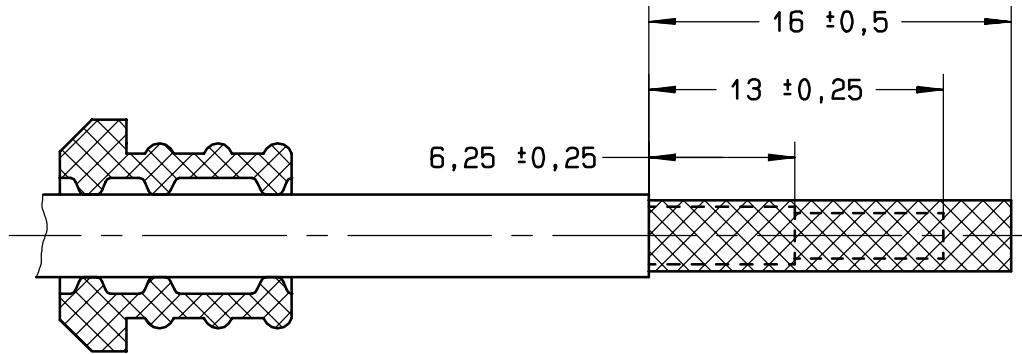


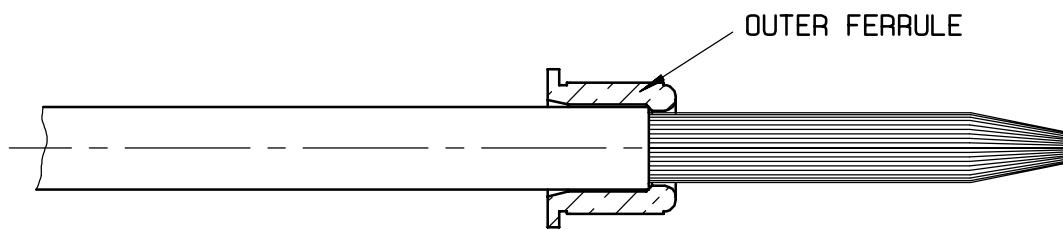


IF NECESSARY, SLIDE SEALING BOOT OVER CABLE BEFORE STRIPPING

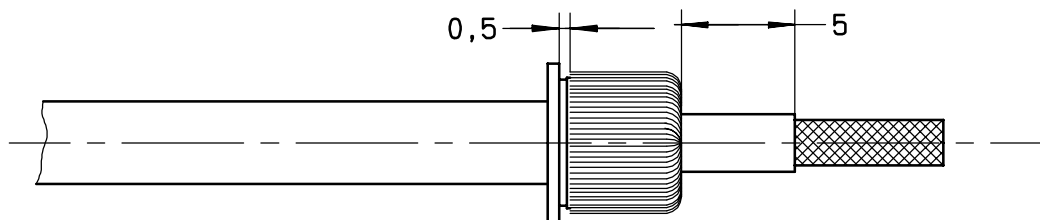
STEP 1/ TRIM CABLE OUTER JACKET TO LENGTH INDICATED
SLIDE BACK THE OUTER BRAID ENOUGH TO CUT THE INNER JACKET TO 6,25 mm AND THE INNER BRAID TO 13 mm.



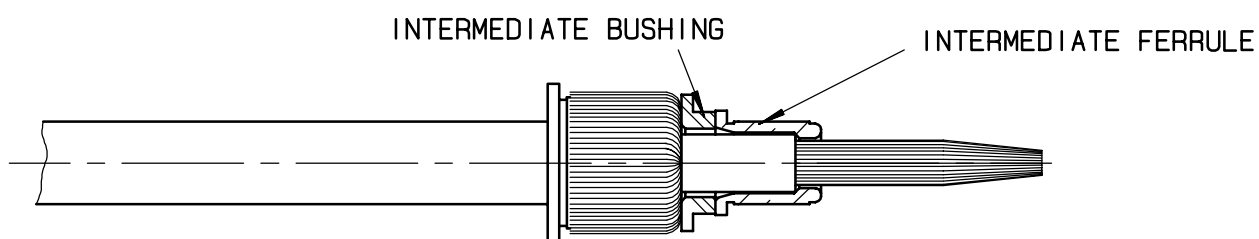
STEP 2/ COMB THE OUTER BRAID AND TWIST THE END TIGHT
SLIDE THE OUTER FERRULE OVER CABLE UNTIL THE OUTER JACKET BOTTOMS ON THE FERRULE INTERNAL SHOULDER.
CAUTION: DO NOT FOLD BACK ANY OF THE BRAID STRANDS UNDER THE FERRULE



STEP 3/ FOLD BACK THE OUTER BRAID OVER THE FERRULE AND TRIM THE END TO 0,5 DIMENSION.
ENSURE THAT ALL STRANDS ARE FOLDED BACK OVER THE FERRULE.



STEP 4/ COMB THE INNER BRAID AND TWIST THE END TIGHT
SLIDE THE INTERMEDIATE BUSHING AND THE INTERMEDIATE FERRULE OVER CABLE
UNTIL THE INNER JACKET BOTTOMS ON THE INTERMEDIATE FERRULE INTERNAL SHOULDER.
CAUTION: DO NOT FOLD BACK ANY OF THE INNER BRAID STRANDS UNDER THE FERRULE OR BUSHING.



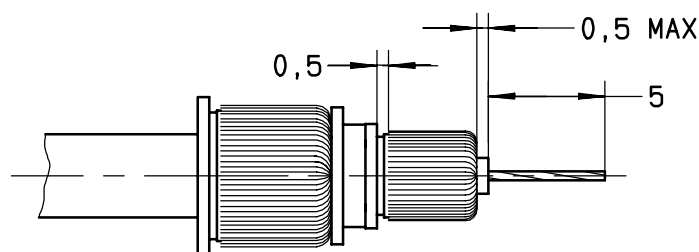
This information is given as an indication. In the continual goal to improve our products, we reserve the right to make any modifications judged necessary.

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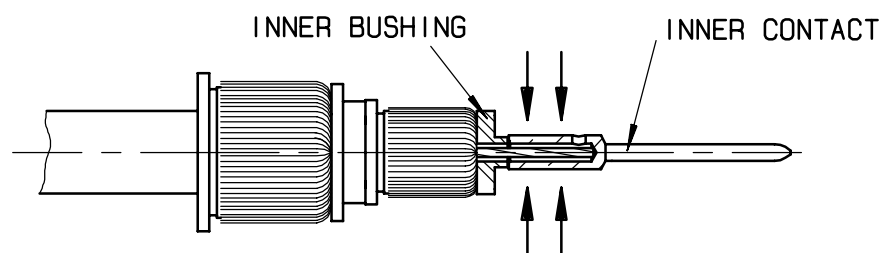
CREATION				
PEN: M990105391A				
NOM: BALDYROU				
DATE: 27 OCT.99				
APPR.: .				
Issue	Revisions	Name	Approved	



STEP 5/ FOLD THE INNER BRAID BACK OVER THE FERRULE AND TRIM THE END TO 0,5 DIMENSION.
TRIM DIELECTRIC TO LENGTH INDICATED: 0,5 MAX
CHECK THAT THE 5mm DIMENSION IS CORRECT, CROP IF NECESSARY.

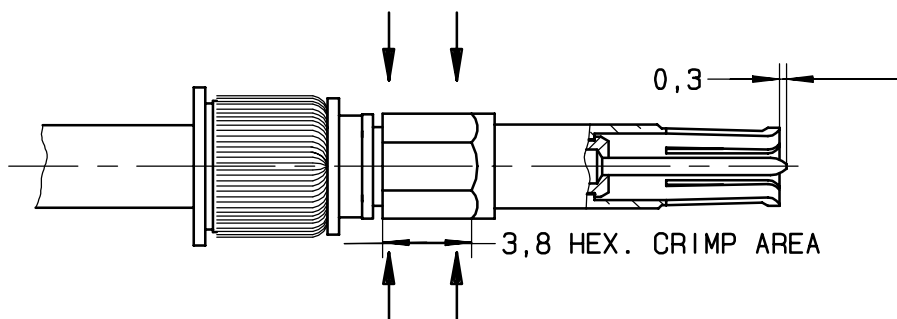


STEP 6/ SLIDE THE INNER BUSHING AND INTRODUCE THE WIRE INTO THE INNER CONTACT
CRIMP THE INNER CONTACT WITH: CRIMPING TOOL M22520/2-01 (RADIAL 282281) SELECTOR POSITION: 4
POSITIONER : 282 586 002

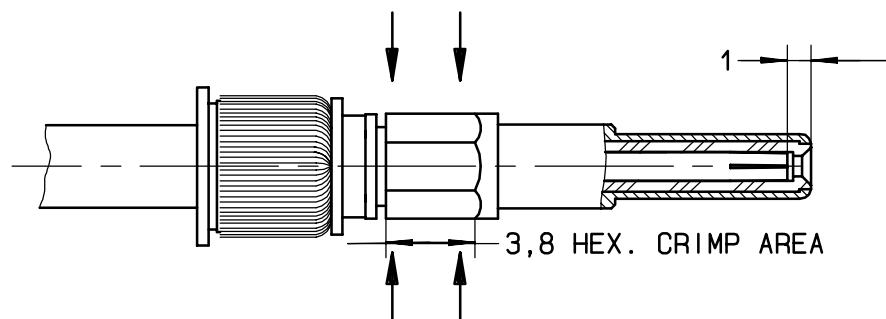


STEP 7/ PUT THE CABLE/INNER CONTACT ASSEMBLY IN THE INTERMEDIATE SUB ASSY
MAKE SURE THAT THE 0,3 OR 1mm DIMENSIONS ARE CORRECT BEFORE CRIMPING

626 170 OR 626 170 001



626 070 OR 626 070 001

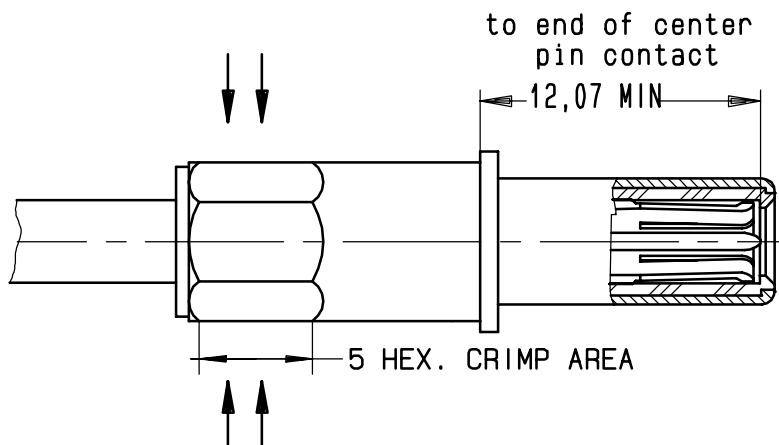


CRIMP THE INTERMEDIATE SUB ASSY WITH: CRIMPING TOOL M22520/5-01 (RADIAL 282293)
DIE : 282 617 001 HEX. B

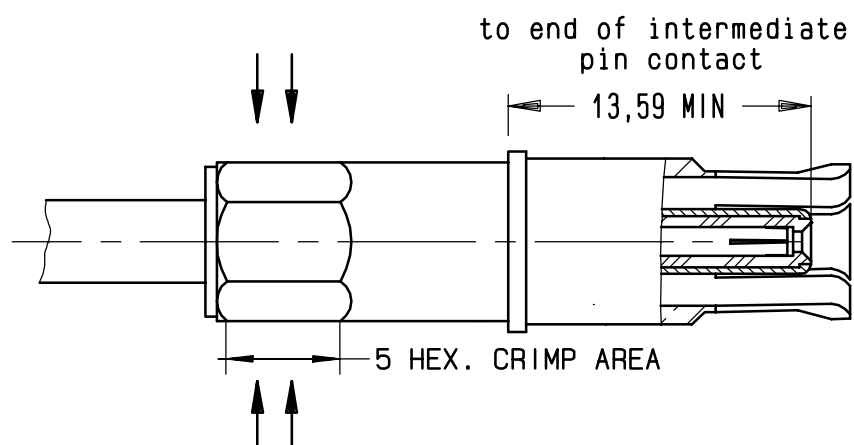
DURING THE CRIMPING OPERATION PUSH ON THE OUTER FERRULE

STEP 8/ PUT THE CABLE/INTERMEDIATE CONTACT ASSEMBLY IN THE OUTER BODY
MAKE SURE THAT THE 12,07 MIN OR 13,59 MIN DIMENSIONS ARE CORRECT BEFORE CRIMPING

626 170 OR 626 170 001



626 070 OR 626 070 001



CRIMP THE OUTER BODY WITH: CRIMPING TOOL M22520/5-01 (RADIAL 282293)
DIE : 282 617 001 HEX. A

DURING THE CRIMPING OPERATION PUSH ON THE OUTER FERRULE

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