

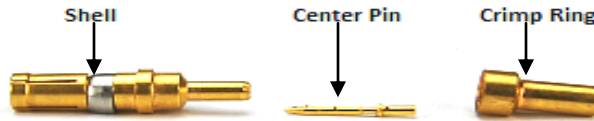


Wiring Assembly Instructions

**7865100-03 Contact, Receiver, Coax, 75 Ohm, RG 179.**



**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.
RG 179	30	A) 7/64" B)11/64" C) 33/64"	*452300 **452200/M	452301 452212	N/A	C 4	5/8" x 1/4"

**NOTES: \* For Center Pin Crimping (Step 5). \*\* For Shield Crimping (Step 9).**

Test Requirements				
Test Type	Voltage (Hi-pot Only)	Pull Test	Depth Gauge	Marker Settings
Hi-pot	500V DC	1.5lbs	N/A	N/A

**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 the selector is set to correct number as listed in "Contact Crimp Information" Table.



**Fig. B. (Crimp Tool 452200/M)**



**Detail A. (Positioner and Crimp Tool)**

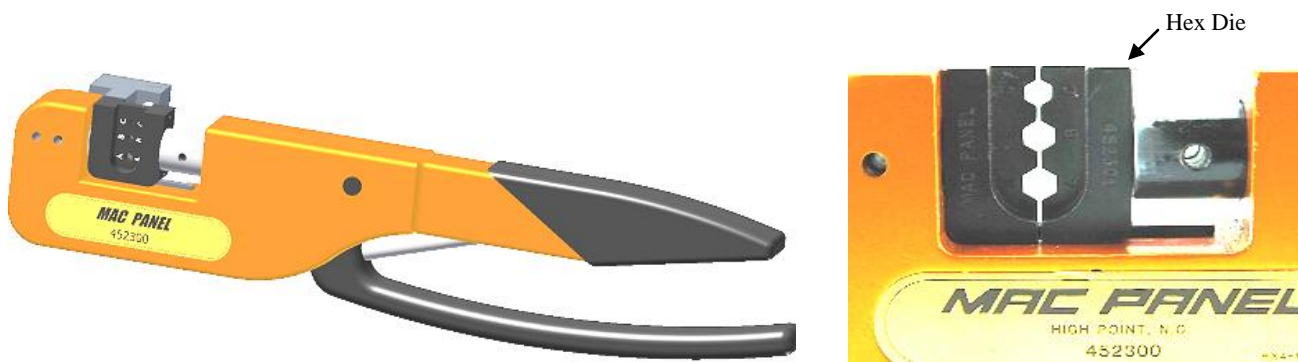


Fig. C. (452300)

Detail A. (452301)

**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. D.



Fig. D.

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

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



Fig. E.

**STEP 5)** Crimp Center Pin onto wire using Tool 452200/M and 452212 Positioner Fig. F.



Fig. F.

**STEP 6)** Install Shell over crimped Center Pin. Fig. G.



Fig. G.

**STEP 7)** Evenly form shielding over Shell as shown in Fig. H.



Fig. H.

**STEP 8)** Slide Crimp Ring over evenly formed shielding over Shell as shown in Fig. J



Fig. J.

**STEP 9)** Use crimp tool 452300 and Hex die 452301 to crimp smaller diameter of Crimp Ring in location (C) of hex die, Fig. K and L.



Fig. K.



Fig. L.

**STEP 10)** Shrink heat-shrink onto Crimp Ring for strain relief to match the image below in **Fig. M**, to complete cable assembly.



Fig. M.

**NOTE:** Shrink-tube is to provide strain-relief and exposed solder joint.