



Wiring Assembly Instructions

7849211-40 Contact, ITA, Coax, 50 Ohm, 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	24	A) 1/4" B) 3/8"	*452200	*452205	Blue	1	N/A
RG174		C) 5/8"	**452300	** 452301	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)

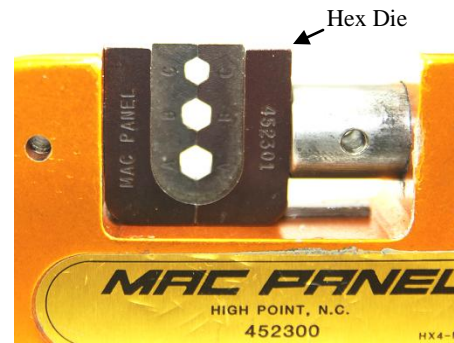


Fig. C. (Crimp Tool 452300)

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

STEP 2) Slide Outer Crimp Ring and Shell over cable as shown in Fig. D below.



STEP 3) Using a ruler along with wire strippers, strip the cable to the dimensions in the "Strip Length" column of Contact Crimp Information Table". Example of stripped wire shown below in Fig. E. to expose cable conductor.



STEP 4) Strip to dimensions (B) and (C), and pull cable Shielding back. Fig. F.



STEP 5) Slide Inner Crimp Ring over Cable Dielectric and under pulled Cable Shield as in Fig. G.



STEP 6) Install Rear Insulation over Cable Dielectric making sure the Insulator seats firmly in the recessed hole shown below in Fig. H.



STEP 7) Slide the Center Pin over cable conductor until it seats firmly against Rear Insulator and crimp using "Contact Crimp Information Table" (452200 and 452205) as in Fig. J.



Fig. J.

STEP 8) Insert Front Insulation over crimped Center Pin allowing it to seat firmly over the Rear Insulator. **Fig. K.**



Fig. K.

STEP 9) Form an evenly spread Cable Shielding over Inner Crimp Ring as in **Fig. L.**

NOTE: Trim any excess Cable Shielding over Rear Insulation to avoid shorts.



Fig. L.

STEP 10) Place Shell in a holding fixture and push Assembly into it to seat firmly against the back of Shell in **Fig. M.**

NOTE: Seating Tool should have a recessed hole to allow Center Pin clearance to push Assembly into Shell.



Fig. M.

Detail A

STEP 11) Slide Outer Crimp Ring unto Shell and use Hex (B) to crimp the large diameter. Use Hex (C) for small diameter of Outer Crimp Ring by using "Contact Crimp Information Table" (452300 and 452301) above. **Fig. M and N.**



Fig. M.



Fig. N.

STEP 12) Perform a visual as well as a retention check and proceed to complete the Assembly. **Fig. P.**



Fig. P.