

# Wiring Assembly Instructions

## Micro Coax ITA Contacts 40-220001-02 (JOY 014) CTI 40-220001-03 (RG 178, JOY 05, JOY 06 & JOY 018) CTI

### 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 "I" is in the position shown in Figure A.

### Crimping Process

1. Prepare cable as shown in figure C.
2. Slide crimp ring over the cable outer jacket.
3. Pull wire braid back over the cable outer jacket.
4. Cut the cable dielectric back .095", exposing the cable center conductor as shown in figure D.
5. Insert cable center conductor into the contact center conductor and solder in place.
6. Insert contact dielectric fully into the contact outer shield with the smaller ID towards the crimp ring, if not previously assembled.
7. Slide outer shield/dielectric subassembly onto center conductor/cable subassembly until fully seated. The center conductor must be between .009-.024" below the tip of the outer shield.
8. Brush wire braid forward over outer shield.
9. Slide crimp ring over the wire braid and crimp using tool body P/N 452300 and hex die set P/N 452315. Crimp the large crimp ring diameter with position A. Crimp the small crimp ring diameter with position B for contact P/N 40-220001-03 (RG178, JOY05, JOY06 and JOY018 cable). Crimp the small crimp ring diameter with position C for contact P/N 40-220001-02 (JOY014 cable).

**Note:** It is permissible to crimp the smaller diameter first and then the larger diameter of the crimp ring to prevent center conductor pull back. Additionally, pressure should be applied to the cable while crimping to further prevent the center conductor from pulling back.

10. Pull test requirements: P/N 40-220001-03 (RG178, JOY05, JOY06 and JOY018) – 8 lbs., P/N 40-220001-02 (JOY014) – 2 lbs.

