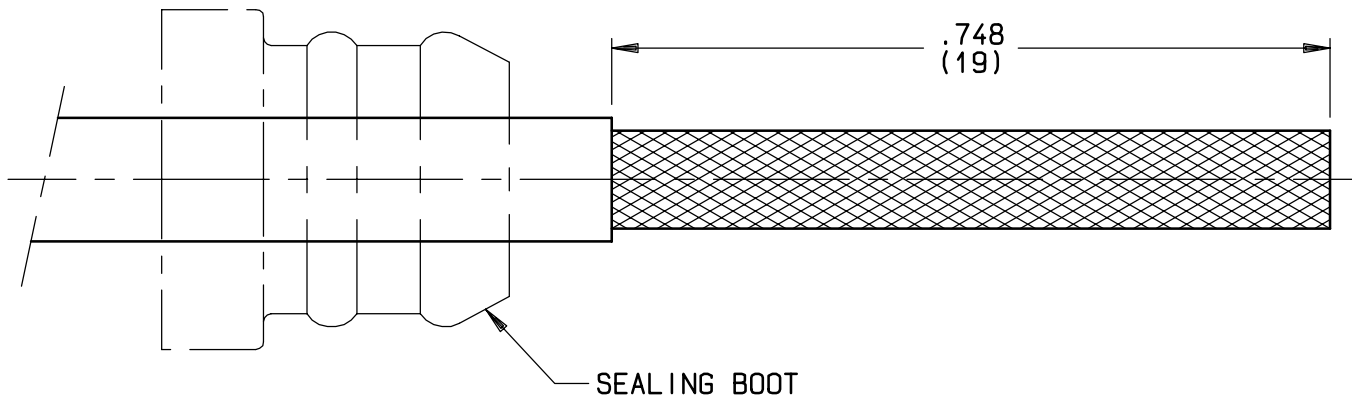


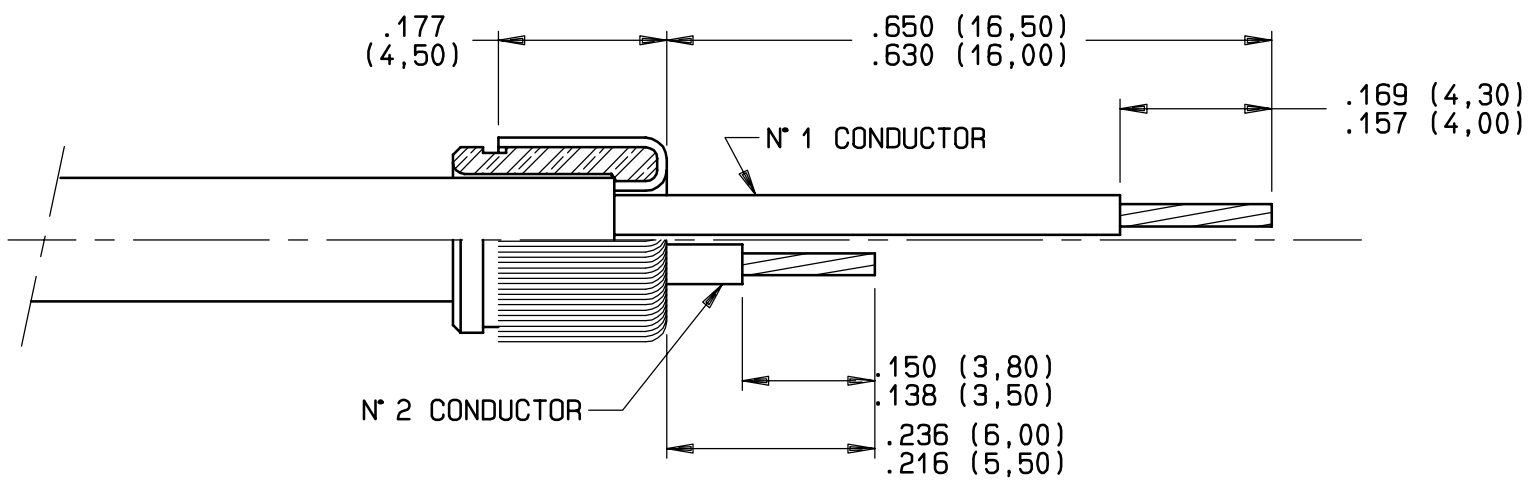


FOR ENVIRONMENTAL APPLICATION, BEFORE STRIPPING, SLIDE SEALING BOOTH OVER CABLE  
FOR NON ENVIRONMENTAL PIN CONTACTS (670150, 670151, 618160 AND 618161), SLIDE CENTERING  
BOOT OVER CABLE BEFORE STRIPPING

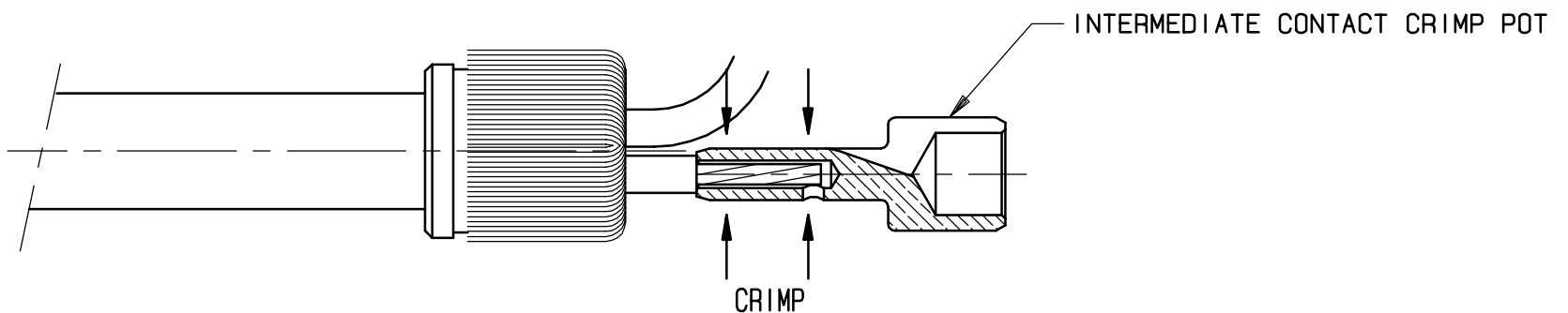
STEP 1/  
TRIM CABLE JACKET TO LENGTH INDICATED



STEP 2/  
SLIDE THE FERRULE OVER THE CABLE. CUT THE HIGH IMMUNITY RIBBON IF ANY  
FOLD BACK BRAID OR BRAIDS OVER THE FERRULE AS INDICATED  
CUT BRAID OR BRAIDS AS SHOWN  
CUT ROD FILLERS  
STRIP THE TWO INNER CONDUCTORS



STEP 3/  
INTRODUCE THE N° 2 CONDUCTOR INTO THE INTERMEDIATE CONTACT CRIMP POT  
CRIMP THE INTERMEDIATE CONTACT CRIMP POT  
CRIMPING TOOL M22520/2-01 (RADIAL 282281)  
SELECTOR POSITION 5  
POSITIONER RADIAL 282574



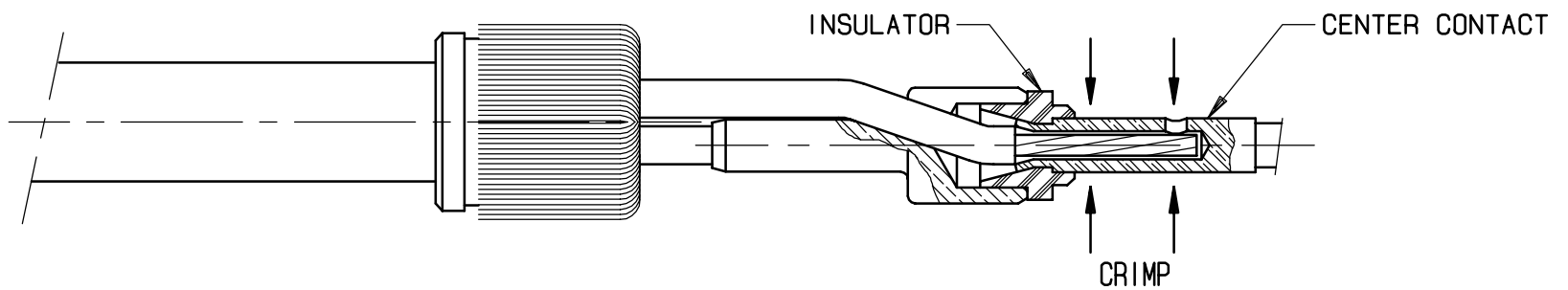
This information is given as an indication. In the continual goal to improve our products, we reserve the right to make any modifications judged necessary.

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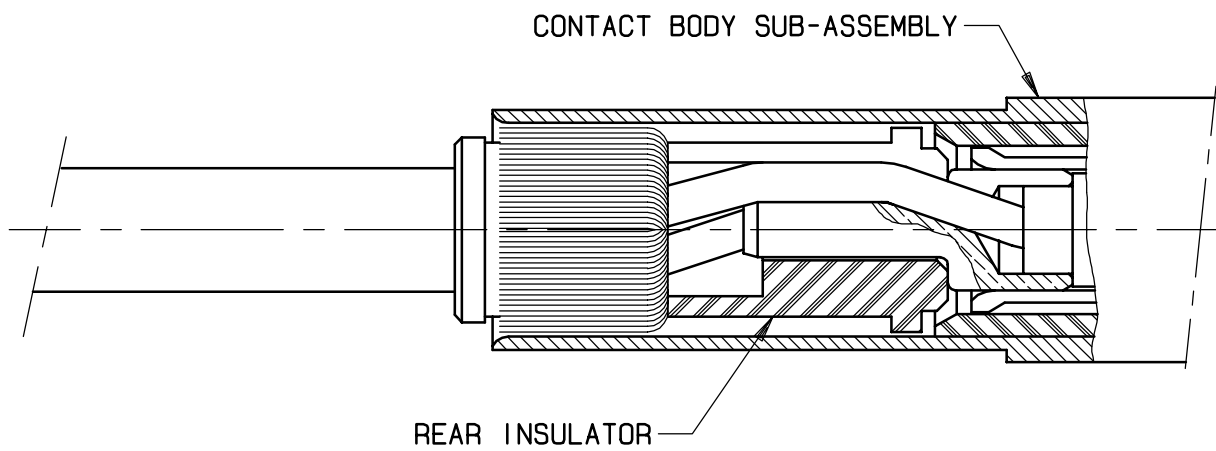
CREATION				
PEN:	26 FEB 01	CORRECTION INDICATIVE DIMENSION ON FLATS FOR M22520/5-45	VALGRESY	JACOB
NOM: MARIE	15 DEC 97	ADDED 618160002	VALGRESY	JACOB
DATE: 01/12/86	22/08/96	ADD.616095009 AND 616195009	GOMBERT	K PECHEUX
APPR.:	2 DEC.94	REDRAWN BY CAD.	BALDYROU	VALGRESY
	Issue	Revisions	Name	Approved



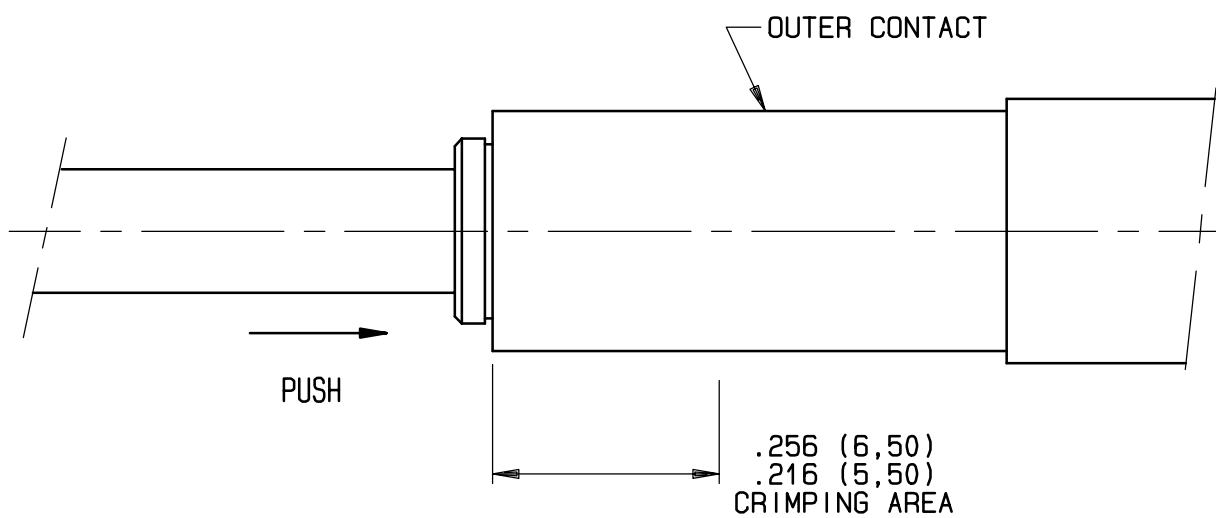
STEP 4/  
 PUT THE N° 1 CABLE IN THE SLOT OF THE INTERMEDIATE CONTACT CRIMP POT  
 SLIDE THE CENTER CONTACT OVER THE CONDUCTOR  
 CRIMP THE CENTER CONTACT  
 CRIMPING TOOL M22520/2-01 (RADIAL 282281)  
 SELECTOR POSITION 5  
 POSITIONER RADIAL 282576



STEP 5/  
 INSTALL THE REAR INSULATOR  
 INTRODUCE THIS CABLE ASSEMBLY INTO THE CONTACT BODY SUB-ASSEMBLY



STEP 6/  
 CRIMP THE OUTER CONTACT BODY BARREL IN THE INDICATED CRIMPING AREA  
 CRIMPING TOOL M22520/5-01 (RADIAL 282293)  
 DIE M22520/5-45 (RADIAL 282236) HEXAGONAL DIE CLOSURE B (.218 ON FLATS)



DURING THE CRIMPING OPERATION PUSH ON THE CABLE

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INSPECTION DIMENSIONS AFTER ASSEMBLY

PART NUMBER		DIMENSIONS	
CONNECTOR	CONTACT	A MAX	B MAX
MIL-C-38999 SERIES 1,3 AND 4 RL	670050		.009 (0,23)
	670051		.009 (0,23)
	670150	.0208 (0,53)	
	670151	.0208 (0,53)	
MIL-C-83527A PrEN3682 MPX	618060		.0315 (0,8)
	618061		.0315 (0,8)
	618160 - 618160002	.039 (1)	
	618161	.039 (1)	
MIL-C-81659B DSX	616095001		.097 (2,46)
	616095009		.097 (2,46)
	616096004		.152 (3,86)
	616195001	.078 (1,97)	
	616195009	.078 (1,97)	
	616196003 616196004	.033 (0,84)	

A: DISTANCE BETWEEN THE END OF OUTER PIN CONTACT AND THE END OF THE CENTER PIN CONTACT

B: DISTANCE BETWEEN THE END OF OUTER SOCKET CONTACT AND THE END OF INTERMEDIATE PIN CONTACT

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