

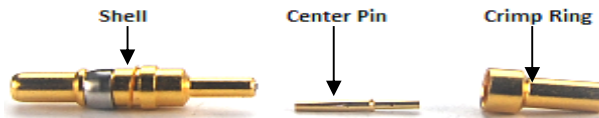


Wiring Assembly Instructions

7865200-03 Contact, ITA, 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 N/A	C 2	5/8" x 1/4"

NOTES: * For Shield Crimping (Step 5). ** For Center Pin 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 M452200/M)



Detail A. (Positioner and Crimp Tool)

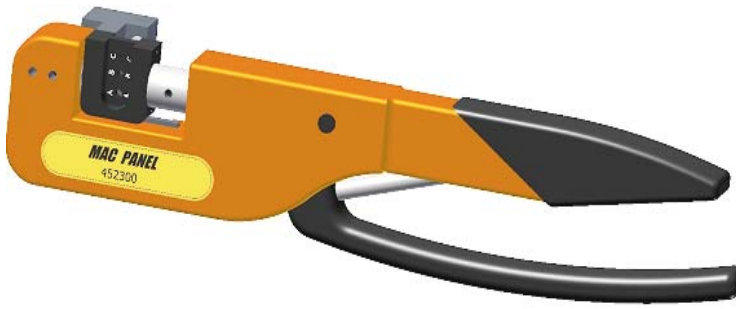


Fig. C. (452300)

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.