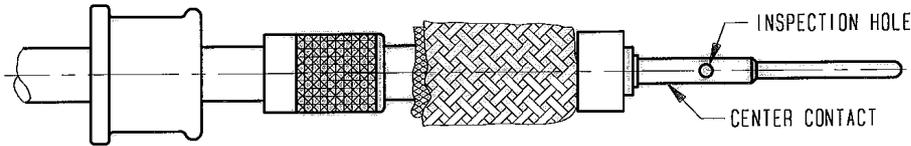
Approved

RADIALL®

101, rue Philibert Hoffmann Z.I. Ouest
93116 ROSNY/BOIS Cedex (France)
Tl.: 01 49 35 35 35
Fax.: 01 48 54 63 63
Tlx: RADI A 235220

STEP 6

PUT THE CENTER CONTACT ON THE CENTER CONDUCTOR
MAKE SURE THAT ALL THE STRANDS OF THE CENTER CONDUCTOR ENTER THE CRIMP BARREL OF THE CENTER CONTACT
PUSH THE CENTER CONTACT UNTIL IT TOUCHES THE INSULATOR BUSHING
MAKE SURE THAT YOU CAN SEE THE CONDUCTOR STRANDS THROUGH THE INSPECTION HOLE IN THE CENTER CONTACT

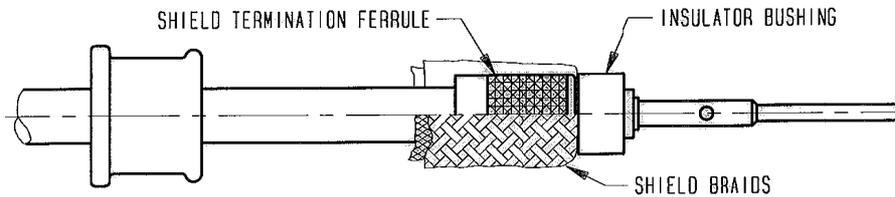


USE A M22520/2-01 CRIMPING TOOL WITH A DANIELS K345 LOCATOR TO CRIMP THE CENTER CONTACT TO THE CENTER CONDUCTOR

SELECTOR ON: 5 FOR BOEING CABLE P/N:S280W503-1
6 FOR BOEING CABLE P/N:S280W503-2
6 FOR RAYCHEM CABLE P/N:5021K1011

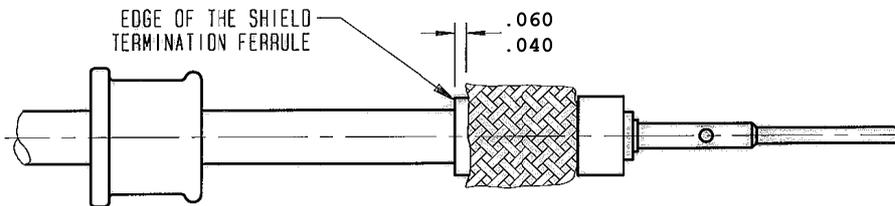
STEP 7

PUSH THE SHIELD TERMINATION FERRULE FORWARD UNTIL IT TOUCHES THE SHIELD BRAIDS THAT TOUCH THE INSULATOR BUSHING



STEP 8

PUT THE SHIELD BRAIDS SYMMETRICALLY AROUND THE SHIELD TERMINATION FERRULE
CUT THE SHIELD BRAIDS AT .040 FROM THE EDGE OF THE SHIELD TERMINATION FERRULE

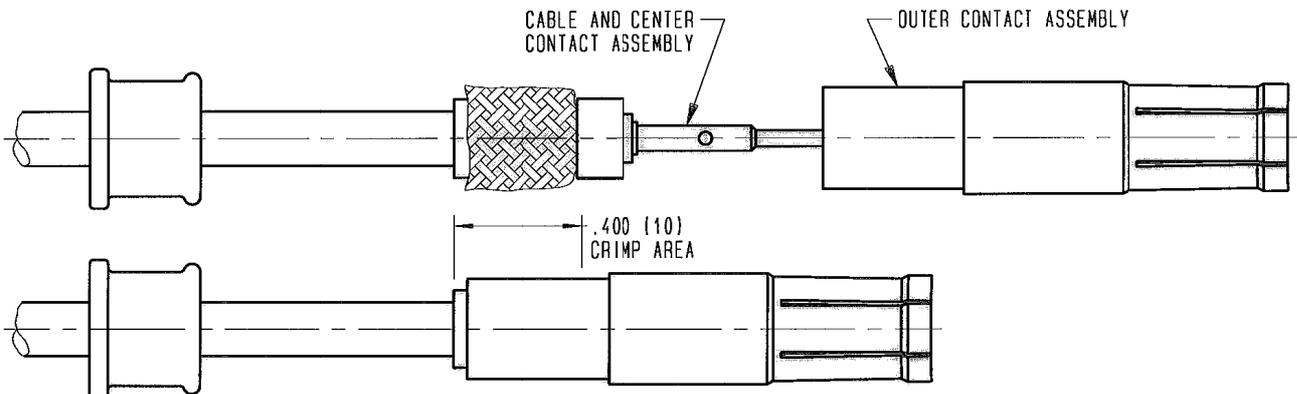


STEP 9

PUSH THE CABLE AND CENTER CONTACT ASSEMBLY INTO THE OUTER CONTACT ASSEMBLY UNTIL IT STOPS

CRIMP THE OUTER CONTACT

USE A M22520/5-01 CRIMPING TOOL WITH M22520/5-45 DIE SET, POSITION B, OR A M22520/10-01 WITH A M22520/10-23



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