



Wiring Assembly Instructions

40-220001-03 Contact, ITA, Micro Coax.

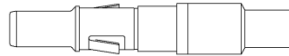
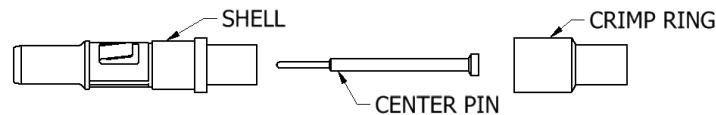


Fig. A. (Contact Sub-Assembly)



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.
JOY 05/ 06/18 RG178	26	A) 1/32" B)5/32" C)3/16" D)3/32"	452300	452315	I	N/A	5/8" x 1/4"

Test Requirements

Test Type	Voltage (Hi-pot Only)	Pull Test	Depth Gauge	Marker Settings
Hi-pot	500V DC	3lbs	412653	76 – 91

NOTE: 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.

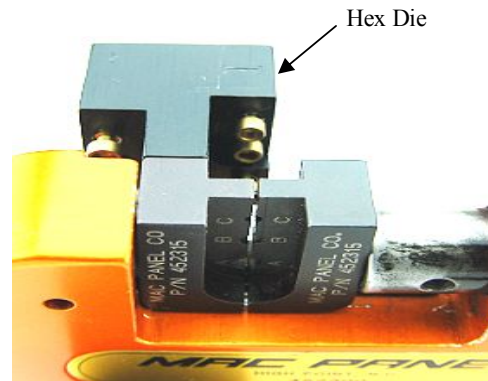
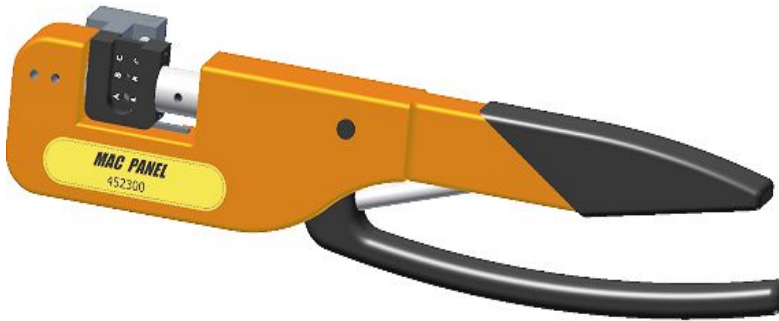


Fig. B. (452300)

Detail A. (452315)

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.**

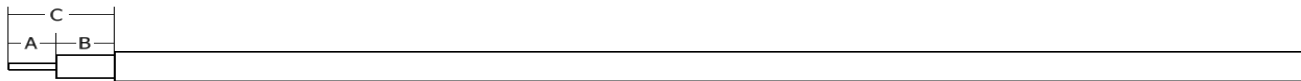


Fig. C.

STEP 4) Slide heat-shrink and crimp ring over cable. Pull shield back over the cable outer jacket as shown below in **Fig. D.**

NOTE: Ensure that no strand of Center Conductor contacts the shield to prevent shorts.

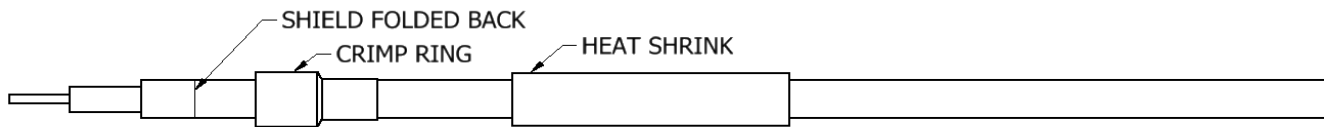


Fig. D.

STEP 5) Trim the Dielectric to achieve dimension "D" in the "Strip Length" column on "Crimp Information" Table. See **Fig. E.**

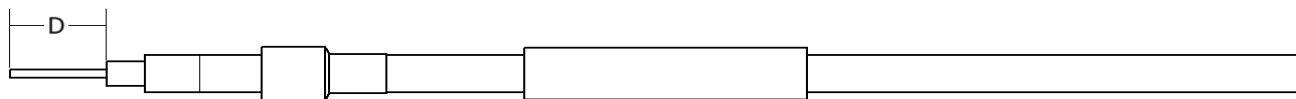


Fig. E.

STEP 6) Tin center pin and center wire. Insert cable center wire into center conductor and solder in place. **Fig. F. and G.**

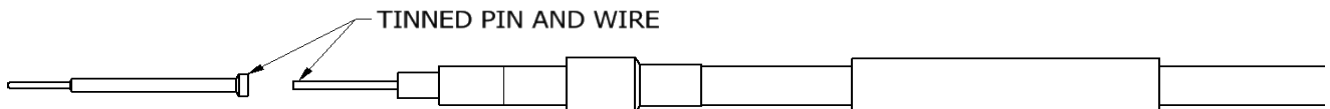


Fig. F.

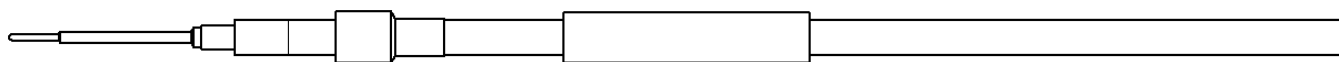
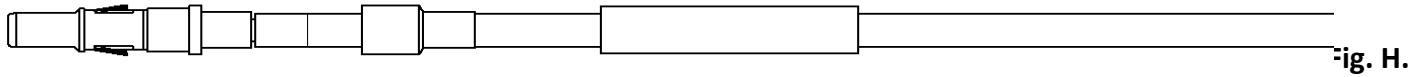
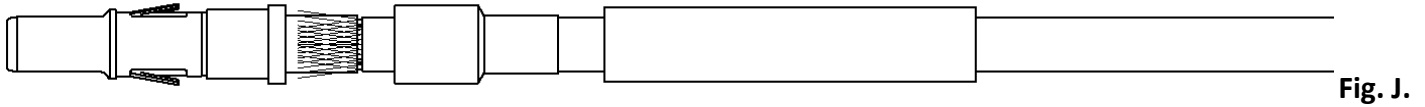


Fig. G.

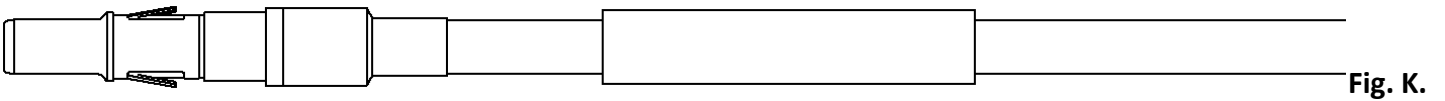
STEP 7) Ensure dielectric is fully seated in shell. Slide shell assembly onto center conductor/cable sub-assembly until fully seated as shown in **Fig. H.**



STEP 8) Evenly form shielding over Shell as shown in **Fig. J.**



STEP 9) Slide crimp ring over shield and up to contact until firmly seated in **Fig. K**

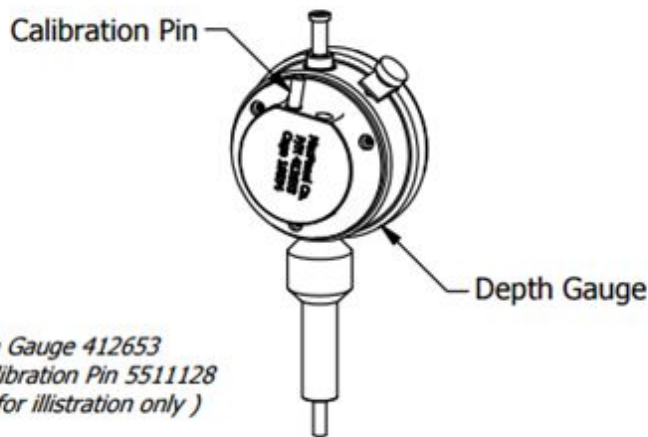


STEP 10) Inspect contact/cable assembly using depth gauge listed in "Test Requirements" Table. Calibrate gauge using instructions below prior to inspection.

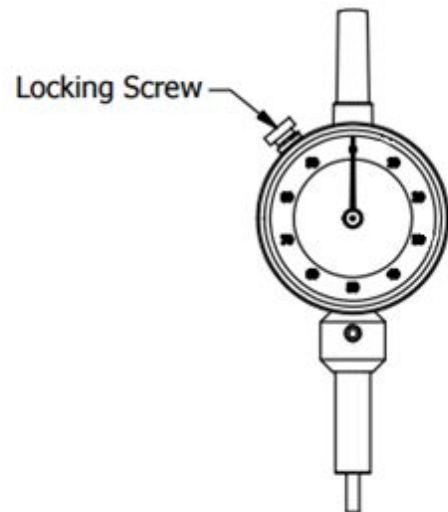
Contact and Calibration equipment			
Contact	Depth Gauge	Calibration Pin	Marker Settings
40-220001-03	412653	551128	76 - 91

Step 1) Remove Calibration Pin from back of the Depth Gauge.

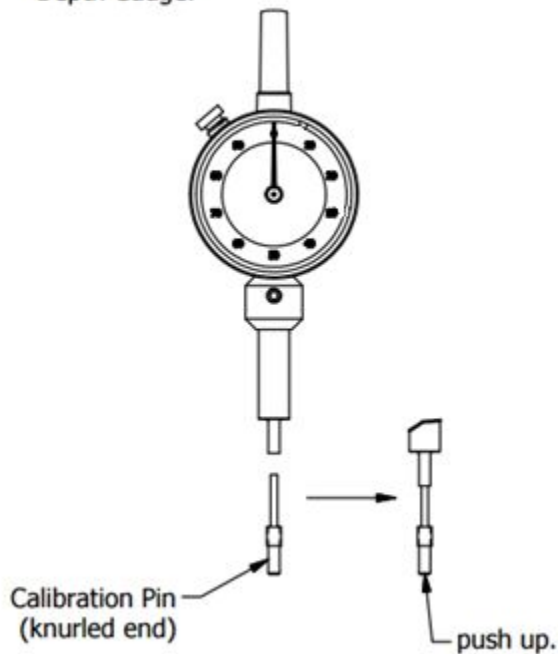
Step 2) Loosen Locking Screw on Depth Gauge body.



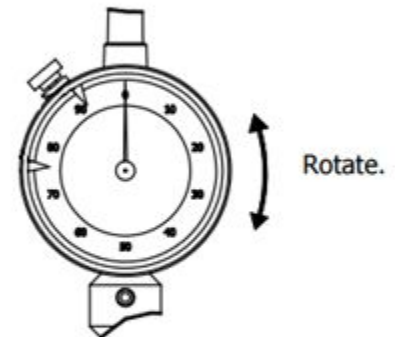
(Depth Gauge 412653 and Calibration Pin 551128 shown for illustration only)



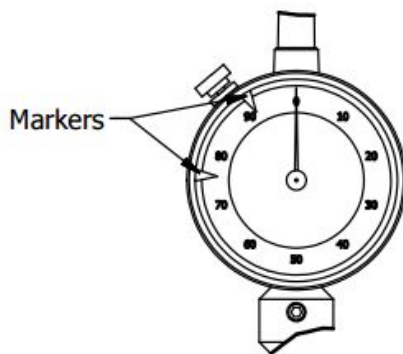
Step 3) Insert the non - knurled end of the Calibration Pin into the end of the Depth Gauge.



Step 4) With the Calibration Pin firmly seated, Rotate the Depth Gauge bezel until the needle reads " 0 ". Re-tighten the locking screw.



Step 5) With the Calibration Pin still firmly seated, rotate the two markers to the numbers specified in the table on Sheet 1.



Step 6) Remove the Calibration Pin and return to the body of the Depth Gauge for future use.

Your Depth Gauge is now properly calibrated and ready to check the appropriate contact.

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

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 as per **Fig. M**.

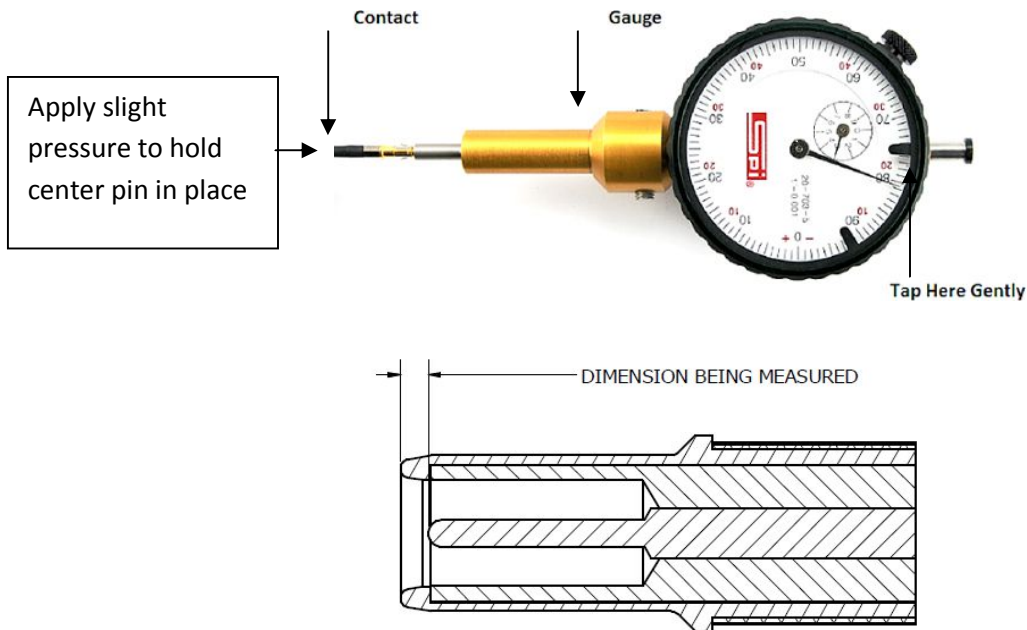


Fig. M

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. N**.

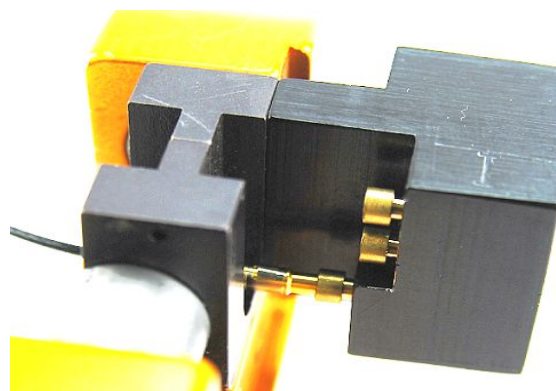
NOTE: Keep steady pressure on wire during crimping to maintain position of center conductor.

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

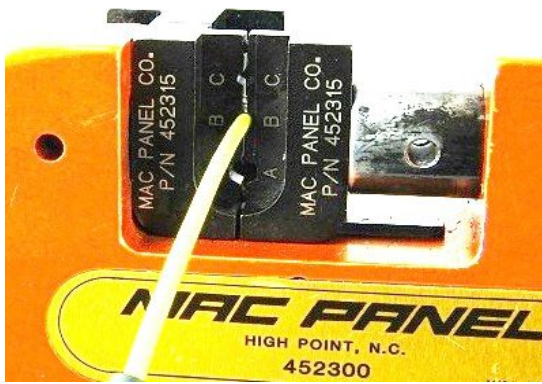
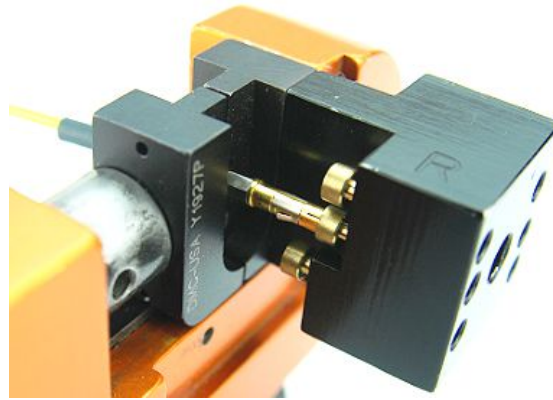
NOTE: Make sure the contact seats properly in the stops aligned with locations on hex die **Figs. N. and P** details.



Fig. N. (Front View)



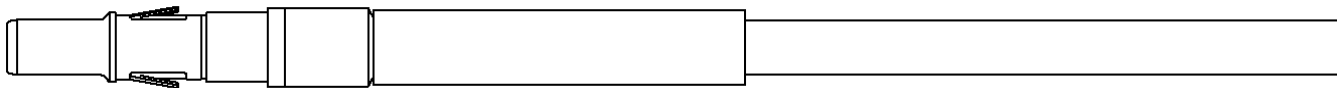
Detail A. (Back View)

**Fig. P. (Front View)****Detail A. (Back View)**

STEP 17) Gauge crimped contact/cable assembly again using the depth gauge (steps 10 to 14). The reading should still be within range.

STEP 18) Perform a "Hi-pot" test to the settings listed in "Test requirements". If a "pass" test occurs proceed to next step.

STEP 19) Shrink heat-shrink onto crimp ring, to match the image below in **Fig. R**, to complete cable assembly.

**Fig. R.**

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