

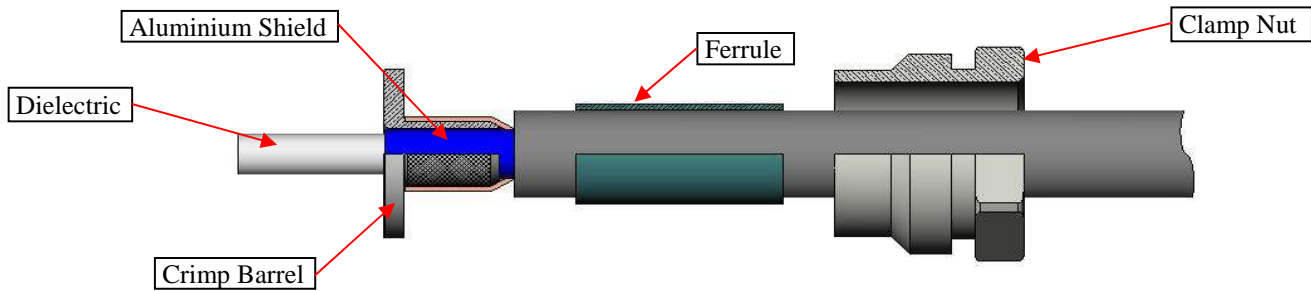
Series NSX TCAS	COAX SIZE 1 & T-CAS SIZE 1 RF CONTACT - WIRING INSTRUCTIONS EN4604-010-KX, ECS 311601, ECS 421601, TIMES MICROWAVE AA-8489, ASNE0691 AND GORE GSC-03-81748-00 CABLES	Issue Dec. 06, 2011	Page 1 / 2
--------------------	----------------------------------------------------------------------------------------------------------------------------------------------------------------------------	------------------------	---------------

- STEP 1 :**
- STRIP CABLE JACKET TO DIMENSIONS SHOWN



CABLES	Dimension A	Dimension B
EN4604-010-KX, ECS 311601, ECS 421601, ASNE0691, GORE GSC-03-81748-00	6 mm	16 mm
TIMES MICROWAVE AA-8489	6,3 mm	17 mm

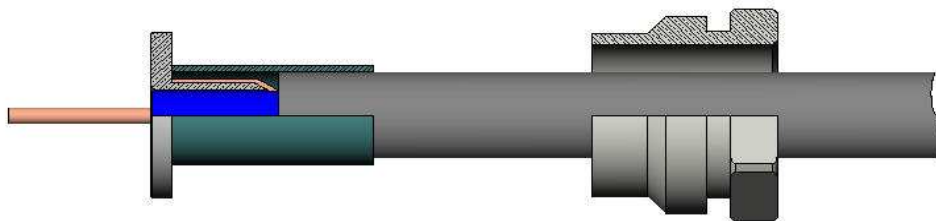
- STEP 2 :**
- SLIDE CLAMP NUT AND FERRULE OVER THE CABLE
- FLARE THE BRAID
- SLIDE CRIMP BARREL OVER ALUMINIUM SHIELD AND PLACE THE BRAID ON KNURLED AREA



- STEP 3 :**
- SLIDE FERRULE OVER BRAID
- CRIMP FERRULE USING:

CABLES	CRIMPING TOOL	DIE
EN4604-010-KX	M22520/5-01	M22520/5-13 HEX A
ECS 311601 AND TIMES MICROWAVE AA-8489		M22520/5-41 HEX A
ASNE0691 AND GORE GSC-03-81748-00		M22520/5-05 HEX B
ECS 421601		M22520/5-43 HEX A

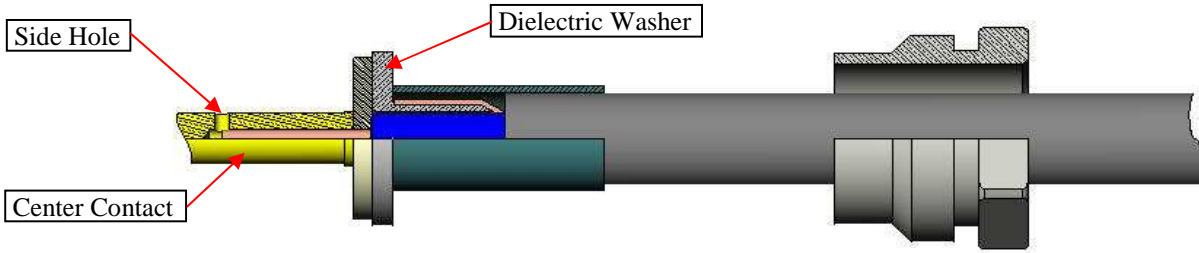
- THEN TRIM DIELECTRIC



- STEP 4 :**
- SLIDE DIELECTRIC WASHER OVER CENTER CONDUCTOR
- THEN SLIDE CENTER CONTACT, CRIMP CENTER CONTACT USING:

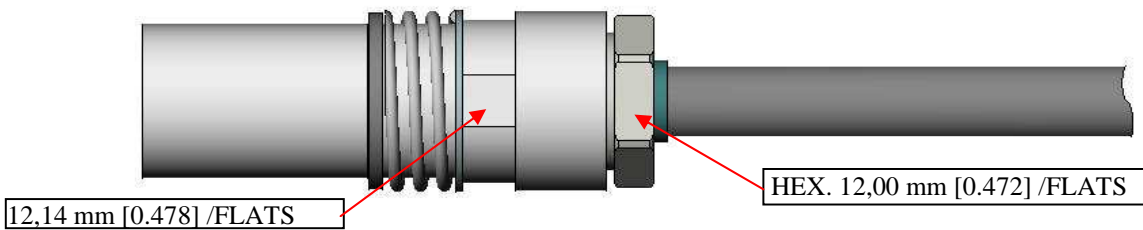
CABLES	CRIMPING TOOL / SELECTOR	POSITIONER / TURRET
ECS 311601	M22520/1-01 / SELECT 8	M22520/1-13 GREEN
TIMES MICROWAVE AA-8489		
ASNE0691	M22520/1-01 / SELECT 7	
GORE GSC-03-81748-00		
EN4604-010-KX		
ECS 421601		

Series NSX TCAS	COAX SIZE 1 & T-CAS SIZE 1 RF CONTACT - WIRING INSTRUCTIONS EN4604-010-KX, ECS 311601, ECS 421601, TIMES MICROWAVE AA-8489, ASNE0691 AND GORE GSC-03-81748-00 CABLES	Issue Dec. 06, 2011	Page 2 / 2
--------------------	----------------------------------------------------------------------------------------------------------------------------------------------------------------------------	------------------------	---------------



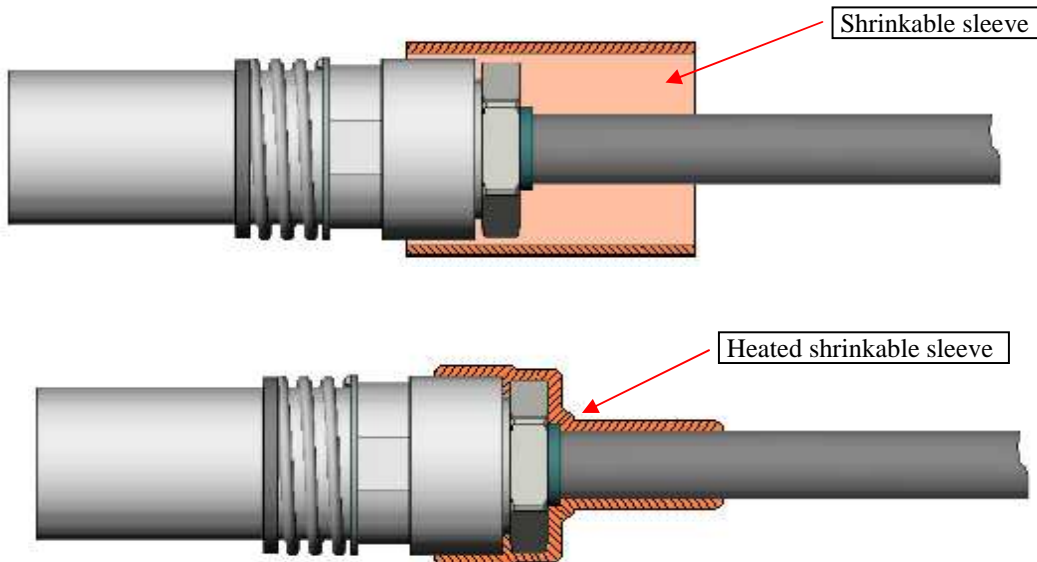
STEP 5 :

- INTRODUCE THE CABLE INTO THE OUTER CONTACT.
- SCREW AND TIGHTEN THE CLAMP NUT
- COUPLING TORQUE: 1,13 to 1,69 N.m [10 to 15 IN.LBS]



STEP 6 : OPTIONAL (when the shrinkable is supplied with the contact)

- INTRODUCE THE SHRINKABLE SLEEVE AROUND THE COAX AND THE CABLE (THE SHRINKABLE SLEEVE SHOULD NOT COVER THE SPRING)
- HEAT THE SHRINKABLE SLEEVE TO STICKS TO THE CONTACT AND THE CABLE



CREATION: NAME : MONDOT JC DATE : OCT, 07, 04 APPR : MACARI JP	Dec. 06, 2011	Dimensions on flats in mm and coupling torque in N.m added in step 5.	PERRIN H.	RAOUI R.
	Apr. 27, 2011	Added ECS 421601 cable	LEGENDRE T.	BROCHET L.
	Feb. 08, 2011	ADDED « STEP 6 : OPTIONAL »	MOUTAULT W.	BROCHET L.
	Jan. 10, 2011	STEP 4: Cable KX selector was 8 becomes 7	LALLOZ A.	BROCHET L.
	Dec. 16, 2010	ADDED EN4604-010-KX CABLE	LALLOZ A.	BROCHET L.
	ISSUE	REVISIONS	NAME	APPROVED