

Crimp Tool Assembly.

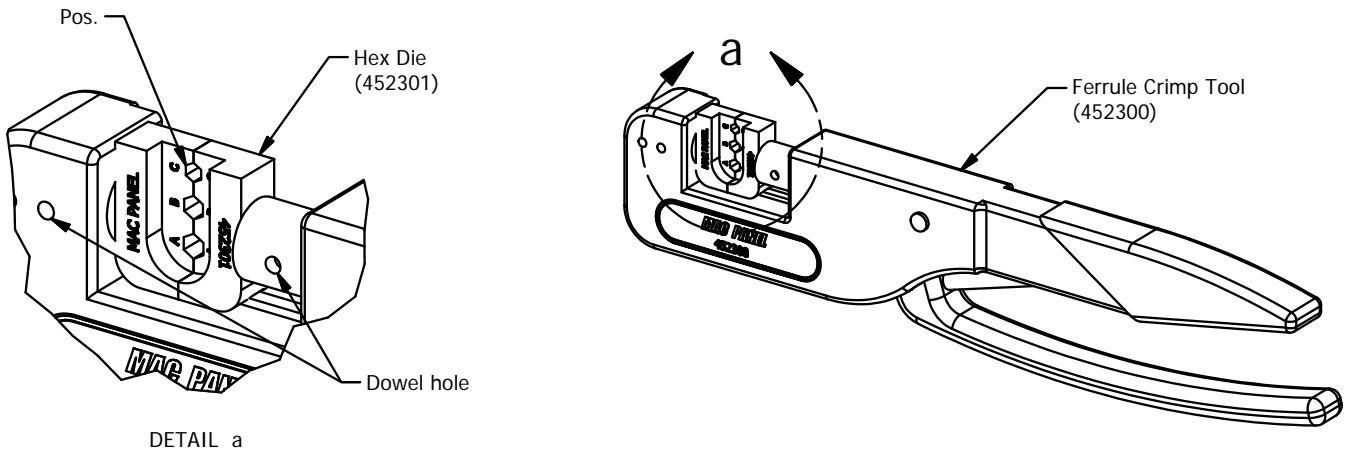
From the "Crimp Information" table below, select the correct ferrule crimp tool / hex die for your contact.

Crimp Information				
Contact	Wire	Ferrule Crimp Tool	Hex Die	Letter
7865100-14	RG179	452300	452301	C
7865200-14	RG179	452300	452301	C

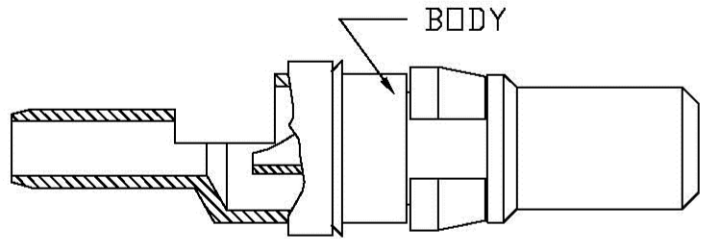
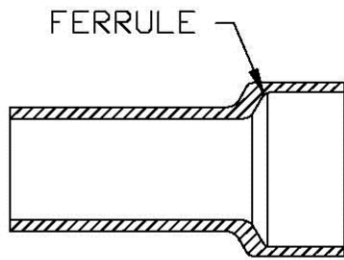
Ferrule Crimp Tool Setup.

Install Hex Die into crimp tool.

- a) Fully close handles and allow handles to automatically release.
- b) Insert Hex die into crimp tool as shown.
- c) Insert two dowels supplied with hex die through holes in the crimp tool.

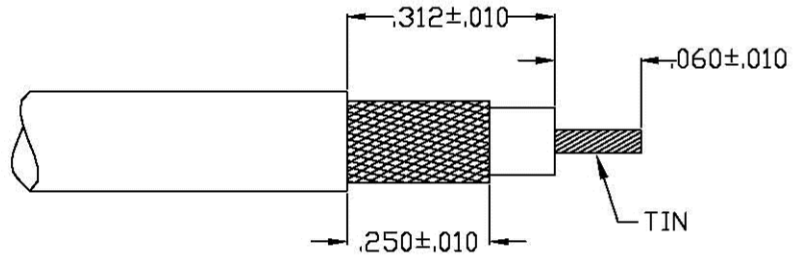


Your crimp tooling is now ready for use.



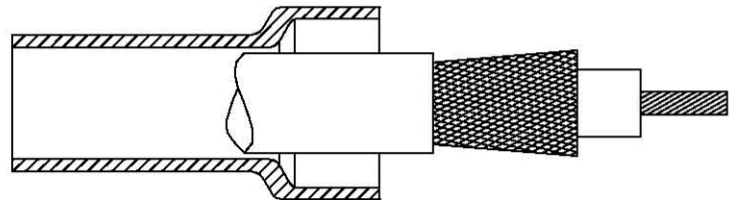
STEP 1

TRIM CABLE TO DIMENSIONS SHOWN.
TIN CENTER CONDUCTOR.



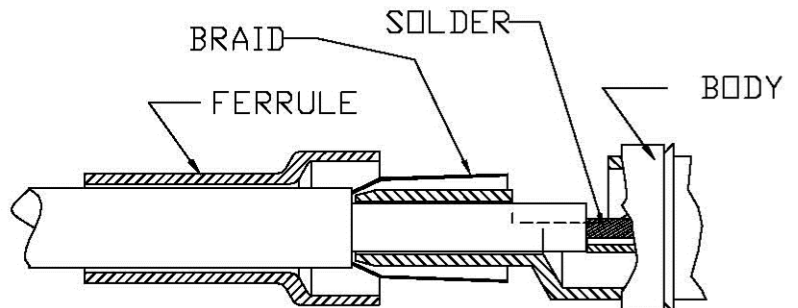
STEP 2

SLIDE FERRULE UP OVER CABLE,
ROTATE DIELECTRIC TO FLAIR BRAID.



STEP 3

INSERT CONNECTOR WEDGE BETWEEN CABLE BRAID
AND DIELECTRIC UNTIL CABLE DIELECTRIC BUTTS
AGAINST CONNECTOR CENTER CONTACT. SOLDER
CENTER CONDUCTOR OF CABLE TO CENTER CONTACT.
CLEAN.



STEP 4

BUTT FERRULE AGAINST SHOULDER OF CONNECTOR
AND CRIMP USING .128 HEX DIE Y-196 (M22520/5-03).

