

DIMENSIONS IN MILLIMETRES

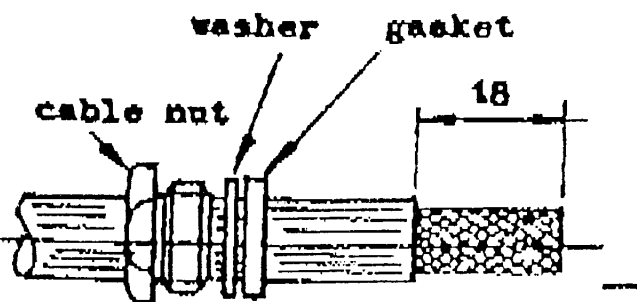


Figure 1

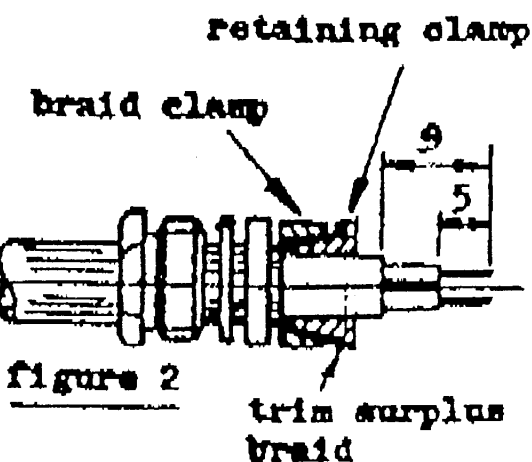


Figure 2

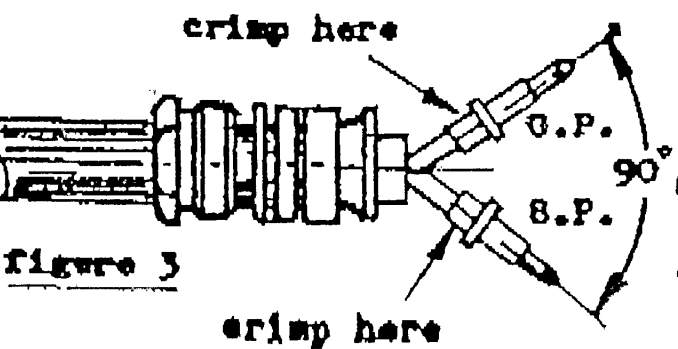


Figure 3

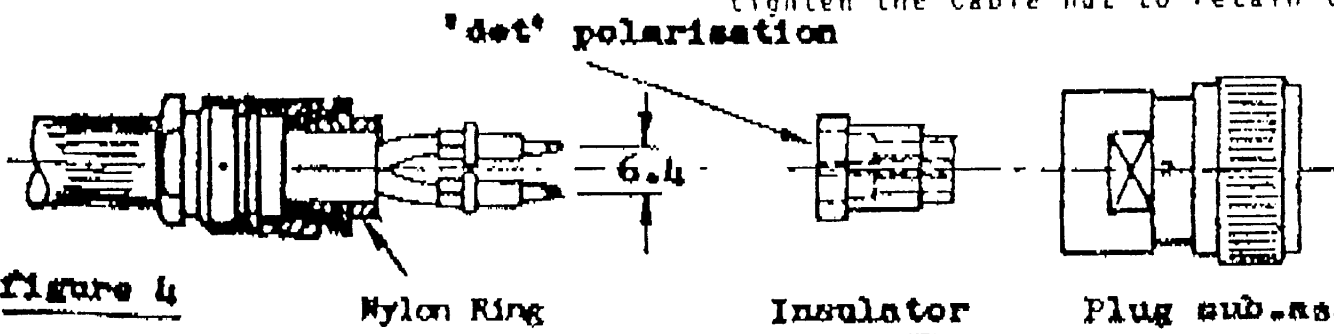


Figure 4

1. Slide cable nut, washer and gasket over cable and trim outer sheath to 18mm from end of cable as shown in Fig.1.
2. Fit braid clamp over braid so that internal shoulder butts against end of outer sheath.
3. Fold back braid, and insert retaining clamp over dielectric to trap braid between braid clamp and retaining clamp. Push retaining clamp as far as possible and trim surplus braid.
4. Trim outer and inner dielectric to dimensions shown taking care not to damage the inner conductors.
5. Separate the inner conductors and inner dielectrics to 90° apart as shown in Fig.3 to permit access of crimp tool dies only. Slide male gold plated contact on copper inner conductor and silver plated on tinned conductor one by one and crimp with Duocrimp 89L ensuring the male contacts ends butt against inner dielectrics.
6. Form back contacts. Slide nylon ring over contacts and dielectric until it butts against the retaining clamp as shown in Fig.4 Check the contacts are 6.4mm apart.
7. Carefully slide the insulator over the pins keeping slot at bottom and polarised dot near the G/P contact until it butts against the retaining clamp ensuring that the ring is fully settled in the recess of insulator.
8. Slide the gasket, washer and cable nut up to the cable clamp.
9. Slide the body sub-assembly over the insulator and ensure that the slot on the insulator is in line with the locating pin on plug sub-assembly, hold it firmly and tighten the cable nut to retain the cable.