Wiring Assembly Instructions

Crimp Tool Assembly.

Step 1

From the "Crimp Information" table below, select the correct Crimp Tool and Hex Die for the contact you are using.

<table>
<thead>
<tr>
<th>Contact P/N</th>
<th>Wire Type</th>
<th>Crimp Tool</th>
<th>Hex Die</th>
<th>Letter in view</th>
<th>Large Crimp</th>
<th>Small Crimp</th>
</tr>
</thead>
<tbody>
<tr>
<td>40-120001-02</td>
<td>JOY 014</td>
<td>452300</td>
<td>452315</td>
<td>R</td>
<td>A</td>
<td>C</td>
</tr>
<tr>
<td>40-120001-03</td>
<td>RG178, JOY 05, 06 &amp; 018</td>
<td>452300</td>
<td>452315</td>
<td>R</td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>561201</td>
<td>JOY 05</td>
<td>452300</td>
<td>452315</td>
<td>R</td>
<td>A</td>
<td>B</td>
</tr>
</tbody>
</table>

Step 2

Attach the Hex Die to the Crimp Tool with the appropriate "letter in view" on the top face.

The crimp tool will automatically re-open the hex die when the handles are fully closed.

Your crimp tool is now ready to crimp the contacts when they have bee fully assembled.

See the following page for the correct contact assembly procedure.
Contact Assembly Procedure.

1) Using appropriate tooling for your cable type, Strip one end to the dimensions shown below.

- Centre Conductor and Dielectric
  - 1.52 mm [ .060 in ]
  - 3.56 mm [ .140 in ]

- Outer Braid

2) Slide crimp ring over cable, Pull outer braid back over cable covering.

- Centre Conductor
- Outer Braid
- Crimp Ring

3) Strip 2.4 mm [ .095 in ] from dielectric leaving centre conductor exposed.

- Centre Conductor
- Dielectric

4) Solder the centre conductor into the contact centre pin.

- Centre pin.

5) Ensure Contact Dielectric is pushed firmly into the contact outer shield.

- Contact outer shield.
- Contact Dielectric

6) Push the centre pin and cable assembly fully inside the contact dielectric.

7) Ensure outer cable braid is folded over contact body.

8) Push crimp ring over contact body and crimp large and small crimp zones using A, B or C part of Hex Die. Correct letters for the contact you are using can be found in the "Crimp Information" table on sheet 1.

- Small crimp zone
- Large crimp zone

0.4 mm ± 0.2 mm [ .016 in ± .008 in ]

Is the distance the centre pin should be below the front face of the contact if it has been assembled correctly.