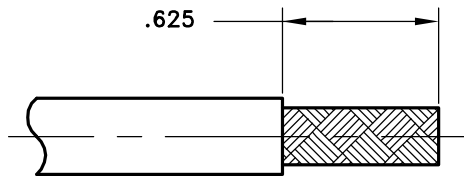
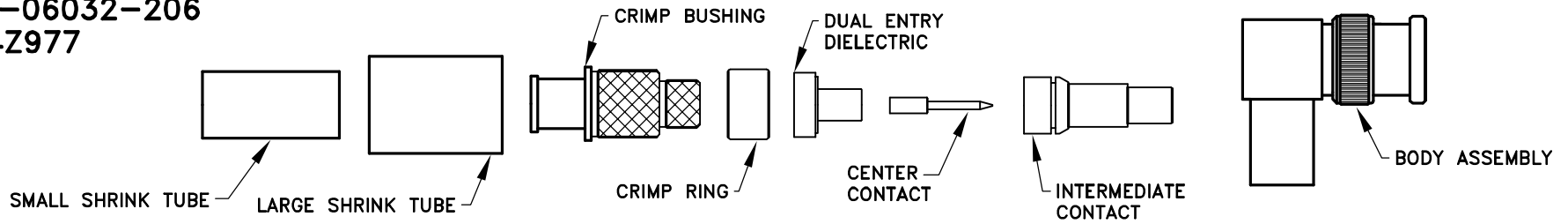
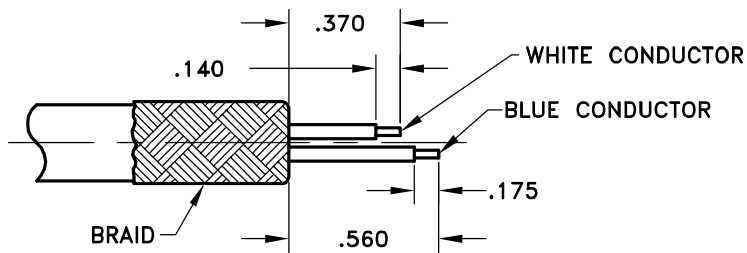


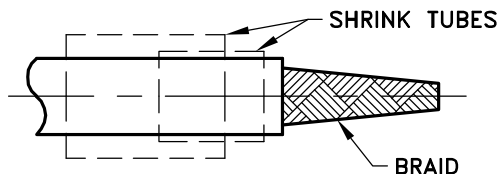
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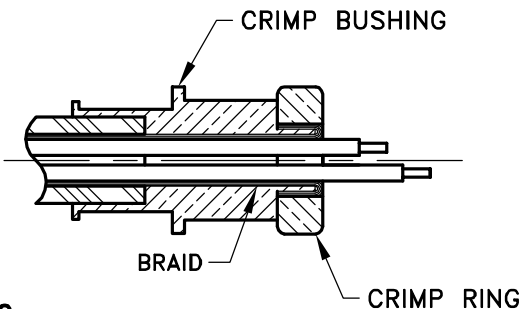
1.) STRIP OUTER JACKET PER DIMENSIONS. DO NOT KNICK BRAID.



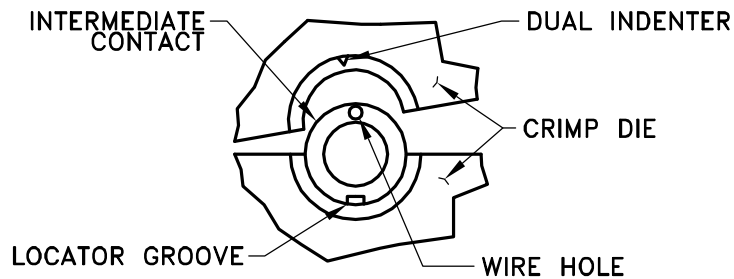
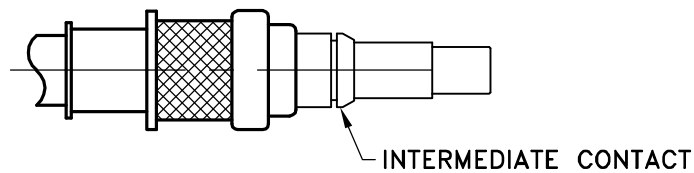
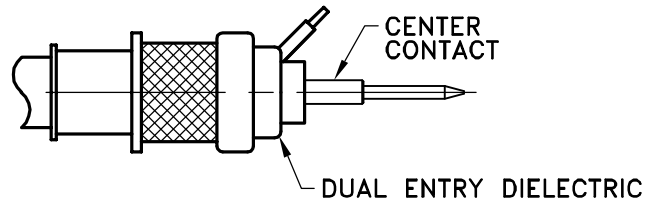
2.) FOLD BRAID(S) BACK OVER JACKET. FOR DOUBLE SHIELDED OR QUADRAX CABLE, REMOVE EXTRANEOUS MATERIAL (MU-METAL, MYLAR, ETC.) FROM BETWEEN BRAID LAYERS. CUT & TRIM CONDUCTORS AS PER DIMENSIONS.



3.) BRING BRAID(S) FORWARD AND TWIST AROUND CONDUCTORS. SLIDE BOTH SHRINK TUBES ONTO CABLE.



4.) PUSH CABLE INTO CRIMP BUSHING UNTIL JACKET BOTTOMS AGAINST THE INSIDE SHOULDER. FOLD THE BRAID(S) BACK OVER THE CRIMP BUSHING. SLIDE THE CRIMP RING OVER THE BRAID UNTIL THE CRIMP RING BOTTOMS OUT.



5.) BEND THE WHITE CONDUCTOR OUTWARD AND POSITION THE BLUE CONDUCTOR TO THE CENTER OF THE CABLE. INSTALL THE DUAL ENTRY DIELECTRIC. THE BLUE CONDUCTOR PASSES THRU THE CENTER AND THE WHITE CONDUCTOR PASSES THRU THE SIDE SLOT. POSITION THE CENTER CONTACT OVER THE BLUE CONDUCTOR AND CRIMP IN PLACE USING MILITARY CRIMP TOOL M22520/1-01 SELECTION 4 WITH POSITIONER 010-0044.

6.) PLACE INTERMEDIATE CONTACT OVER CENTER CONTACT. INSERT THE WHITE CONDUCTOR INTO THE SMALL HOLE AT THE REAR OF THE INTERMEDIATE CONTACT. BOTTOM THE INTERMEDIATE CONTACT AGAINST THE DUAL ENTRY DIELECTRIC.

7.) USING A MILITARY CRIMP TOOL (M22520/5-01) AND A DANIELS Y778 DIE SET (POSITION B), CRIMP THE INTERMEDIATE CONTACT IN PLACE.

8.) PUSH ASSEMBLY INTO BODY ASSEMBLY UNTIL IT BOTTOMS. HEX CRIMP WITH A MILITARY CRIMP TOOL (M22520/5-01) AND A DANIELS Y778 DIE SET (POSITION A). BRING LARGE SHRINK TUBE UP ONTO REAR OF CRIMP BUSHING AND SHRINK IN PLACE. BRING SMALL SHRINK TUBE UP ONTO REAR OF BODY ASSEMBLY TO DIMENSION SHOWN AND SHRINK IN PLACE.

