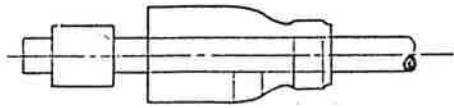


SIZE #8 DATABUS CONTACT ASSEMBLY INSTRUCTIONS

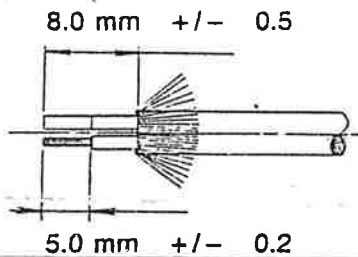
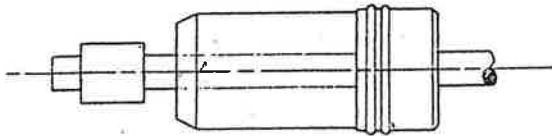
Ferrule Shrink Boot Cable



A

Slide sealing device and ferrule over cable (H/Shrink sleeve - Applicable for use on Mil-Std 1760 connectors. **Cable Grommet** - Applicable only for deployment in 38999 connectors.)

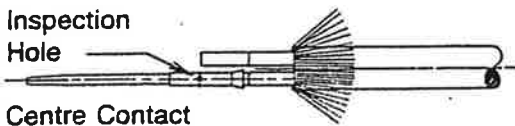
Cable Grommet



B

Remove outer sheath of cable to 8.0 mm comb out all braids evenly and fold back. Remove cable fillers from stripped length. Strip the centre contact conductor to 5.0 mm. Note: It is recommended that both intermediate and centre contact conductors are scored at the correct stripping length. The intermediate conductor insulation should not be removed until the centre contacts has been crimped.

Scored Intermediate
 Conductor Insulation



C

Crimp centre contact (Pin or Socket) onto the stripped wire using tool M22520/2-01 and crimp positioner 294GB-5049 (setting No.5 for 24 AWG) butting rear end of contact wire insulation. The conductor end should be visible in the inspection hole.

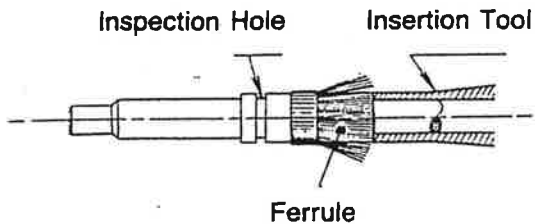
Intermediate Contact

D

Strip intermediate contact conductor to 5.0 mm. Insert centre contact into centre hole of intermediate contact assembly. At the same time insert the intermediate contact conductor into the outer hole of the intermediate contact assembly. Push firmly home until the centre contact is felt to snap into place and ensure that the insulation of each conductor is fully inserted into the intermediate contact insulator. The intermediate conductor should be visible in the inspection hole in the intermediate contact. There should be no loose cable strands visible. Crimp the intermediate contact assembly using the appropriate cavity of crimp jaw 294GB-5050 fitted into M22520/5-01 tool.

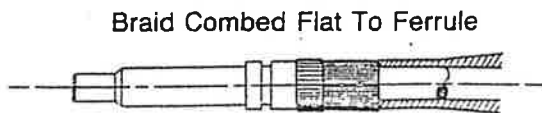
Intermediate Contact
 Insulator

ISSUE	1				
DATE	16.3.90				
SIG					



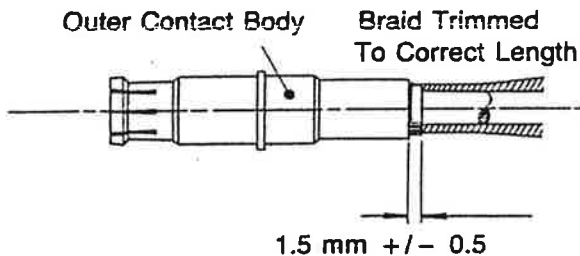
E

Slide the ferrule forward under the braid to trap the braid against the rear of the intermediate contact insulator, for all succeeding operations keep the ferrule firmly against the rear of the insulator using a suitable tool.



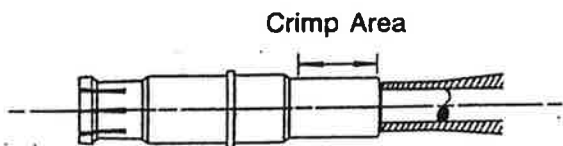
F

Comb the braid back evenly and flatten it onto the ferrule.



G

Slide the outer contact body over the intermediate contact assembly and ferrule until approximately 1.5 mm of the ferrule is visible. Trim off the excess braid using the rear of the outer contact body as a guide. Ensure that there are no loose braid clippings at the rear of the ferrule.



H

Place the outer contact body into the hexagonal cavity of the crimp jaws 294GB-5050. Slide the intermediate contact assembly and ferrule tool. The rear of the ferrule should be 0.5 mm + 0.5 mm to the rear of the outer contact body when fully inserted. Complete the hexagonal crimp.