

Wiring Assembly Instructions

40-120001-02 (JOY 014) CTI

40-120001-03 (RG 178, JOY 05, JOY 06 & JOY 018) CTI

561201 - Contact, Receiver, Micro Coax, DC-2 GHz, Joy 05 Cable

Tool Setup

Use Crimp Tool P/N 452300, along with P/N 452315 Hex Die Set.
Install P/N 452315 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. Cut 0.095 off wire Dielectric, leaving 0.095 of Inner Wire exposed as shown in Fig. D.
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. Center Conductor should be approximately 0.009/0.024" below the tip of Outer Shield.
8. Brush Shielding forward over Outer Shield.
9. Slide Crimp Ring over Braid and crimp using Tool Body P/N 452300 with Hex Die Set P/N 452315 installed. Use the largest Hex (A) for the large diameter on the Crimp Ring. Use the Hex (B) for the small diameter on the Crimp Ring for the 40-120001-03 (RG 178, JOY 05, JOY06 & JOY 018) contact. Use Hex (C) for the 40-120001-02 (JOY 014) contact.
10. Quality Assurance requirements for pull test is: RG 178, JOY 05, JOY06 & JOY 018 - 8 lbs., JOY 014 - 2lbs.

