



Wiring Assembly Instructions

7865200-04 Contact, ITA, Coax, 50 Ohm, RG 142.



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) 5/16" C) 21/32"	452300	452308	N/A	A	5/8" 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.

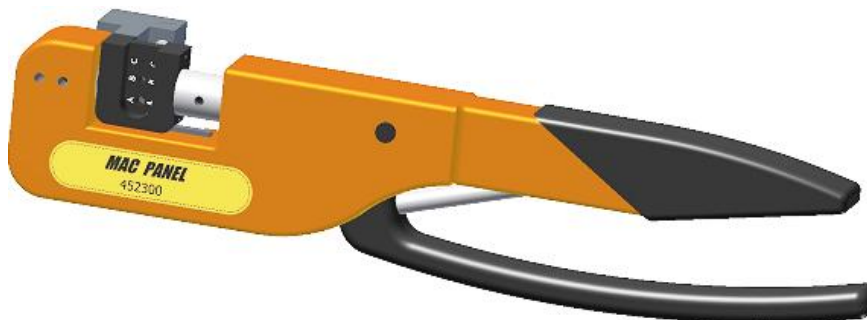


Fig. B. (452300)



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.



Fig. L.

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