

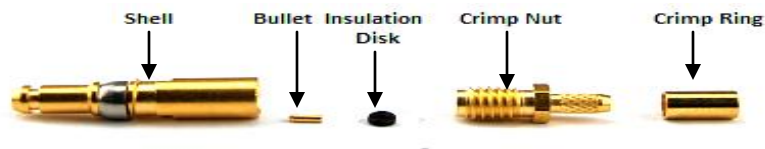


Wiring Assembly Instructions

7865200 - Contact, ITA, Coax, 50 Ohm, RG316.



Fig. A. (Contact Sub-Assembly)



Contact Sub-Assembly Piece Parts. (Insulator painted black for identification only)

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 316	26	A) 3/32" B)23/64" C) 21/32"	452300	452303	N/A	B	5/8" x 1/4"

Test Requirements

Test Type	Voltage (Hi-pot Only)	Pull Test	Depth Gauge	Marker Settings
Hi-pot	500V DC	3lbs	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 hex die, is set to correct indicator as listed in "Contact Crimp Information" Table.

NOTE: Refer to **Fig. B** for reference.

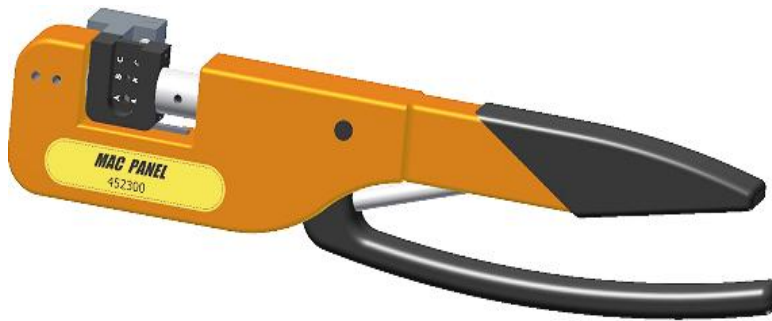


Fig. B. (452300)

Detail A. (452303)

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) Tin Bullet and center wire. Slide Crimp Nut over Cable dielectric making sure the Crimp Nut is flush with dielectric and seated against shield. Fig. E. and F.



Fig. E.



Fig. F.

STEP 6) Place cable in a holding fixture and place Insulator Disk over Center Conductor, seating it firmly against the Crimp Nut. Solder Bullet in place making sure the Bullet is flush with Insulation Disk as shown in Fig. G.

NOTE: Inspect Bullet to ensure no solder is visible. Check for retention of Bullet and solder joint.



Fig. G.

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



Fig. H.

STEP 8) Screw Shell onto Crimp Nut and finger tight until firmly seated and slide Crimp Ring over evenly formed Shield over Crimp Nut and wrench tighten to 7lbs of torque as in **Fig. J**.



Fig. J.

STEP 9) Use crimp tool and crimp "Crimp Ring" in location **(B)** of hex die **Fig. K**.

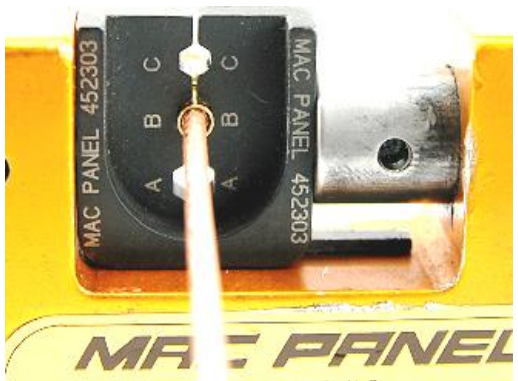


Fig. K.

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



Fig. R.

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