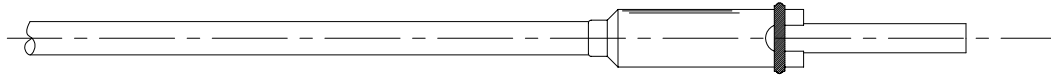
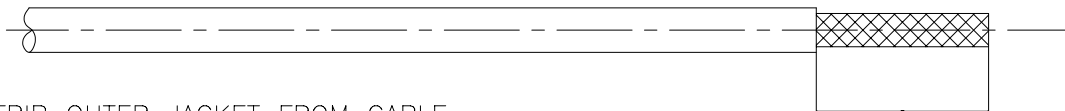


INSTALLATION PROCEDURE

TRIAxIAL CONTACT TERMINATION
SIZE 8 DK-602-0186-X / DK-602-0187-X
FOR SHIELDED TWISTED PAIRS AWG 24



1 - SLIP THE BRAID TERMINATOR ONTO THE CABLE.



2 - STRIP OUTER JACKET FROM CABLE.

SINGLE BRAID CABLE:

Raychem

10612 -EPD 44690-EPD 44691

DOUBLE BRAID CABLE:

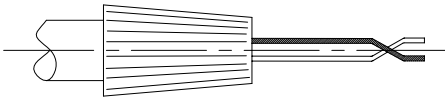
Raychem

10613 -EPD 44692-EPD 44693

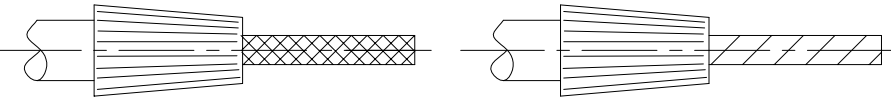
DOUBLE BRAID+MU METAL CABLE:

Raychem

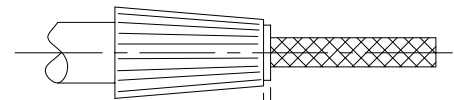
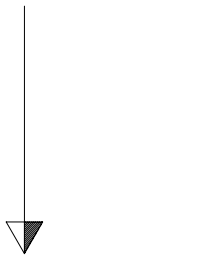
10614 -EPD 44694-EPD 44695



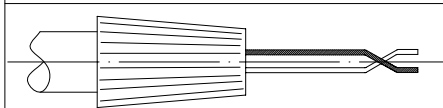
3 - COMB OUT BRAID AND FOLD BACK.



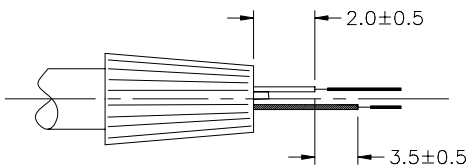
COMB OUT FIRST BRAID AND FOLD BACK.



1.0 MAX
COUPER LE RUBAN MU METAL



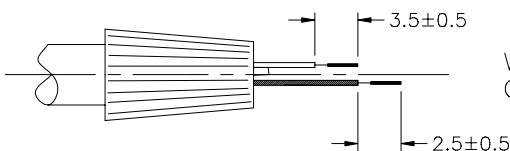
COMB OUT AND FOLD BACK THE SECOND BRAID.



4 - STRAIGHTEN EXPOSED TWISTED PAIR WIRES.

5 - CUT THE FILLERS.

6 - STRIP INNER CONDUCTORS.

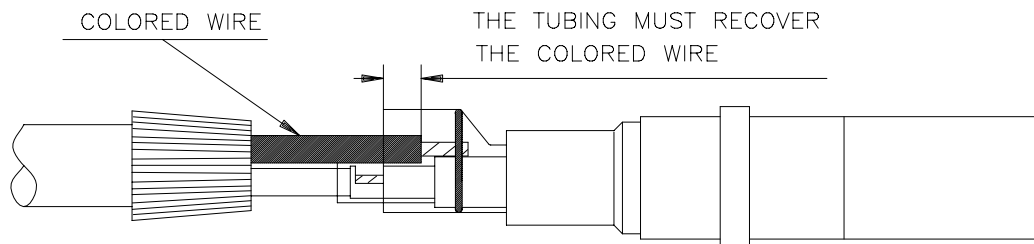


White
Colored

7 - PRE-TIN THE CONDUCTORS ENDS WITH Sn63 Pb37 SOLDER ALLOY AND RMA FLUX.

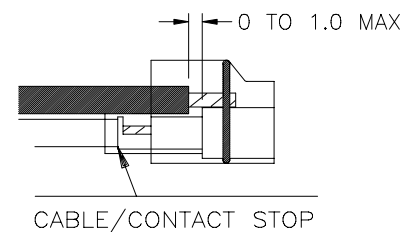
8 - UNLESS USER OTHERWISE SPECIFIES (BY COLOURS) TRIM AS FOLLOW :
TRIM POSITIVE SIGNAL CONDUCTOR (WHITE WIRE) AND NEGATIVE SIGNAL CONDUCTOR (COLORED WIRE).

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9- INSERT THE CONDUCTORS INTO THE CONTACT:

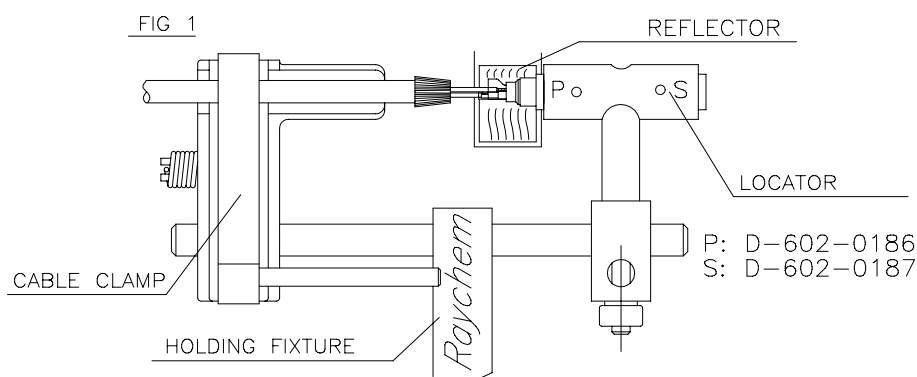
- POSITIVE SIGNAL CONDUCTOR (WHITE) INTO INNER SLEEVE.
- NEGATIVE SIGNAL CONDUCTOR (COLORED) BETWEEN THE TWO SLEEVES.
- SLIDE THE CABLE UNTIL IT BOTTOMS AGAINST THE CONTACT.
- CHECK THE POSITION OF THE NEGATIVE SIGNAL (COLORED) CONDUCTOR AND THE POSITION OF TUBING AS SHOWN.



10- INSERT CONTACT/CABLE ASSEMBLY INTO THE HOLDING FIXTURE.

11- SWITCH ON THE HEATING TOOL FOR A MINIMUM OF 30 SECONDS BEFORE STARTING INSTALLATION.

12- POSITION THE CONTACT IN THE REFLECTOR USING THE HOLDING FIXTURE.



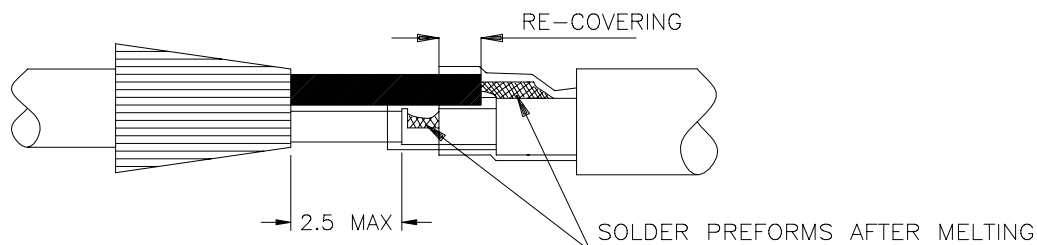
13- HEAT UNTIL THE TWO SOLDER PREFORMS WERE COMPLETELY MELTED AND FLOWED.

14- WAIT 15 SECONDS BEFORE REMOVING THE CONTACT FROM THE HOLDING FIXTURE.

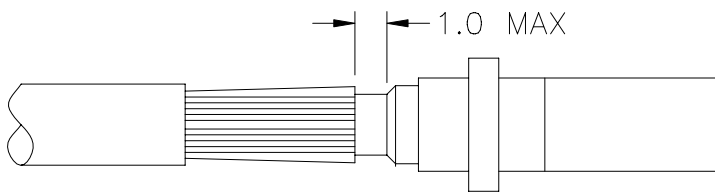
INSPECTION OF THE CONTACT TERMINATION

INSPECT THE COMPLETED TERMINATION FOR CORRECT ASSEMBLY ACCORDING TO THE FOLLOWING CRITERIA:

1. THE 2 SOLDER PREFORMS HAVE TOTALLY DISAPPEARED.
2. THE NEGATIVE SIGNAL CONDUCTOR (COLORED) SHOULD BE RE-COVERED BY THE TUBING.

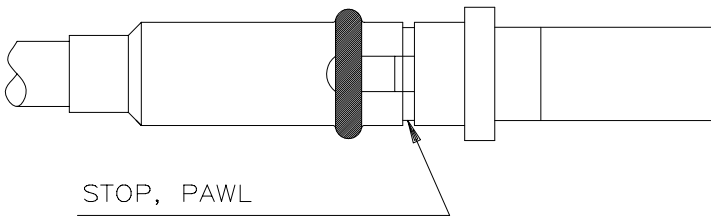


NB : SLIGHT BROWNING OF THE SLEEVE (made in KYNAR) MAY BE ACCEPTED DURING THE INSTALLATION PROCESS AS PRODUCT PERFORMANCES ARE NOT AFFECTED.



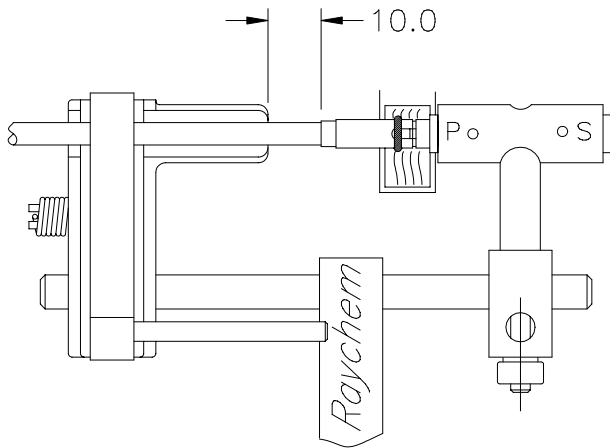
15 - FOLD BACK THE BRAID(S) OF THE CABLE ONTO THE REAR OF THE CONTACT WITHOUT RE-COVERING ON THE COLORED WIRE.

16 - TRIM THE BRAID STRANDS AS SHOWN.



17 - SLIDE THE BRAID TERMINATOR OVER THE BRAID UNTIL IT BOTTOMS AGAINST THE CONTACT.

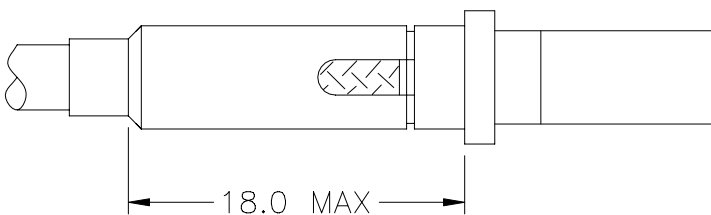
18 - CHECK THE ALIGNMENT OF THE BRAID TERMINATOR COMPARED WITH CONTACT AND CABLE.



19 - HEAT THE BRAID TERMINATOR UNTIL THE SOLDER PREFORM MELTS COMPLETELY AND FLOWS THROUGH THE HOLES.

20 - HOLD THE TERMINATOR WITH A PLIERS DURING THE INSTALLATION.

INSPECTION OF THE BRAID TERMINATION



21 - THE SOLDER PREFORM SHOULD HAVE MELTED AND WETTED TO THE BRAID STRANDS AND THE TERMINATOR TWO INSPECTION HOLES SHOULD BE VISIBLE.

TOOLING :

- HOT AIR TOOL : CV-5302+REFLECTOR PR25D OR CV-1981(POS 7)+REFLECTOR PR25D
- CONTACT HOLDING FIXTURE AD-1319-9, LOCATOR AT-1319-22
- CONTACT EXTRACTION TOOL M81969/14-06

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