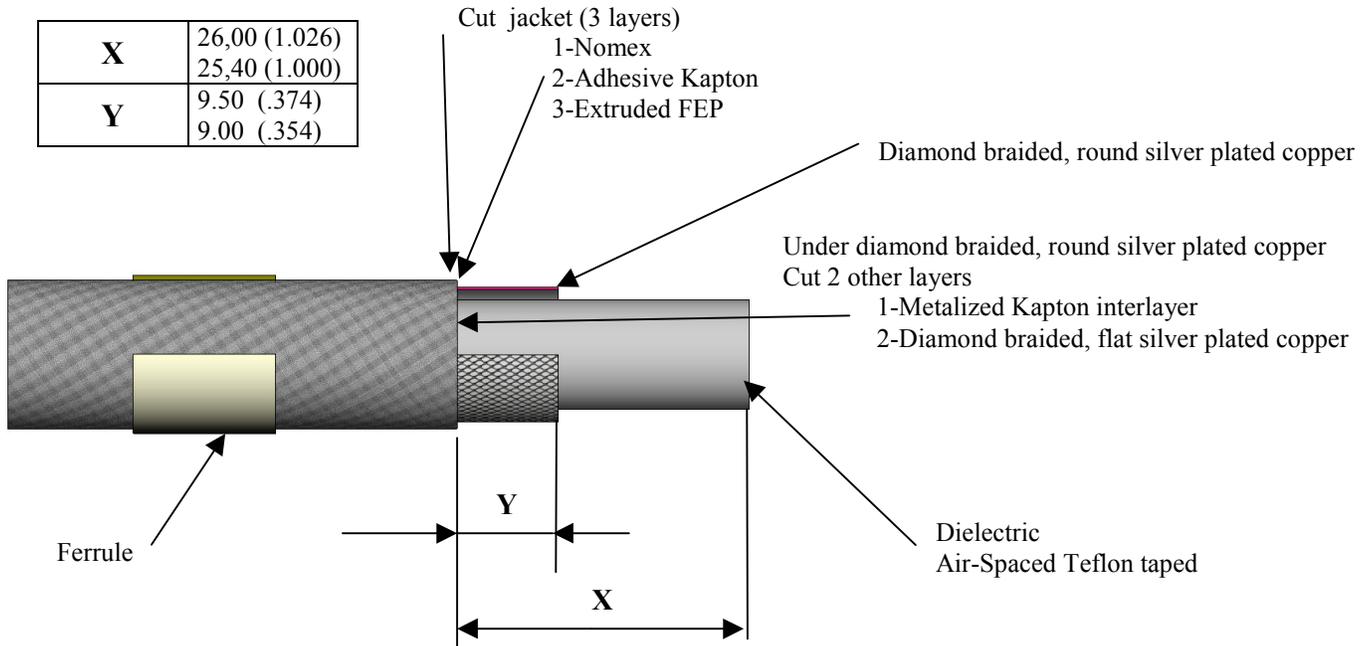
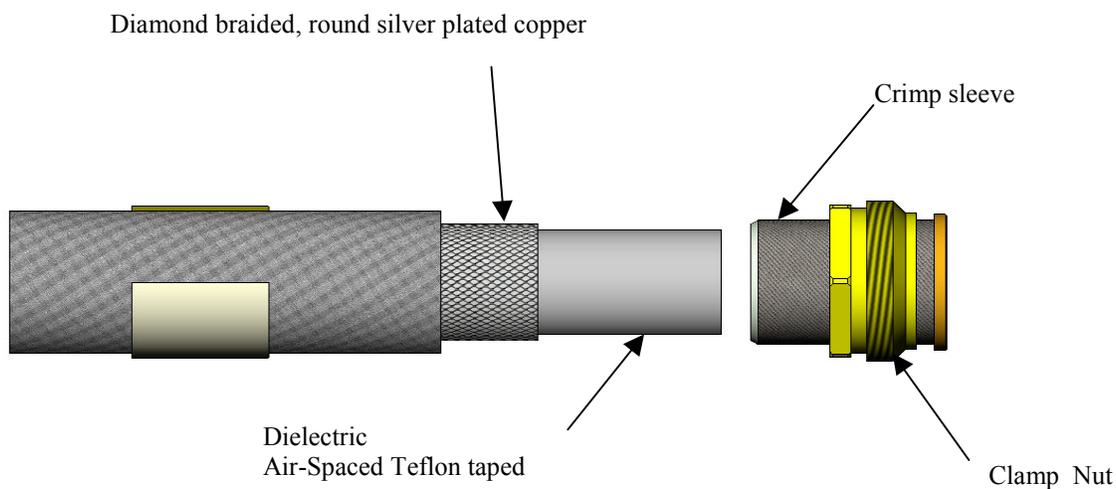


**STEP 1**

SLIDE FERRULE OVER THE CABLE  
STRIP CABLE JACKET TO DIMENSIONS SHOWN


**STEP 2**

FLARE THE BRAID  
SLIDE CLAMP NUT WITH CRIMP SLEEVE OVER DIELECTRIC AND PLACE THE BRAID ON KNULED AREA  
PER FIGURE 1



<b>CREATION</b>				
<b>NAME :</b> GOMBERT				
<b>DATE :</b> 19/ JAN / 2006	XX/XX/XX			
<b>APPR. :</b> MACARI	<b>ISSUE</b>	<b>REVISIONS</b>	<b>NAME</b>	<b>APPROVED</b>

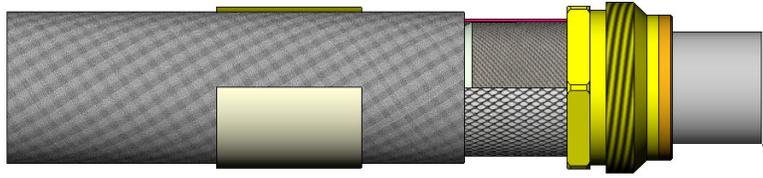
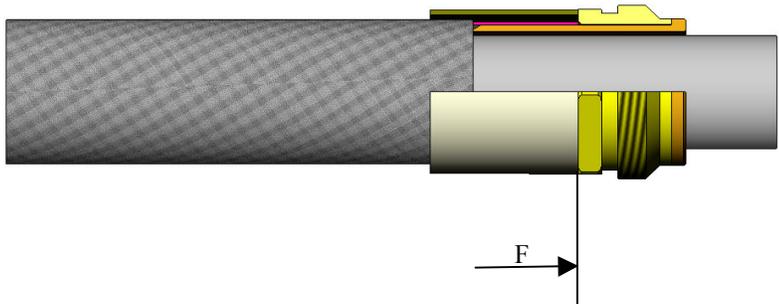
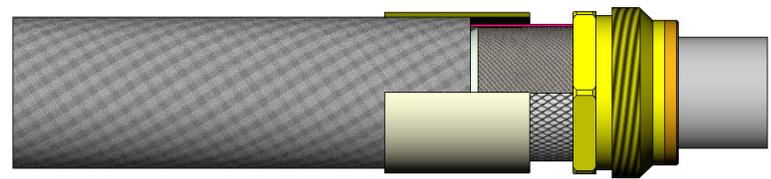


FIGURE 1

Dielectric  
Air-Spaced Teflon taped

**STEP 3**

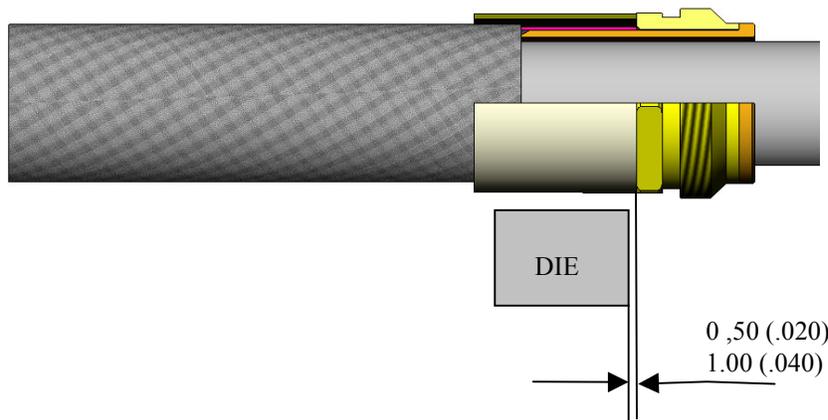
SLIDE FERRULE OVER BRAID AT " F "



**STEP 4**

CRIMP FERRULE USING

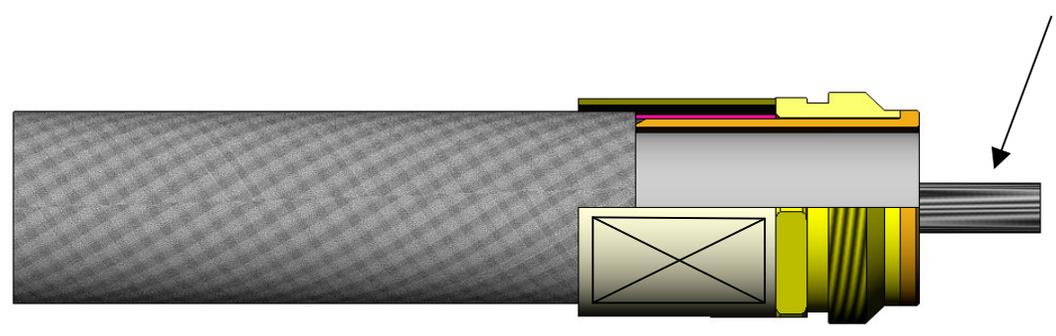
CABLE	CRIMPING TOOL	DIE
TYCO FN52RL	M22520/5-01	M22520/5-27



STEP 5

THEN TRIM DIELECTRIC

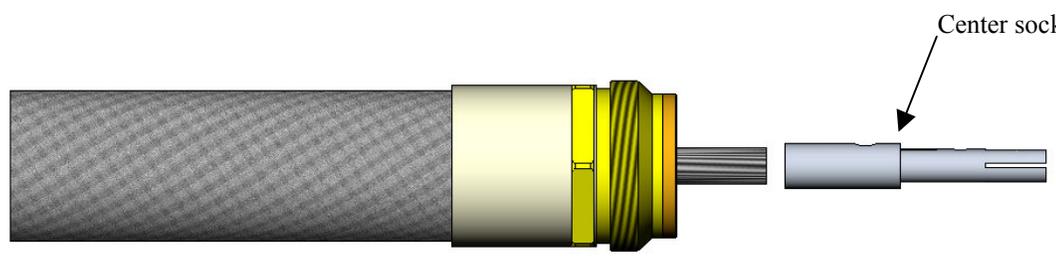
Solid, silver plated copper



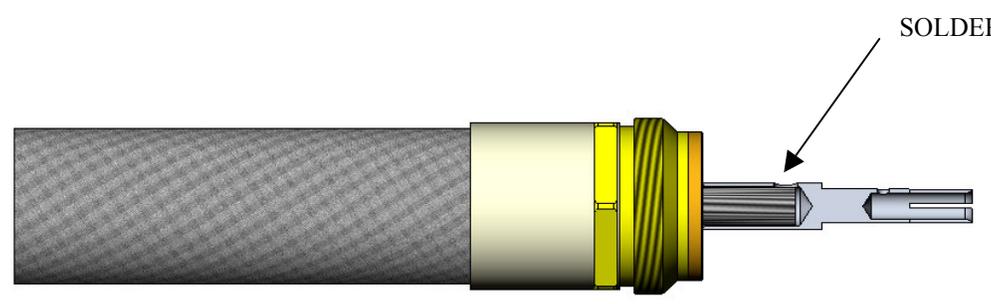
STEP 6

SLIDE CENTER SOCKET CONTACT OVER SOLID SILVER PLATED COPPER  
THEN SOLDER

Center socket contact

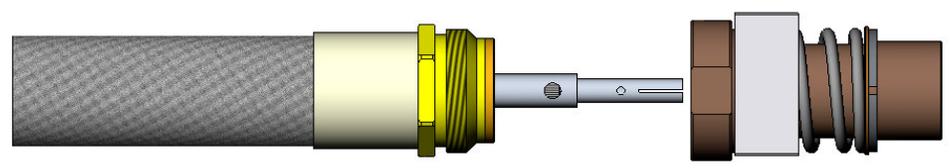


SOLDER



STEP 6

INTRODUCE THE CABLE INTO THE OUTER CONTACT





SCREW AND TIGHTEN THE CLAMP NUT WITH  
45 to 55 IN-LBS TORQUE ( 52 daN.cm to 63 daN.cm)

