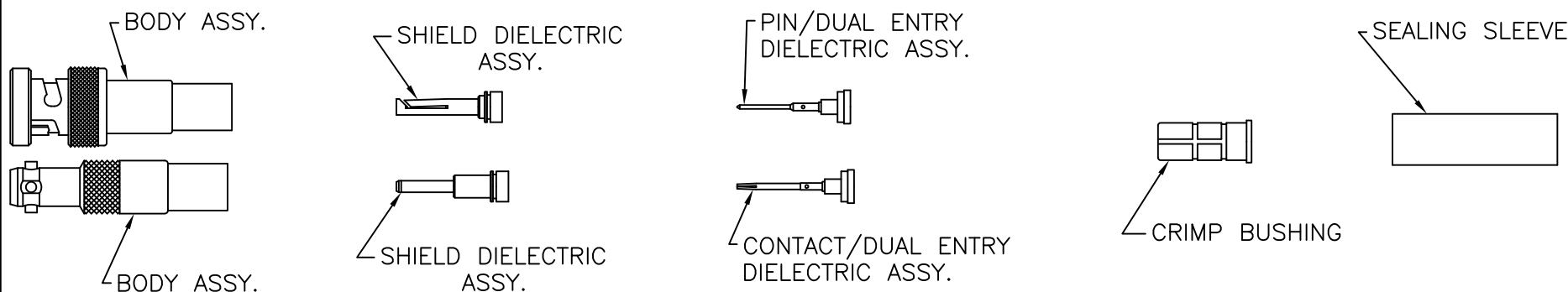
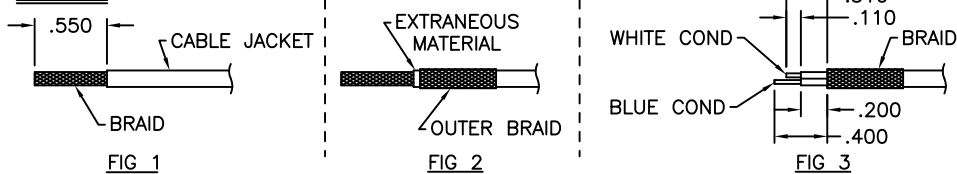


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M	53444	6/29/2011
N	55718	6/24/2015



STEP 1



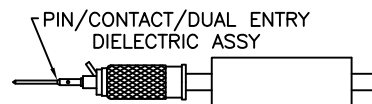
- REMOVE CABLE JACKET TO RECOMMENDED DIM SHOWN (FIG 1), FOR DOUBLE SHIELDED OR QUADRAX CABLE FOLD BACK OUTER BRAID AND REMOVE EXTRANEOUS MATERIAL (MYLAR, MU-METAL, ETC.) AS FAR BACK AS POSSIBLE (FIG 2).
- COMB BACK BRAID(S) AND FOLD BACK OVER OUTER JACKET (FIG 3).
- STRIP CENTER CONDUCTORS TO RECOMMENDED DIM AS SHOWN (FIG 3), LIGHTLY TIN CENTER CONDUCTORS (RECOMMENDED).

STEP 2



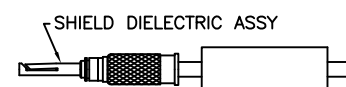
- BRING BRAID(S) OVER CENTER CONDUCTORS, TWIST BRAIDS AROUND CENTER CONDUCTORS (FIG A).
- PLACE SEALING SLEEVE ONTO CABLE AS SHOWN.
- PUSH CABLE THRU CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE CRIMP BUSHING (FIG B).
- FOLD BRAID(S) BACK OVER CRIMP BUSHING (FIG B).

STEP 3



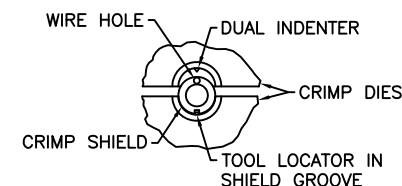
- BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
- INSTALL PIN/CONTACT/DUAL ENTRY DIELECTRIC ASSY OVER BLUE CONDUCTOR AND SEAT AGAINST BRAID, WITH WHITE CONDUCTOR THRU SIDE SLOT, CRIMP CENTER PIN/CONTACT WITH MILITARY CRIMP TOOL M22520/2-01 SETTING 4 USING TROMPETER POSITIONER 010-0041.

STEP 4

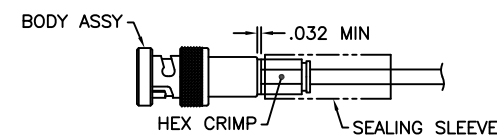


- PLACE SHIELD/DIELECTRIC ASSY OVER CENTER PIN/CONTACT, INSERT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF SHIELD/DIELECTRIC ASSY AND BOTTOM AGAINST DUAL ENTRY DIELECTRIC.
- CRIMP IN PLACE WITH MILITARY CRIMP TOOL M22520/5-01 USING CD5-9 CLOSURE B (SEE DETAIL A).

DETAIL A



STEP 5



- PUSH ASSEMBLY INTO BODY ASSEMBLY UNTIL BOTTOMED, VERIFY THAT PIN/CONTACT IS CENTERED WITHIN BODY ASSEMBLY. HOLD ASSEMBLY FIRMLY BOTTOMED UNTIL FULLY HEX CRIMPED AS SHOWN WITH MILITARY CRIMP TOOL M22520/5-01 USING CD5-9 CLOSURE A (.255 HEX).
- BRING SEALING SLEEVE UP ONTO HEX CRIMPED PORTION OF THE BODY ASSEMBLY NOT TO EXTEND PAST STEP OF BODY

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