

# WIRING ASSEMBLY INSTRUCTIONS

## 0884010-13 (JOY-014)

### Tool Setup:

Use Crimp Tool P/N 452300, along with P/N 452309 Hex Die Set. Install P/N 452309 Hex Die Set onto P/N 452300 Crimp Tool.

### Backgage Setup:

Assemble Backgage using supplied screw so that "R" is in the position shown, Figure A and B.

### Crimping Process:

1. Prepare Cable as shown in Figure C.
2. Slide Crimp Ring over Cable.
3. Pull Shielding fully back over Cable Outer Covering.
4. When using JOY-014, slide Teflon Tubing onto Cable Wire Dielectric before soldering Cable Inner Wire.
5. Insert Cable Inner Wire into Center Conductor and solder in place.
6. Insert Dielectric fully into Outer Shield (if not previously assembled).
7. Slide Outer Shield/Dielectric sub-assembly as created in Step 6 onto Center Conductor/Cable sub-assembly as created in Step 5, until fully seated. Dielectric Tip should be approximately 0.035" below the Front Edge of the Outer Shield.  
Center Conductor should be approximately 0.040/0.080" below the tip of Outer Shield.
8. Slide Crimp Ring over Braid and crimp using Tool Body P/N 452300 with Hex Die Set P/N 452309 installed. Use the largest Hex (A) for the large diameter on the Crimp Ring. Use Hex (C) on the small diameter of the Crimp Ring.

Figure B

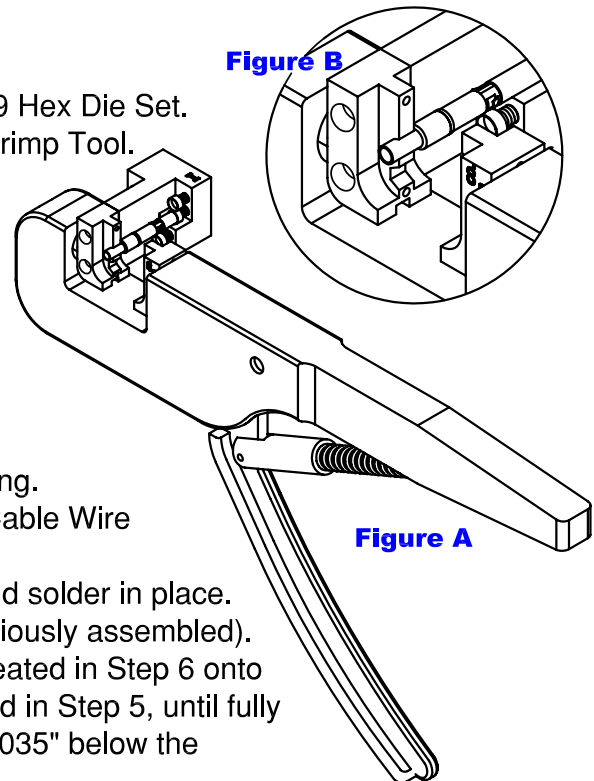


Figure A

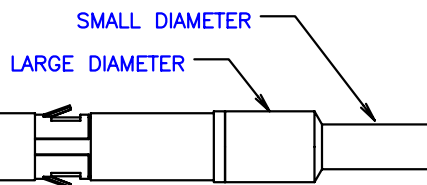


Figure C

