



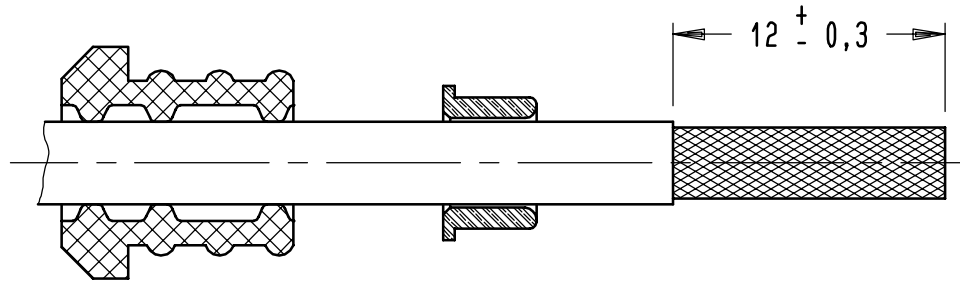
Series
TCX

SIZE 8 CONCENTRIC TWINAX CONTACTS
WIRING INSTRUCTIONS
CABLE P/N : MIL-C-17/176 00002 AND PAN 6421

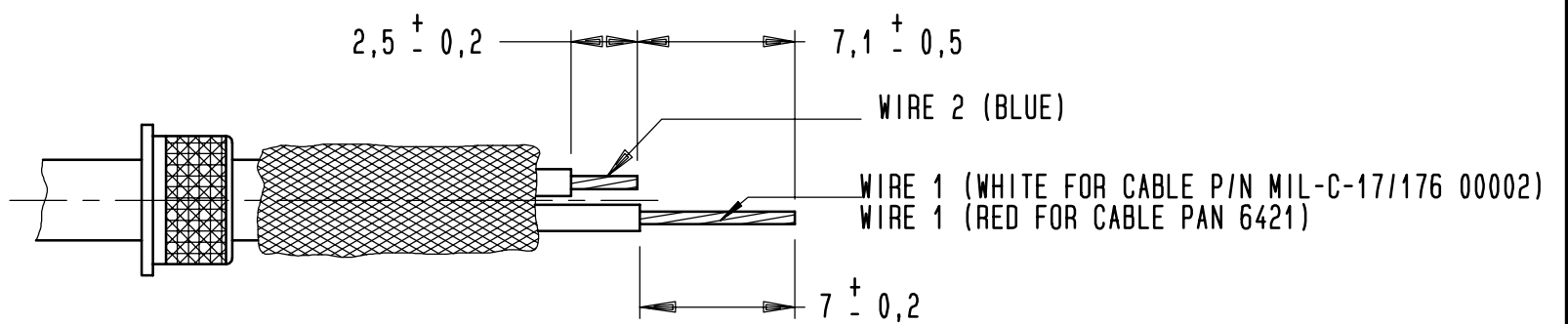
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IF NECESSARY BEFORE STRIPPING, SLIDE SEALING BOOT OVER CABLE

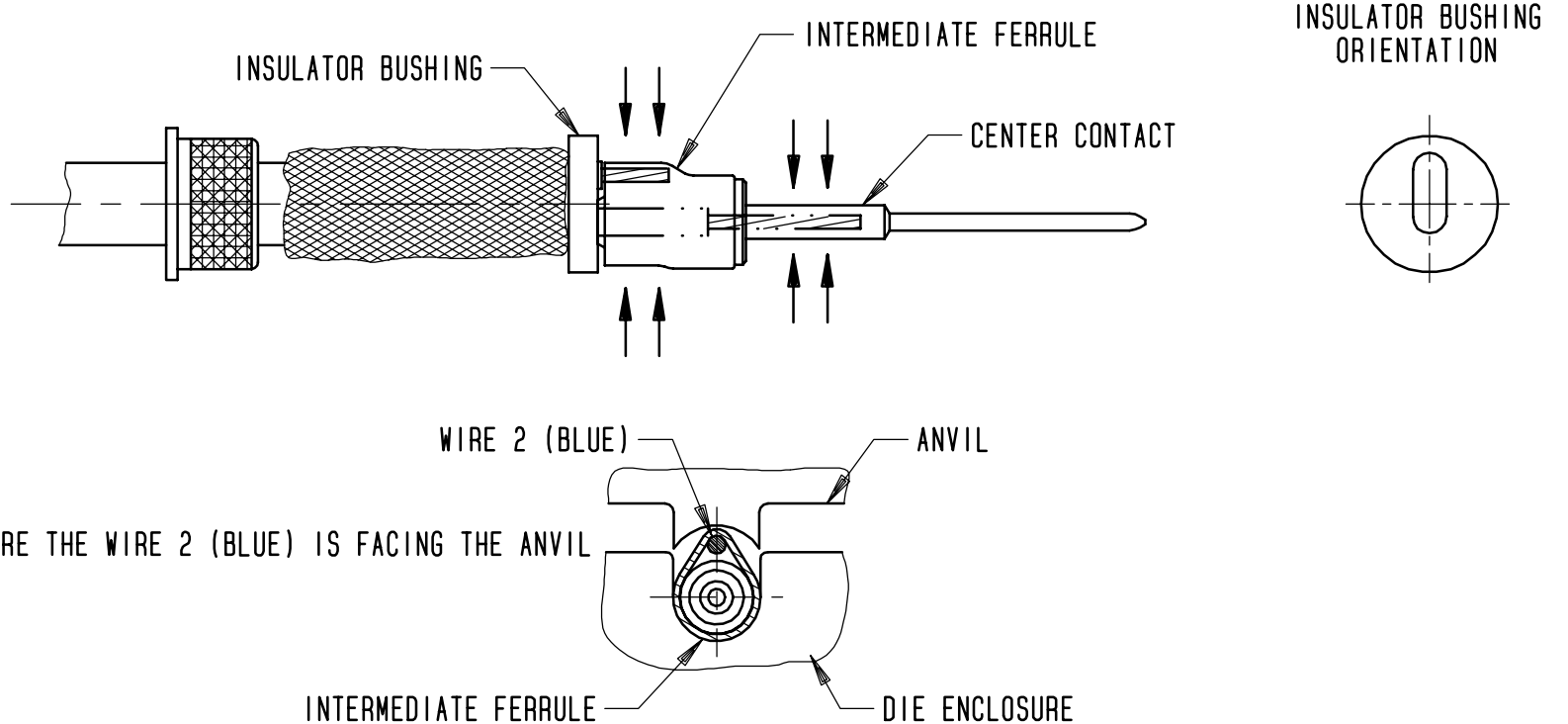
STEP 1/ SLIDE THE INNER FERRULE OVER CABLE
TRIM CABLE JACKET TO LENGTH INDICATED



STEP 2/ PUSH THE SHIELD BRAID BACK AND OVER THE CABLE JACKET
CUT ROD FILLER
STRIP THE TWO INNER WIRES TO LENGTH INDICATED



STEP 3/ PUT THE TWO WIRES IN THE INSULATOR BUSHING UNTIL IT'S BUT AGAINST THE SHIELD BRAID, (SEE ORIENTATION)
INTRODUCE THE WIRE 1 (RED) INTO THE CENTER CONTACT
INTRODUCE THE WIRE 2 (BLUE) INTO THE INTERMEDIATE FERRULE
CRIMP THE CENTER CONTACT AND THE INTERMEDIATE FERRULE USING:
CRIMPING TOOL: M22520/5-01 (RADIALL P/N 282 293)
DIE : RADIALL P/N 282 617 003 (DANIELS Y793A modified) recommended by RADIALL
or M22520/5-104 (DANIELS Y792) according to MIL-C-39029/95 and /96, not recommended by RADIALL
or DANIELS Y793 OR Y793A, not recommended by RADIALL



BE SURE THE WIRE 2 (BLUE) IS FACING THE ANVIL

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.

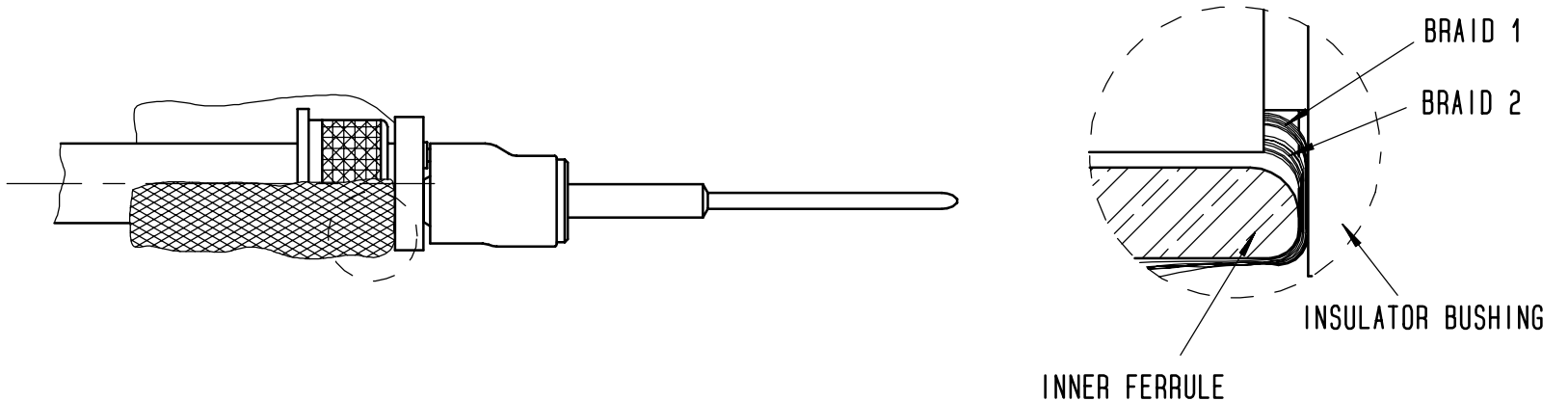
4112-9610

Issue	Revisions	Name	Approved
CREATION			
PEN: M970106323A	08/11/02	ADDED DIE P/N 282 617 003 AND CABLE P/N PAN 6421	DUPUIS BALDYROU
NOM: BALDYROU	07/06/02	ADDED DIE M22520/5-104 (DANIELS Y792)	DUPUIS BALDYROU
DATE: 16 JULY 99	24/01/01	CHANGED LENGTH 7 WAS 6,8	BALDYROU B. VAN DEN
APPR.: B. VAN DEN	11/12/00	RECUCED LENGTH 2,5 WAS 3	BALDYROU B. VAN DEN



STEP 5/ PUSH THE INNER FERRULE FORWARD AND UNDER THE BRAID UNTIL IT IS AGAINST THE INSULATOR BUSHING

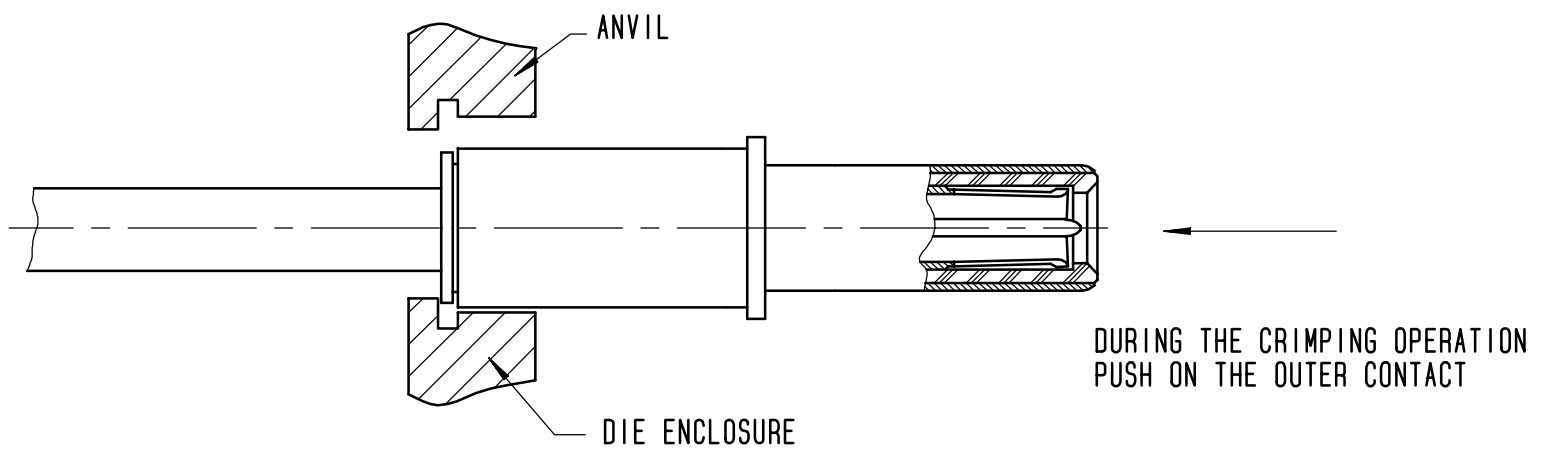
PAY ATTENTION FOR CABLE PAN 6421 :
TIGHTEN THE TWO BRAIDS ON THE INNER TERMINATION FERRULE
DO NOT COMB THE TWO BRAIDS IN THE CRIMPING AREA



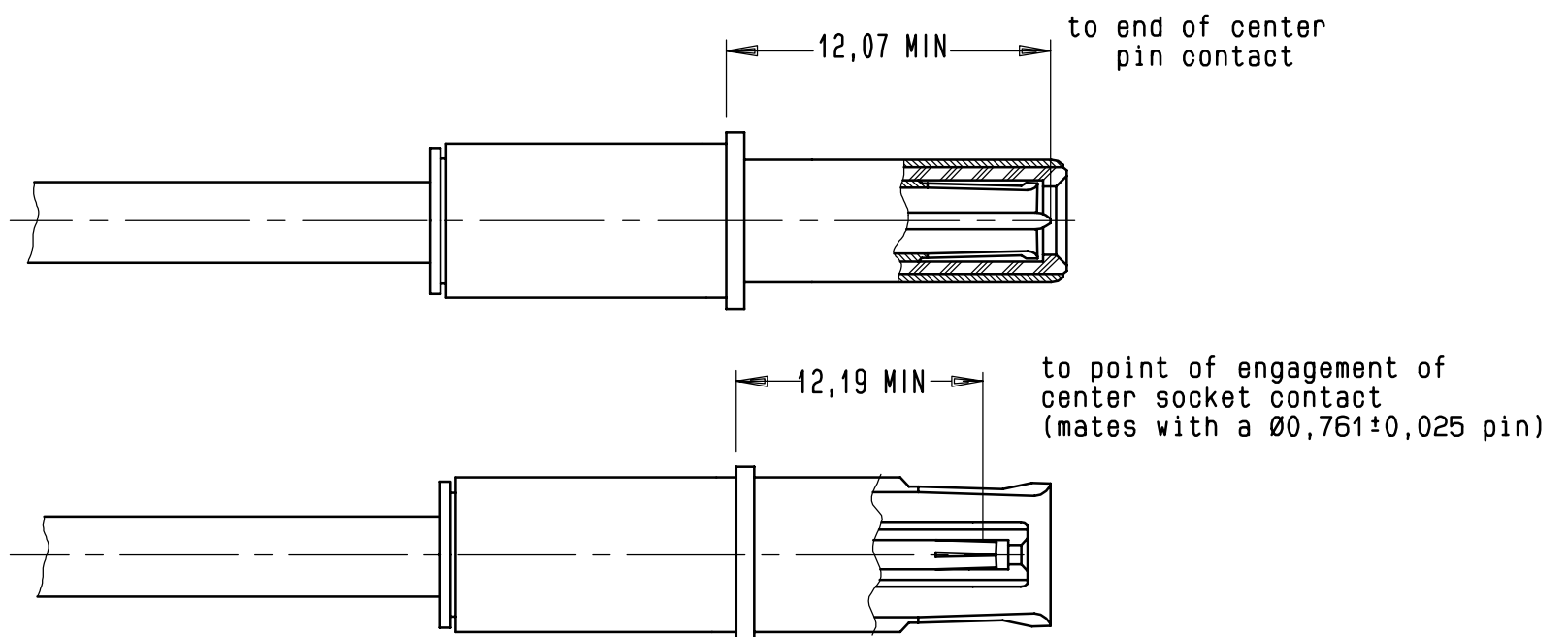
STEP 6/ PUT THE CABLE/CENTER CONTACT ASSEMBLY IN THE REAR OF THE OUTER CONTACT
CUT AROUND THE BRAID SO THAT THE BRAID IS FLUSH WITH THE SURFACE OF THE OUTER CONTACT
CRIMP THE OUTER CONTACT IN THE INDICATED CRIMPING AREA USING:

CRIMPING TOOL: M22520/5_01 (RADIALL P/N 282 293)

DIE : RADIALL P/N 282 617 003 (DANIELS Y793A modified) recommended by RADIALL
or M22520/5-104 (DANIELS Y792) according to MIL-C-39029/95 and /96, not recommended by RADIALL
or DANIELS Y793 OR Y793A, not recommended by RADIALL



STEP 7/INSPECTION DIMENSIONS AFTER CRIMPING



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