

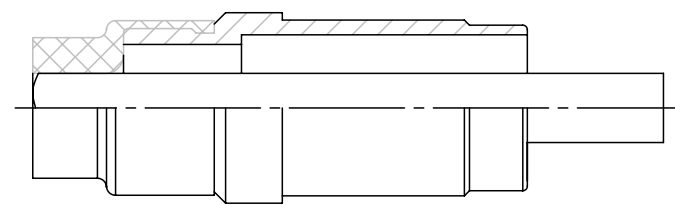
Series  
EPX

CONCENTRIC TWINAX CONTACTS: 617050, 617150, 617050001 and 617150001.  
ASSEMBLY INSTRUCTIONS.  
FOR PAN 6421, M17176/00002 AND RAYCHEM 10613 CABLES.

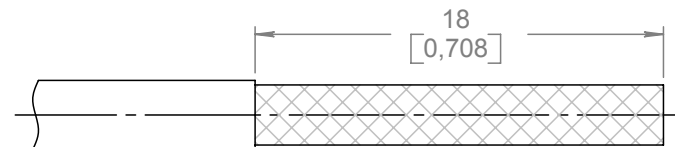
Issue:  
Jul. 17, 2008

Page  
1/3

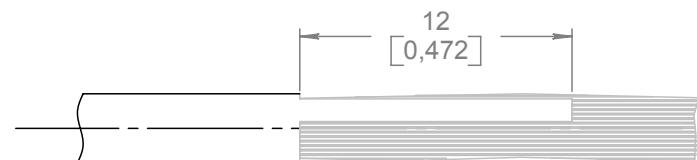
1 - a. For environmental contact, slide the environmental sleeve over the cable before stripping.



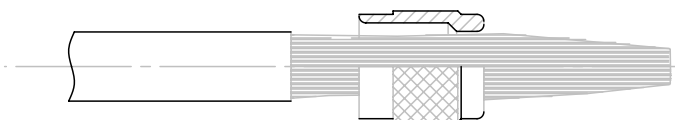
b. Strip cable as illustrated.



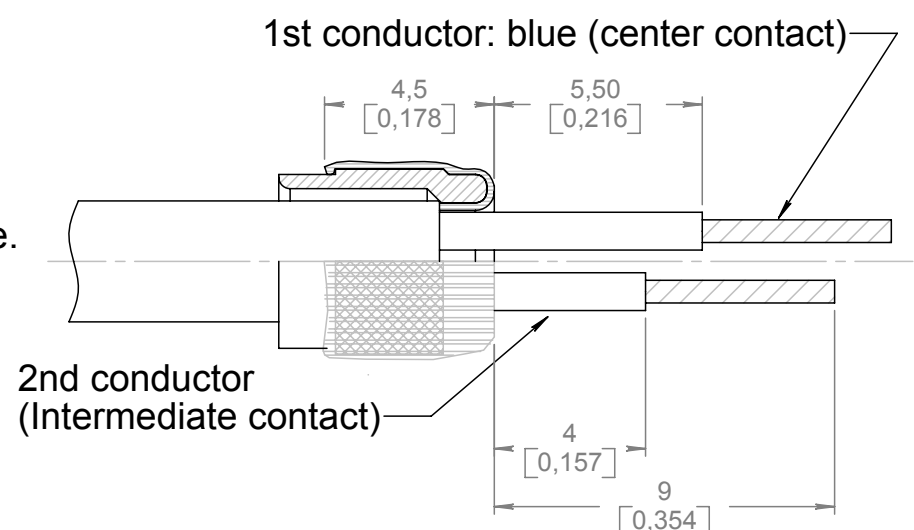
c. Comb braids and cut the high immunity ribbon. Cut the 2 conductors to the length indicated.



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

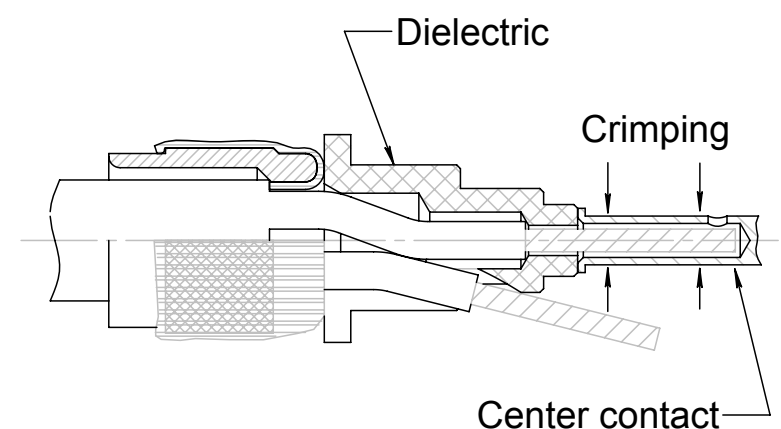


b. Fold back the braid(s) over the shield crimp sleeve. Cut the braid(s) and the 2 conductors as shown. Cut the rod fillers.



3 - a. Slide the dielectric on the first conductor. The 2nd conductor coming in the slot.

b. Slide the center contact on the first conductor until it butts against the braid(s). The cable conductor must be visible through the inspection hole.



c. Crimp the center contact:  
- Crimping tool M22520/2.01 (RADIAL 282 281), selector 3.  
- Positioner RADIAL 282 560.

DIMENSIONS : mm (inch are given for information only)



<b>CREATION</b>  <b>PEN:</b>  <b>NOM:</b> MACARI JP. <b>DATE:</b> Apr. 15, 85 <b>APPR.:</b>	Jul. 17, 08	"Raychem 10613 cable" added in the title.	Malty	Pailot
	Mar. 21, 01	Added "cut the rod fillers" to 2b.	Valgresy	Baldyrou
	Feb. 27, 01	Added bracket to 5c. Hex B and 6b. Hex A.	Valgresy	Baldyrou
	Feb. 26, 01	Indicative DIM on flat in inches.	Valgresy	Jacob
	Jan. 22, 99	Redraw, Added operations 1a. and 7, Suppression of 2nd conductor tinning.	Garcia	Giet
	Issue	Revisions	Name	Approved

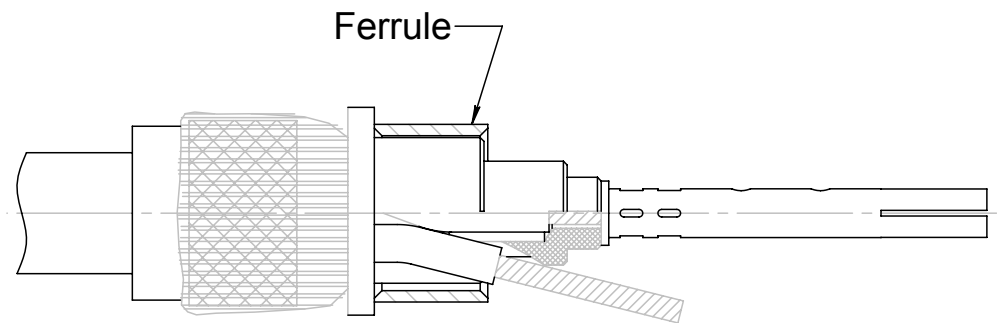
RP2737EN

RADIAL PROPRIETARY INFORMATION

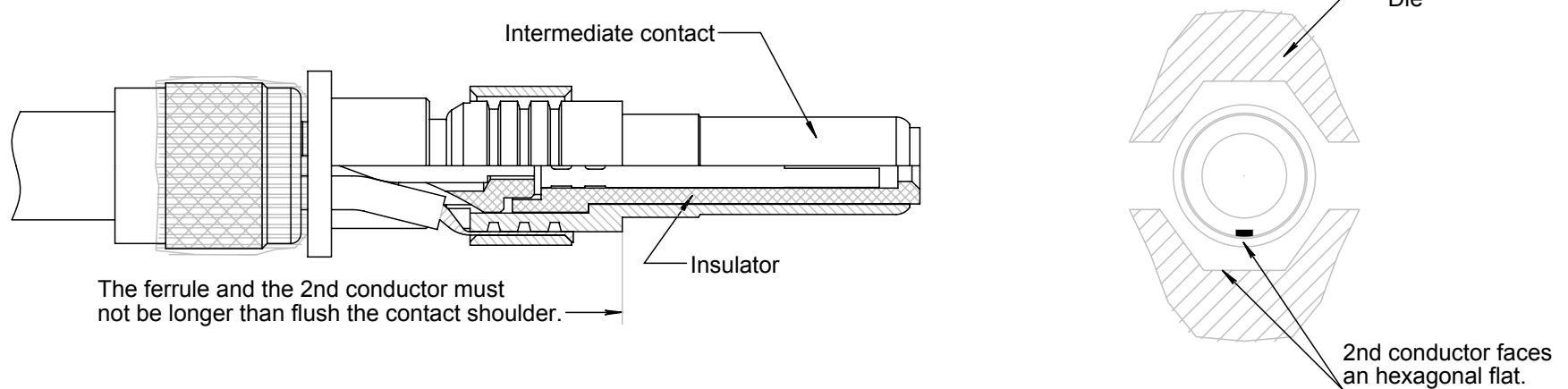
This information is given as an indication. In the continual goal to improve our products, we reserve the right to make any modifications judged necessary.

4112\_9311

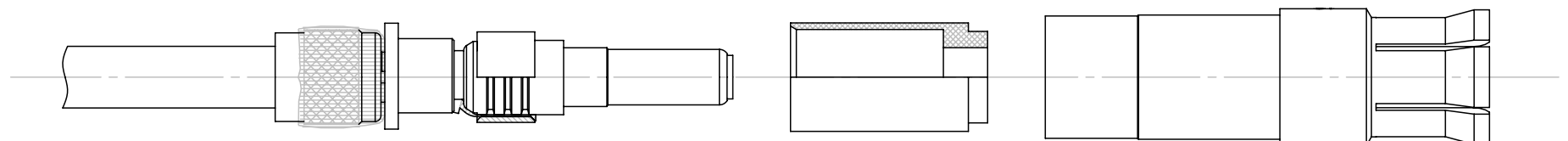
- 4 - Slide the ferrule over the dielectric until it butts against the shoulder.



- 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, slide back the ferrule over the intermediate contact barrel. As indicated on the drawing below.
- c. Crimp the ferrule: - Crimping tool M22520/5.01 (RADIAL 282 293).  
- Die M22520/5.05 (RADIAL 282 246). Hex B ( 4,50 [.178] on flats. )  
Be sure the 2nd conductor is facing an hexagonal flat before crimp.

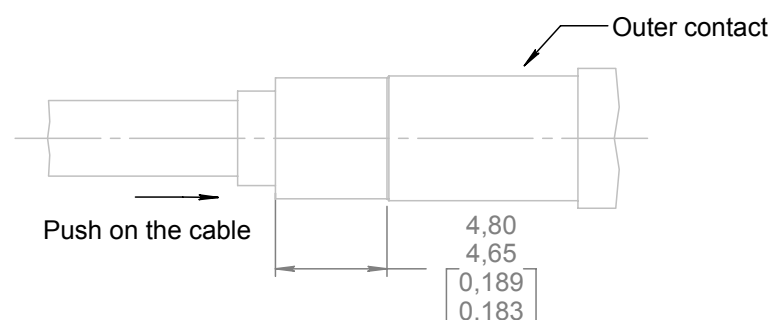


- 6 - a. Introduce the intermediate contact into the intermediate insulator, then into the contact outer body.



- b. Crimp the outer contact: - Crimping tool M22520/5.01 (RADIAL 282 293).  
- Die M22520/5.05 (RADIAL 282 246). Hex A ( 5,40 [.213] on flats. )

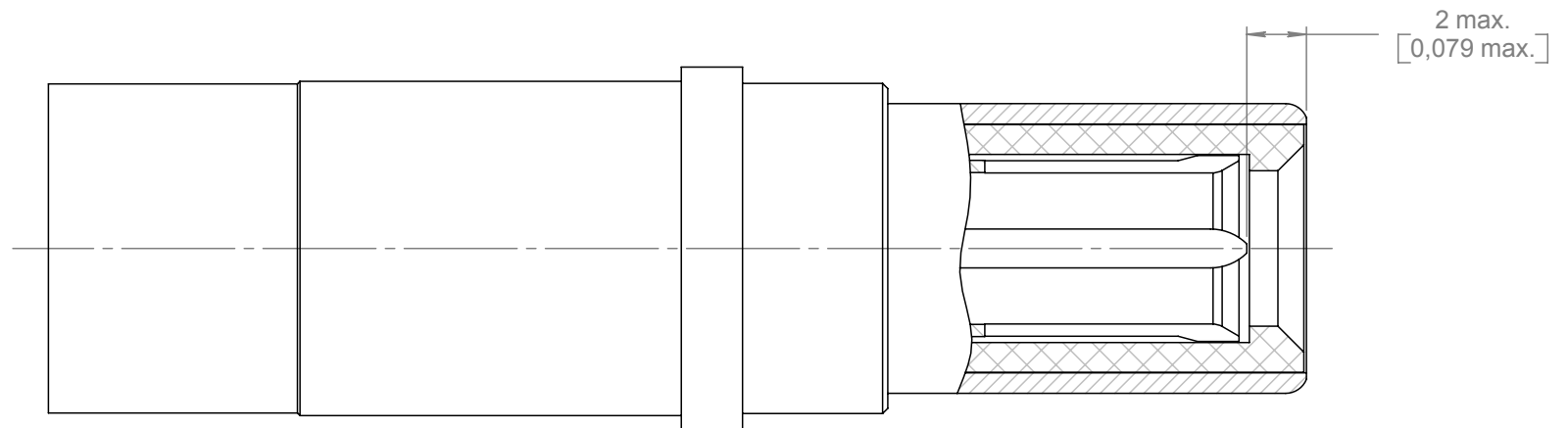
Press slightly the outer contact between dies, in the indicated crimping area below and push on the cable to put all components in the best position. Then close completely the dies.



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

- INSPECTION DIMENSIONS AFTER ASSEMBLY -

A - PIN TWINAX CONTACT:



B - SOCKET TWINAX CONTACT:

