



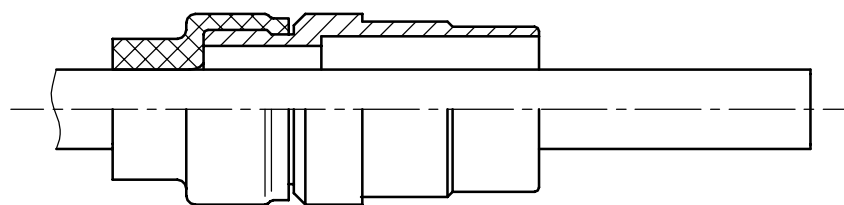
Series
EPX

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

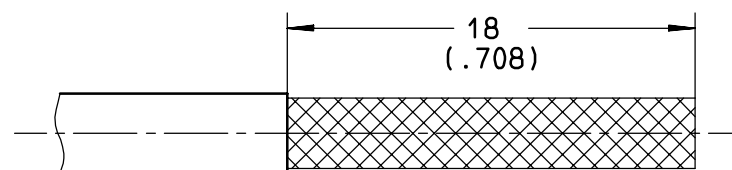
Issue:
21 MAR 2001

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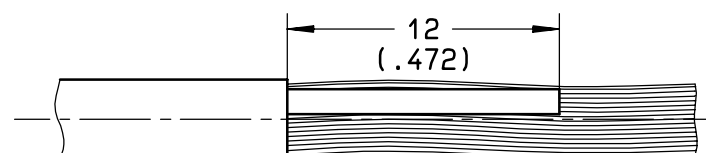
.1- a. For environmental contact, slide the environmental sleeve over the cable before stripping.



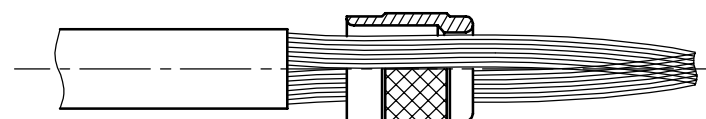
b. Strip cable as illustrated.



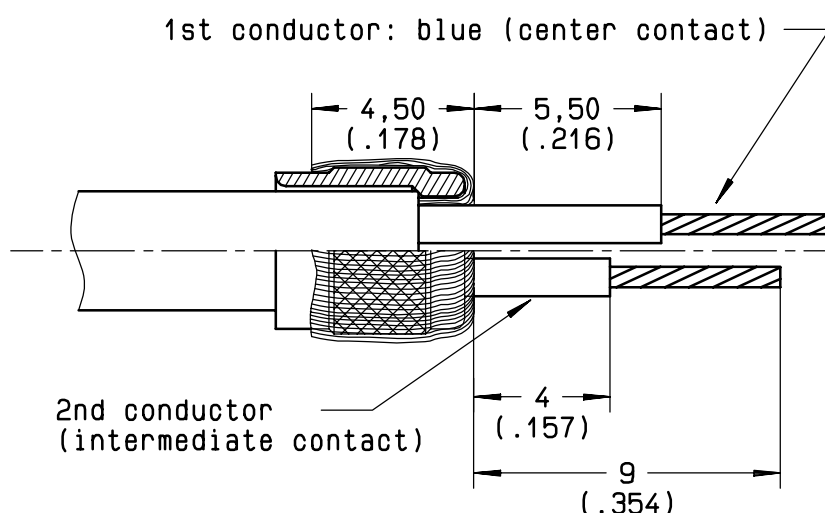
c. Comb braids and cut the high immunity ribbon. Cut the 2 conductors to length indicated.



.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.

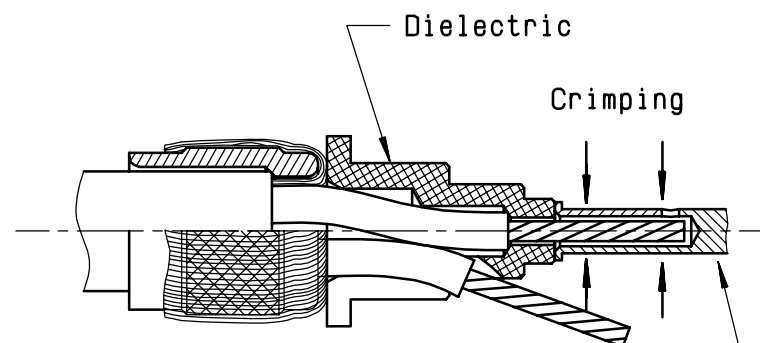


b. Fold back the braid over the shield crimp sleeve. Cut the braid and the 2 conductors as shown. Cut the rod fillers.



.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. The cable conductor must 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.

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.

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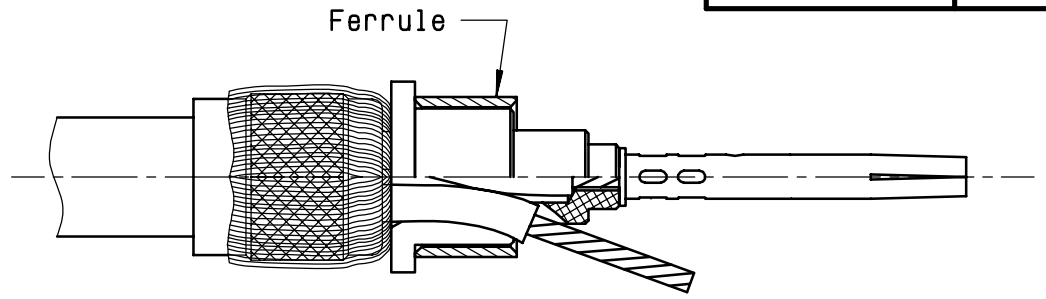
CREATION	Issue	Revisions	Name	Approved
PEN:	21 MAR 01	Added "cut the rod fillers" to 2-b	VALGRESY	.
NOM: JP.MACARI	27 FEB 01	ADDED BRAKET TO 5-c Hex B AND 6-b Hex A	VALGRESY	BALDYROU
DATE: Apr 15, 85	26 FEB 01	INDICATIVE DIM ON FLAT IN INCHES	VALGRESY	JACOB
APPR.: .	01.22.99	Redraw; Added operations 1a. and 7; Suppression of 2nd conductor tinning.	L.Garcia	L GIET

RADIALL[®]

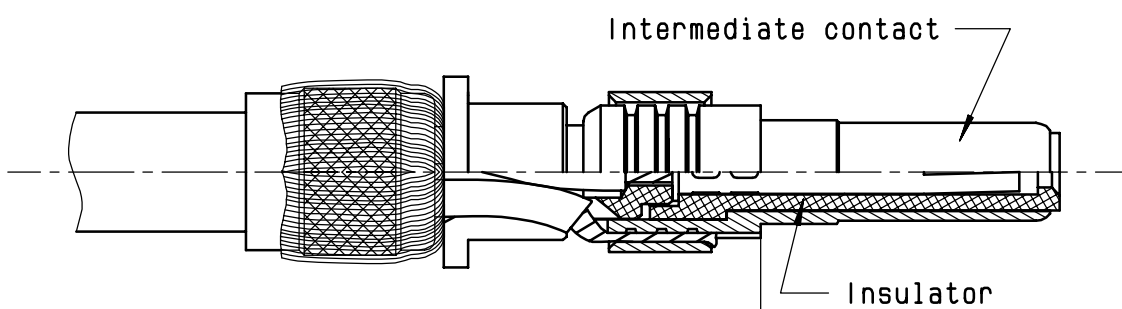
101, rue Philibert Hoffmann Z.I. Ouest
93116 ROSNY/BOIS Cedex (France)
Tl.: 01 49 35 35 35
Fax.: 01 48 54 63 63
Tlax: RADIA 235220



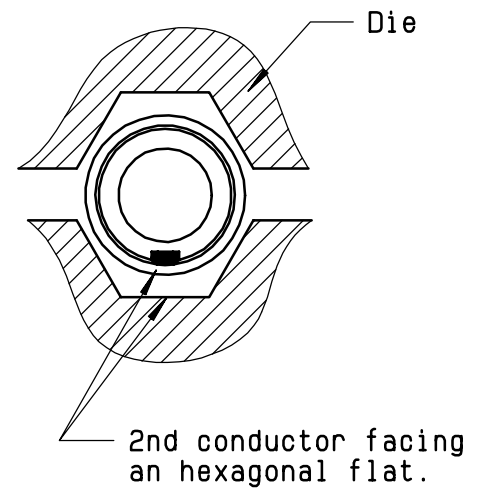
- .4- Slide the ferrule over the dielectric until it butts against the shoulder.



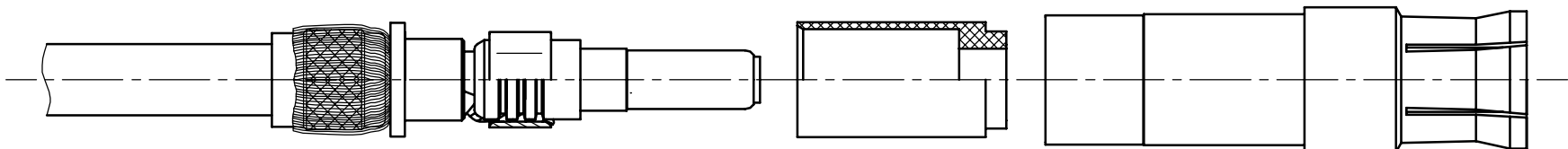
- .5- a. Slide the intermediate insulator over the crimped center contact. Then, introduce this sub-assembly into the intermediate contact.
- b. Put the 2nd conductor in the barrel slot, slide back the ferrule over the intermediate contact barrel. As indicated on the drawing below.
- c. Crimp the ferrule: . Crimping tool M22520/5.01 (RADIALL 282 293).
. Die M22520/5.05 (RADIALL 282 246). Hex B (4,5mm) .178 on flats.)
Be sure the 2nd conductor is facing an hexagonal flat before crimp.



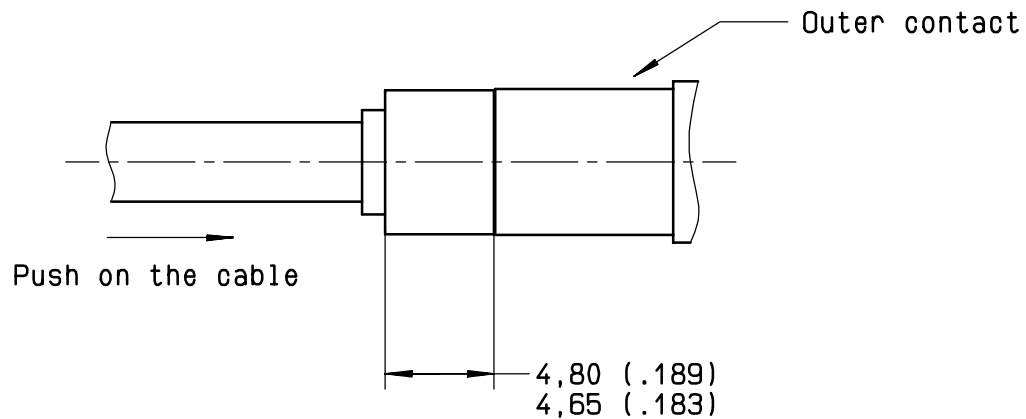
The ferrule and the 2nd conductor must not be more than flush the contact shoulder.



- .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 (RADIALL 282 293).
. Die M22520/5.05 (RADIALL 282 246). Hex A (5,4 mm) .213 on flats.)
Press lightly the outer contact between dies, in the indicated crimping area below and push on the cable to put all components in a good position. Then close completely the dies.



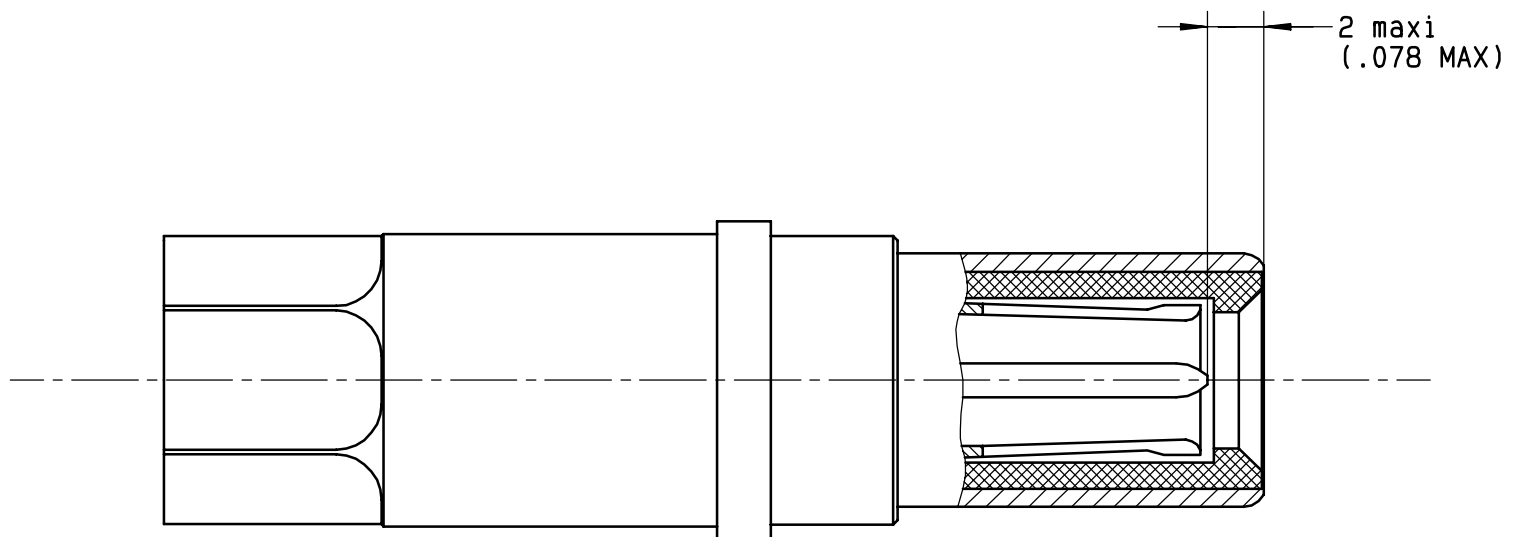
- .7- For environmental contact, bring back the environmental sleeve on the contact outer body.

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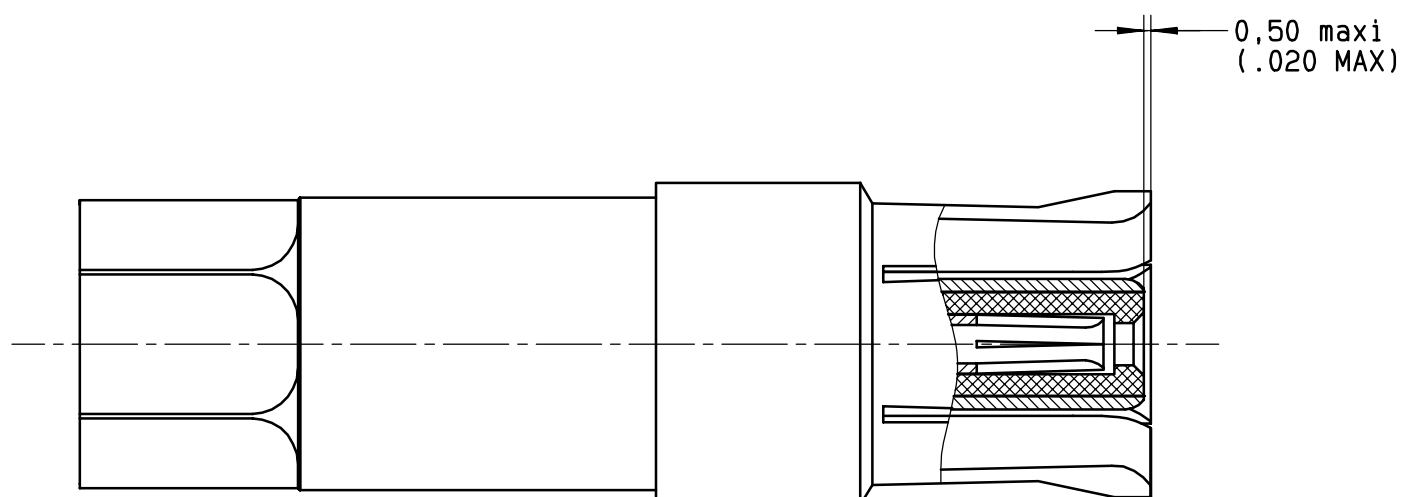


- INSPECTION DIMENSIONS AFTER ASSEMBLY -

.A- PIN TWINAX CONTACT:



.B- SOCKET TWINAX CONTACT:



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