



Wiring Assembly Instructions

7865100-04 Contact, Receiver, Coax, 50 Ohm, RG142.



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 142	18	A) 3/32" B) 23/64" C) 21/32"	452300	452308	N/A	N/A	1/4" x 1/4"

Test Requirements				
Test Type	Voltage (Hi-pot Only)	Pull Test	Depth Gauge	Marker Settings
Hi-pot	500V DC	20lbs	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.

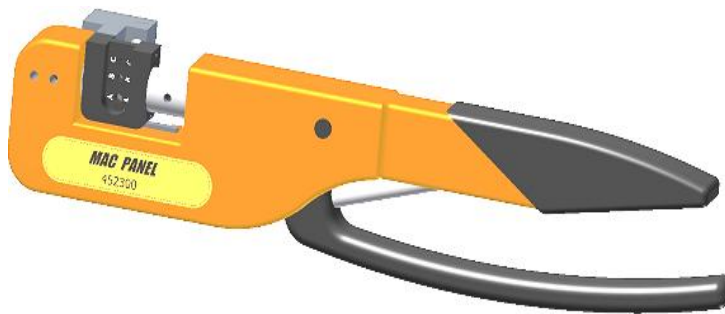
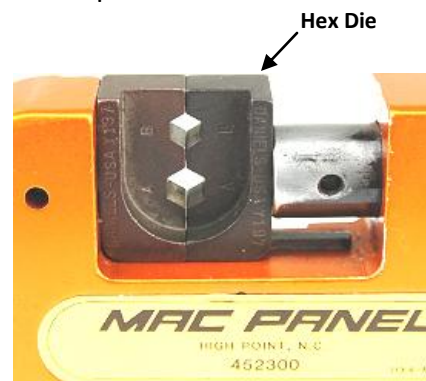


Fig. B. (452300)



Detail A. (452308)

**STEP 2)** 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 3)** 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 4)** Install Shell over Teflon. Make sure it is butted against Shielding. **Fig. E**.



Fig. E.

**STEP 5)** Install Shell onto Crimp Nut by screwing and finger tight. **Fig. F**.



Fig. F.

**STEP 6)** Pull forward and form shielding evenly over Shell as shown in **Fig. G**.



Fig. G.

**STEP 7)** Slide Crimp Ring over evenly formed shielding over Shell as shown in **Fig. H**.



Fig. H.

**STEP 8)** Use crimp tool **452300** and Hex die **452308** to crimp "Crimp Ring" in location **(A)** of hex die. **Fig. J.** and **K**.



Fig. J.



Fig. K.

**STEP 9)** Apply heat-shrink onto crimped assembly for strain relief to match the image below in **Fig. L**, to complete cable assembly.



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