

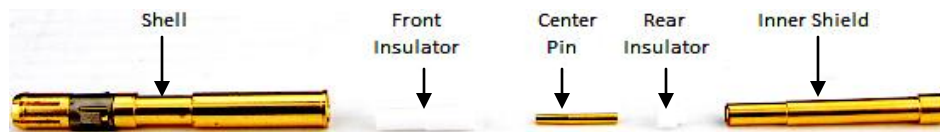


Wiring Assembly Instructions

7847211-40 Contact, Receiver, Coax, 50 Ohms, RG316, RG174.



Fig. A. (Contact Sub-Assembly)



Contact Sub-Assembly Piece Parts.

Contact Crimp Information Table

Wire Type	Wire Awg.	Strip Length In Inches	Crimp Tool	Hex Die Set/ Positioner	Indicator	Selector No.	Heat-shrink Length X Dia.
RG316/ RG174	24	A) 1/4" B) 3/8" C) 5/8"	*452200 **452300	*452205 **452301	Green N/A	2 N/A	N/A N/A

NOTES: *For Center Pin Crimping (Step 7). **For Shield Crimping (Step 11)

Test Requirements

Test Type	Voltage (Hi-pot Only)	Pull Test	Depth Gauge	Marker Settings
Hi-pot	500V DC	5lbs	N/A	N/A

NOTE 1: Refer to **IPC/WHMA-A-620A** standard (Ch. 11.1.2) for cable lengths, measurements and tolerance.

NOTE 2: Overall length of cable should be less 3/8" to compensate for the contact attachment.

STEP 1) From the "Contact Crimp Information" Table, use the crimp tool and hex die set listed.



Fig. B. (Crimp Tool 452200)



Detail A. (Crimp Tool and Positioner)

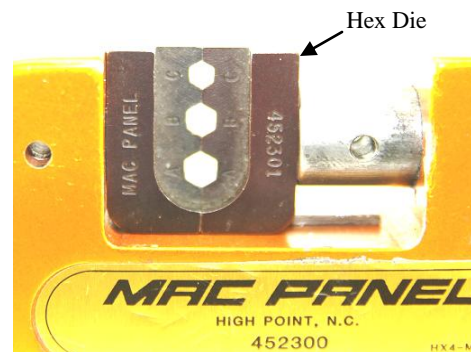
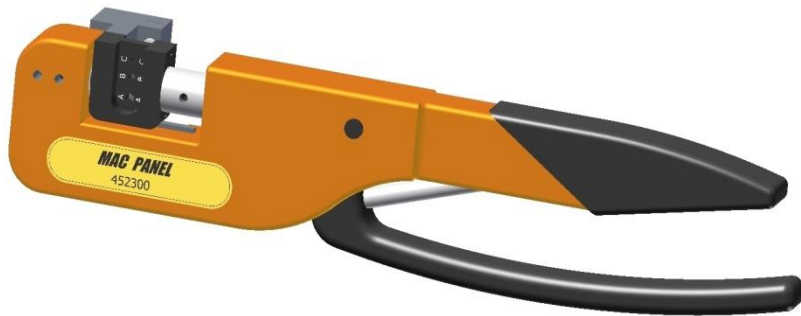


Fig. C. (Crimp Tool 452300)

Detail A. (Hex Die 452301 Installed in Crimp Tool)

STEP 2) Using a ruler along with wire strippers, strip the cable to the dimensions in the "Strip Length" column. Example of stripped wire shown below in **Fig. D.** to expose braid.



Fig. D.

STEP 3) Pull shield back and strip to dimensions **(A)** and **(B)**, **Fig. E.**

NOTE: Dimension "A" should be stripped with cable Shield but not Dimension "B"



Fig. E.

STEP 4) Pull shield up and slide Inner Shield over it as in **Fig. F.**



Fig. F.

STEP 5) Pull shield back over Inner Shield exposing stripped wire dielectric and forming an evenly spread of Shield around Inner Shield as shown below in **Fig. G.**

NOTE: Ensure that no strand of Center Conductor contacts the shield to prevent shorts.



Fig. G.

STEP6) Install Rear Insulation over dielectric seating it firmly against Inner Shield as in **Fig. H.**



Fig. H.

STEP 7) Insert Center Conductor into Center Pin and crimp in place using information provided in the "Crimp Information Table" (**452200 and 452205**). **Fig. J.**



Fig. J.

STEP 8) Slide Front Insulator over Crimped Center Pin as in **Fig. K**



Fig. K.

STEP 9) Slide shell onto center conductor until fully seated as shown in **Fig. L**



Fig. L.

STEP 10) Crimp Shielding together by using medium (B) of Hex die to crimp in the groove on Shell and the same medium to crimp Inner Shield to cable (**45200 and 452301**) **Fig. M. N. and P.**



Fig. M.

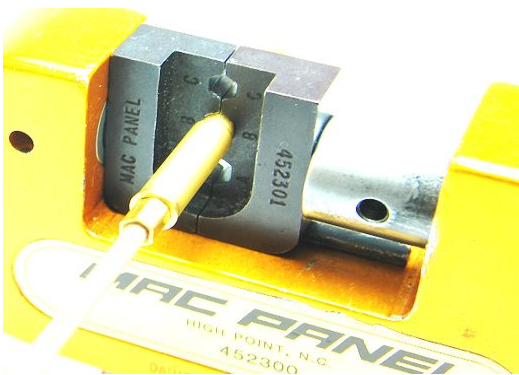


Fig. N.

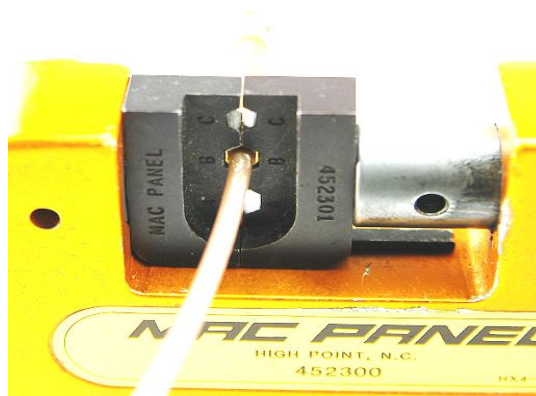


Fig. P.

STEP 11) Perform a "Hi-pot" test to the settings listed in "Test requirements". If a "pass" test occurs proceed to complete the assembly. **Fig. R.**



Fig. R.