



Wiring Assembly Instructions

**0884010-07 Contact, Receiver, Mini – Coax, RG316DS.**



**Fig. A.** (Contact Sub-Assembly)



Contact Sub-Assembly Piece Parts.

**Contact Crimp Information Table**

Wire Type	Wire Awg.	Strip Length In Inches	Crimp Tool	Hex Die Set	Indicator	Selector No.	Heat-shrink Length X Dia.
DBL SHLD RG316	26	A) 11/64" B) 1/4" C) 27/64	452300	452309	R	N/A	5/8 X 3/16

**Test Requirements**

Test Type	Voltage (Hi-pot Only)	Pull Test	Depth Gauge	Marker Settings
Hi-pot	500V DC	3lbs	412657	20 - 60

**NOTE 1:** Refer to **IPC/WHMA-A-620A** standard (Ch. 11.1.2) for cable lengths, measurements and tolerance.

**NOTE 2:** Overall length of cable should be less 3/8" to compensate for the contact attachment.

**STEP 1)** From the "Contact Crimp Information" Table, use the crimp tool and hex die set listed.

**STEP 2)** Ensure hex die, is set to correct indicator as listed in "Contact Crimp Information" Table.

**NOTE:** Refer to **Fig. B** for reference.

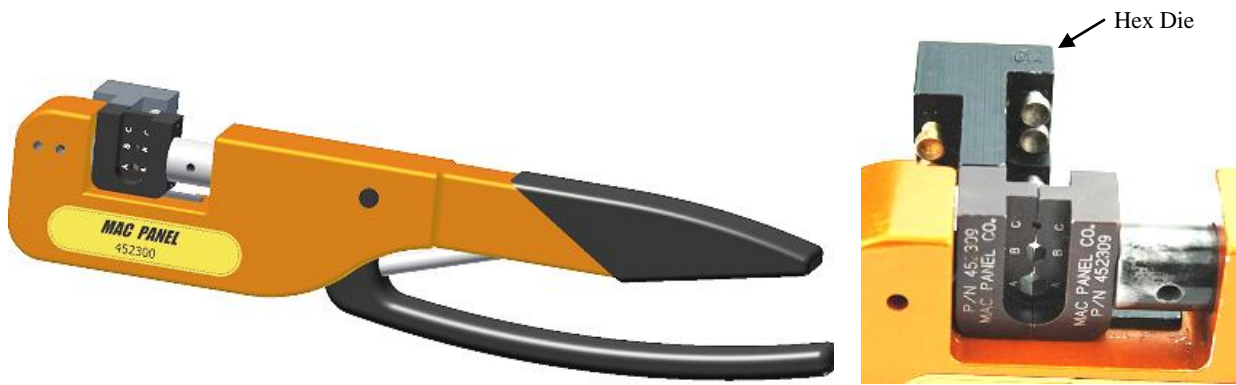


Fig. B.

Detail A.

**STEP 3)** Using a ruler along with wire strippers or automatic wire stripping machine, strip the cable to the dimensions in the "Strip Length" column. Example of stripped wire shown below in Fig. C



Fig. C.

**STEP 4)** Tin center pin and center wire. Insert cable center wire into center conductor and solder in place. Fig. D and E



Fig. D.



Fig. E.

**STEP 5)** Ensure dielectric is fully seated in shell. Slide shell assembly onto center conductor/cable sub-assembly until fully seated as shown in Fig. F.



Fig. F.

**STEP 6)** Evenly form shielding over contact as shown in Fig. G.



Fig. G.

**STEP 7)** Slide crimp ring over shield and up to contact until firmly seated in Fig. H.



Fig. H.

**STEP 8)** Inspect contact/cable assembly using depth gauge listed in "Test Requirements" Table. Fig. J.

**NOTE:** Calibrate gauge using reference sheet IN 412657 (Instructions for calibrating Depth Gauge) before using.

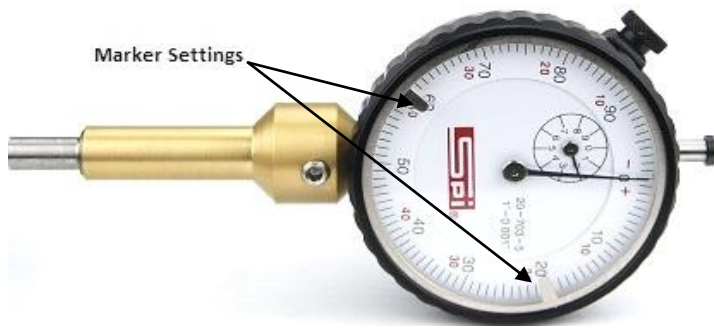


Fig. K.

**STEP 11)** Test contact by inserting contact/cable assembly fully into test gauge, until seated firmly. **Fig. L.**

**STEP 12)** Gently tap top of pin gauge to ensure that gauge is seated fully to bottom of center contact pin.

**STEP 13)** Hold contact/cable assembly, and test gauge firmly, proceed to take measurement. **Fig. M**



Fig. L.

**STEP 14)** Results should be between the "Marker Settings". Listed on the "Test Requirements" Table.

**NOTE:** Do not proceed to step 15 if results are unacceptable.(Repeat steps 3 through 13).

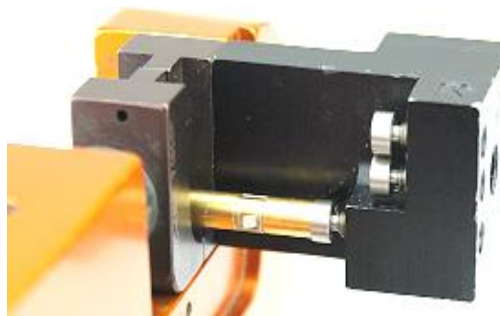
**STEP 15)** Use crimp tool, and crimp large diameter of crimp ring in location **(A)** of hex die **Fig. M.**

**STEP 16)** Crimp small diameter of crimp ring in location **(B)** of hex die. **Fig. N.**

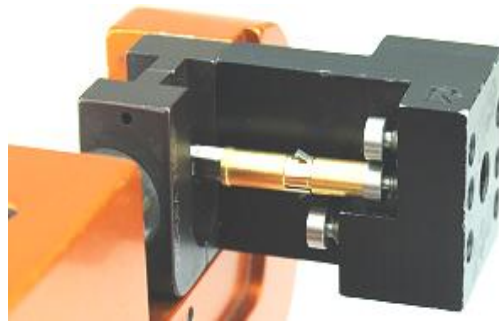
**NOTE:** Make sure the contact seats properly in the stops aligned with locations on hex die **Figs. M** and **N** details.



Fig. M. (Front View)



Detail (Back View)

**Fig. N. (Front View)****Detail (Back View)**

**STEP 17)** Perform a "pull and return test" as per **IPC/WHMA-A-620A** standard (Ch. 19.7.2.1) utilizing a pull force of 3lbs.

**STEP 18)** Gauge crimped contact/cable assembly again using the depth gauge (steps 10 to 16). The reading should still be within range.

**STEP 19)** Perform a "Hi-pot" test to the settings listed in "Test requirements". If a "pass" test occurs proceed to next step.

**STEP 20)** Shrink heat-shrink onto crimp ring, to match the image below in **Fig. P**, to complete cable assembly.

**Fig. P.**

**NOTE:** Shrink-tube is to provide strain-relief.