



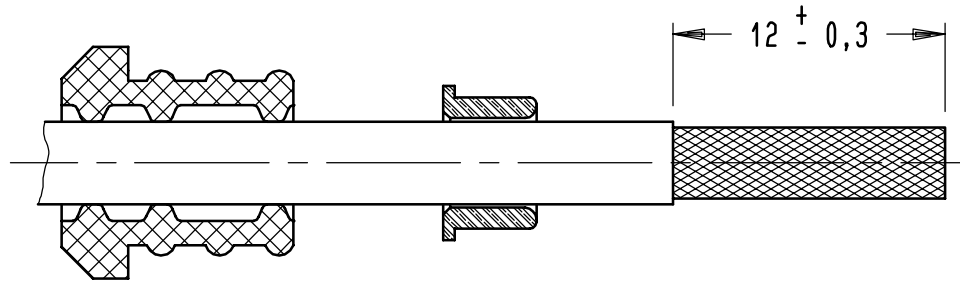
Series
TCX

SIZE 8 CONCENTRIC TWINAX CONTACTS
WIRING INSTRUCTIONS
CABLE P/N : PAN 6421 AND MIL-C-17/17600002

Issue: 18 NOVEMBER 2002
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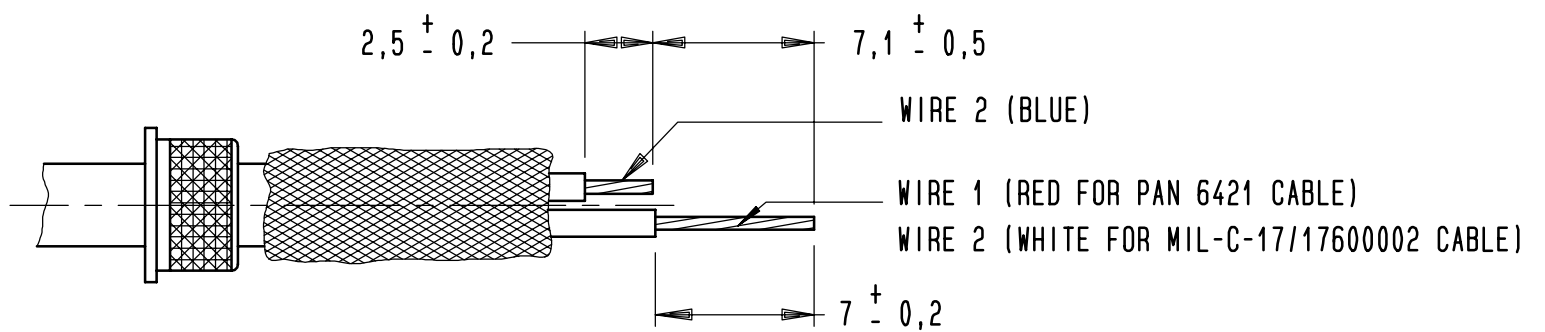
IF NECESSARY BEFORE STRIPPING, SLIDE SEALING BOOT OVER CABLE

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

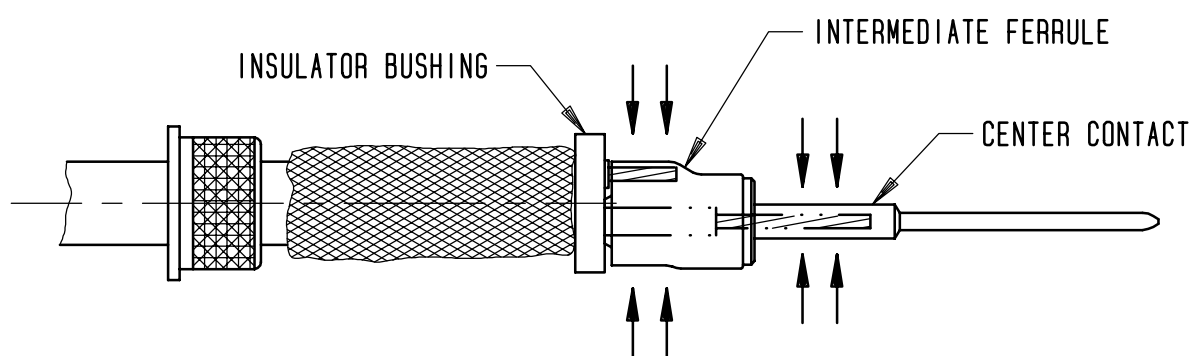


ATTENTION :
PLEASE USE ONLY CONTACTS
WHICH HAVE A BLACK MARK
ON THE INNER FERRULE

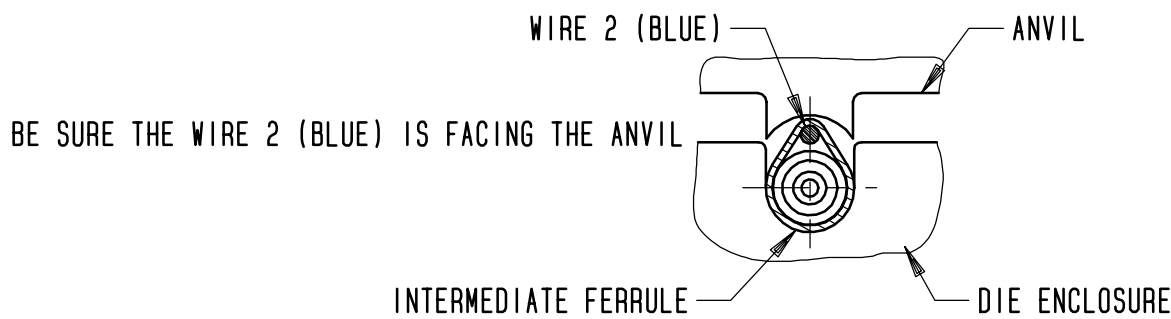
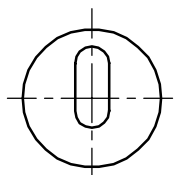
STEP 2/ PUSH THE SHIELD BRAID BACK AND OVER THE CABLE JACKET
CUT ROD FILLER
STRIP THE TWO INNER WIRES TO LENGTH INDICATED



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 (RADIAL P/N 282 293)
DIE : RADIAL P/N 282 617 003



INSULATOR BUSHING
ORIENTATION



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

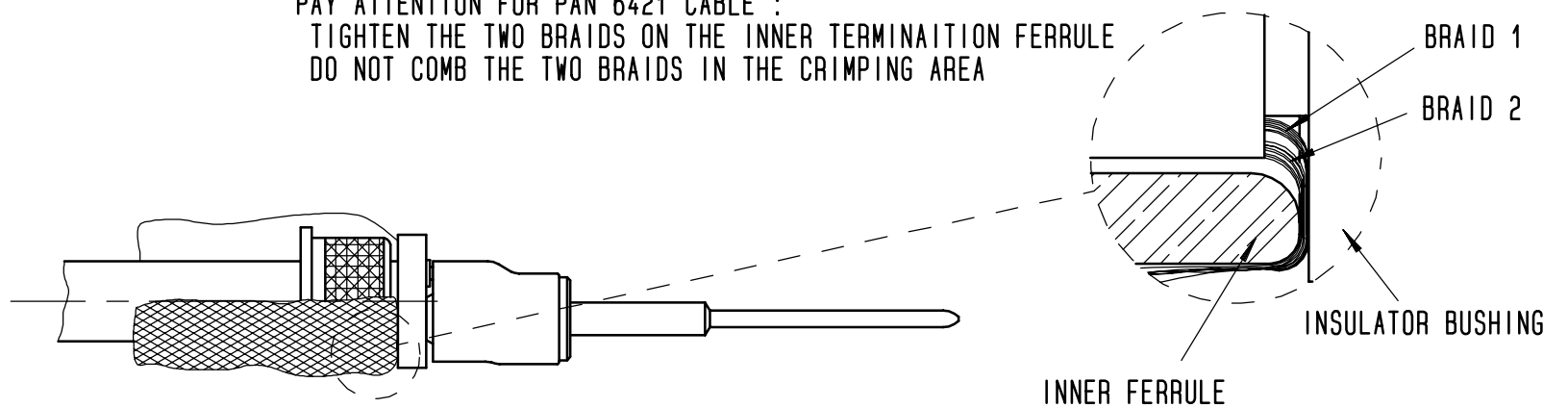
This information is given as an indication. In the continual goal to improve our products, we reserve the right to make any modifications judged necessary. 4112-9610

CREATION				
PEN: M020104819A				
NOM: DUPUIS				
DATE: 15 OCT. 02	18 NOV 02	ADDED MIL-C-17/17600002 CABLE	DUPUIS	LAHOREAU
APPR.: L. GIET	18 OCT 02	ADDED : ATTENTION USE ONLY CONTACTS...	DUPUIS	MACARI
	Issue	Revisions	Name	Approved



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

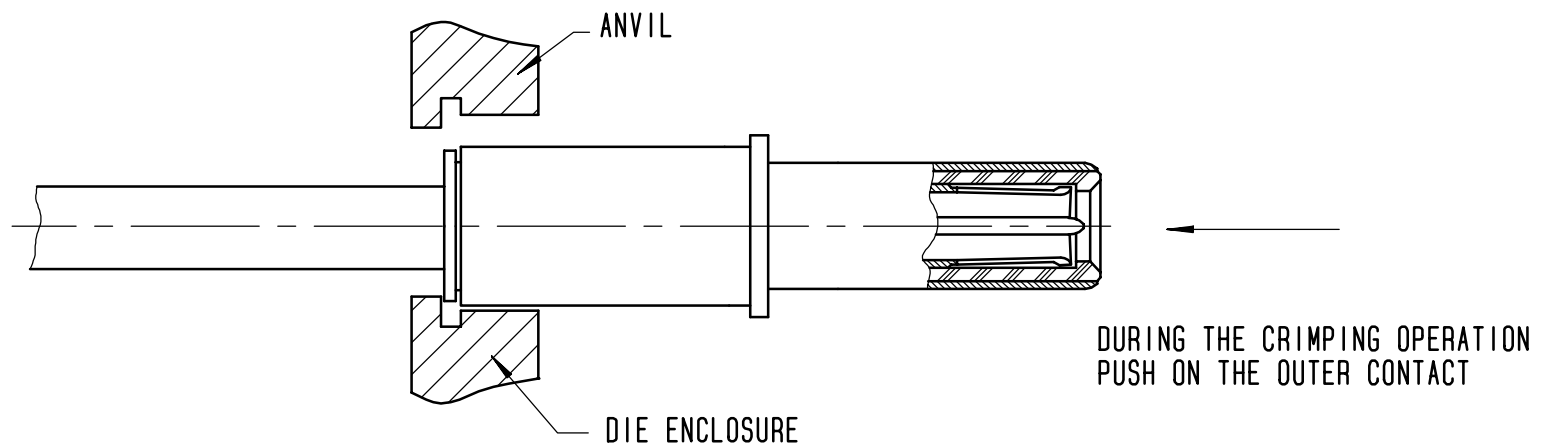
PAY ATTENTION FOR PAN 6421 CABLE :
TIGHTEN THE TWO BRAIDS ON THE INNER TERMINATION FERRULE
DO NOT COMB THE TWO BRAIDS IN THE CRIMPING AREA



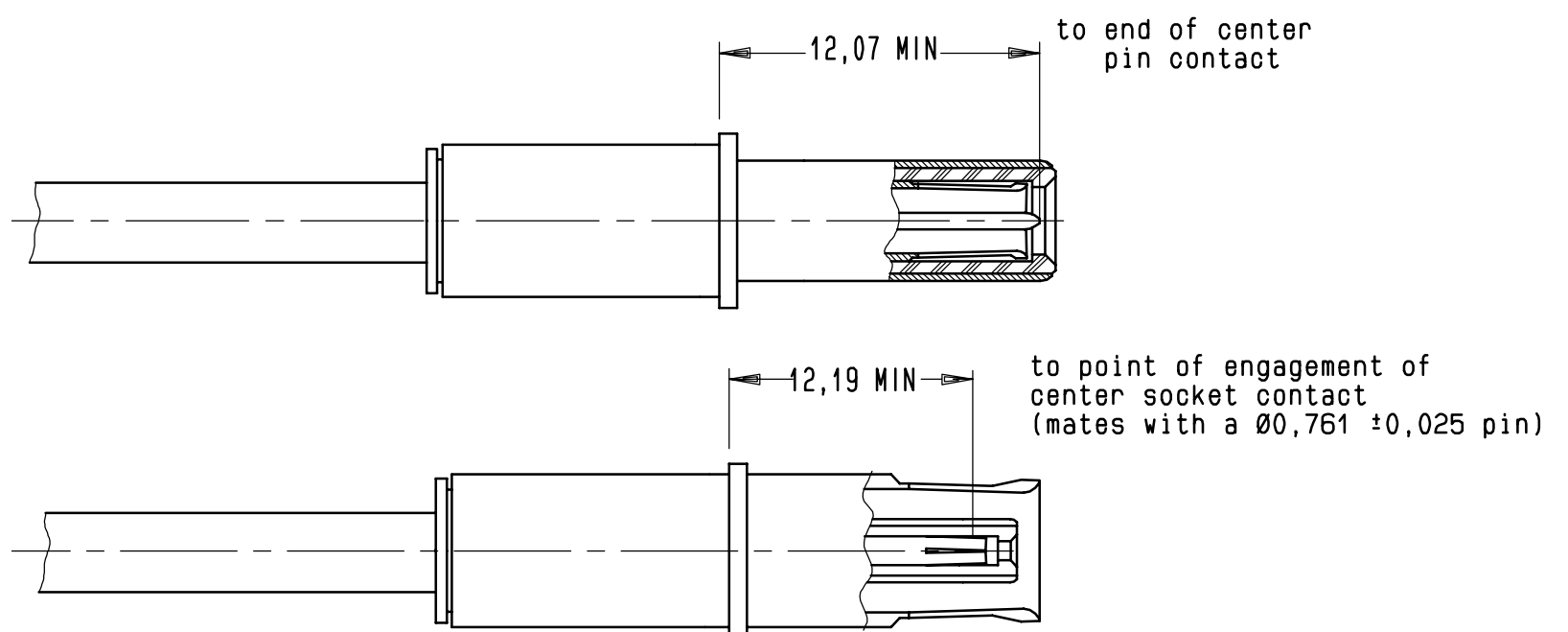
STEP 6/ PUT THE CABLE/CENTER CONTACT ASSEMBLY IN THE REAR OF THE OUTER CONTACT
CUT AROUND THE BRAID SO THAT THE BRAID IS FLUSH WITH THE SURFACE OF THE OUTER CONTACT
CRIMP THE OUTER CONTACT IN THE INDICATED CRIMPING AREA USING:

CRIMPING TOOL: M22520/5 01 (RADIALl P/N 282 293)

DIE : RADIALl P/N 282 617 003



STEP 7/INSPECTION DIMENSIONS AFTER CRIMPING



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