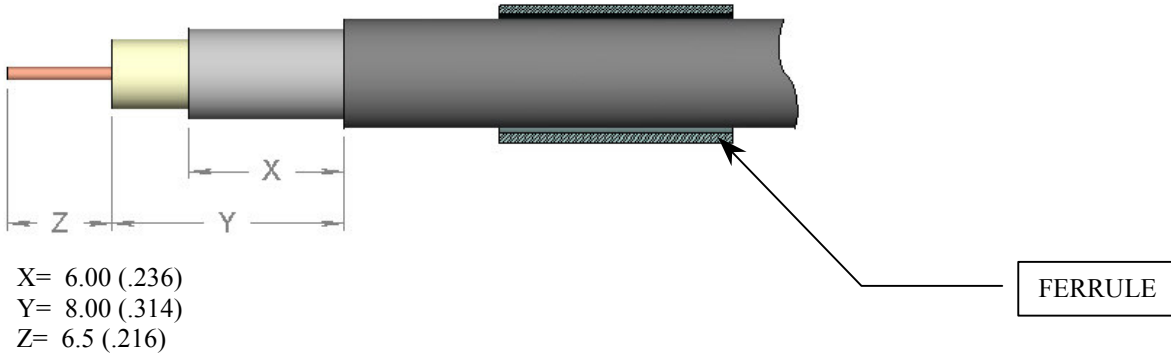


Series 38999 EPX	WIRING INSTRUCTIONS	Issue June 12, 2006	Page 1 / 2
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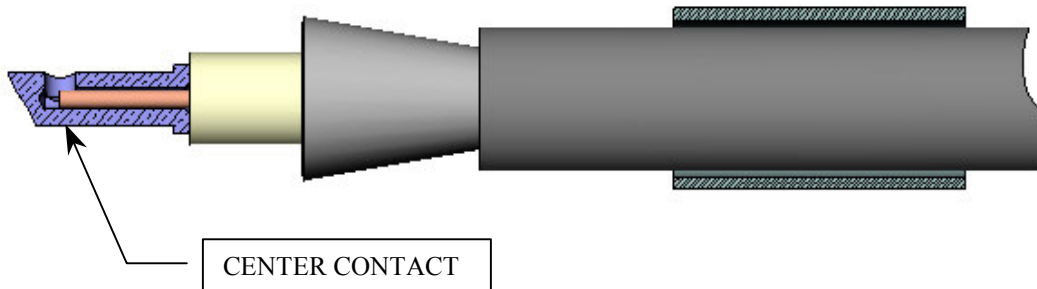
**STEP 1/**

STRIP CABLE TO DIMENSIONS SHOWN ABOVE.  
SLIDE FERRULE OVER THE CABLE.


**STEP 2/**

SLIDE CENTER CONTACT BARREL OVER CABLE.  
CONTACT SHOULDER BUTTING AGAINST CABLE DIELECTRIC.  
CRIMP CENTER CONTACT USING :

CABLE	CRIMPING TOOL / SELECTOR	POSITIONER / TURRET
	M22520/2-01 RADIALL (282281)	K1025S RADIALL (282 587)

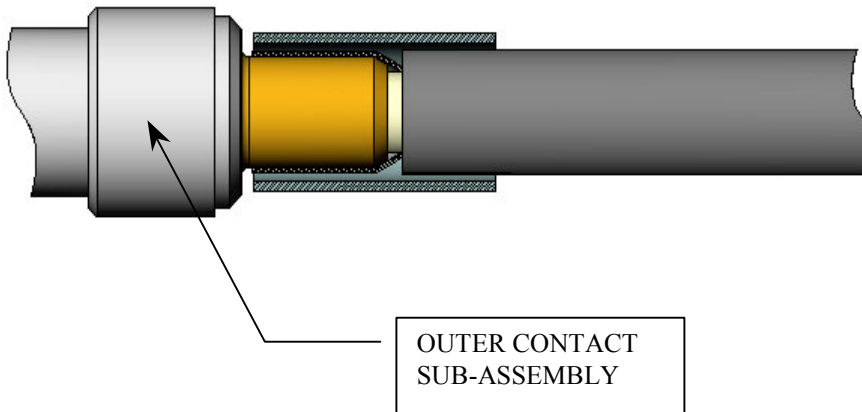

**STEP 3/**

FLARE BRAID, INSERT CENTER CONTACT INTO THE OUTER CONTACT BODY.  
AND PUSH UNTIL IT SNAPS INTO THE INSULATOR.  
PLACE BRAID OVER KNURLED PART OF OUTER CONTACT SUB-ASSEMBLY.  
COMB THE BRAID

<b>CREATION</b> NAME : BVDM DATE : Jan 20, 2006 APPR. : Perrin	July 03,2006	Stripping dimension Z :6.5 was 5.5 – Added snapping in Step 3		
	June 12, 2006	LMR-240-75 cable added	LE GLOAHEC	PESSARD
	<b>ISSUE</b>	<b>REVISIONS</b>	<b>NAME</b>	<b>APPROVED</b>

**STEP 4/**

SLIDE FERRULE OVER BRAID UNTIL IT BUTTS AGAINST SHOULDER OF OUTER CONTACT SUB-ASSEMBLY.  
CRIMP FERRULE USING :



CABLE	CRIMPING TOOL	DIE
MPA61111 DXL	M22520/5-01 RADIALL (282293)	M22520/5-45 HEX B
MPA61111 DXJ		M22520/5-13 HEX A
LMR-240-75		