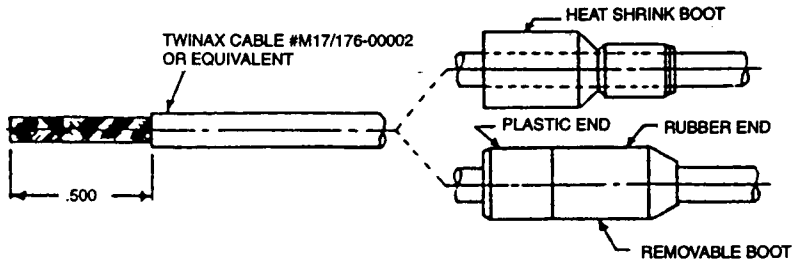
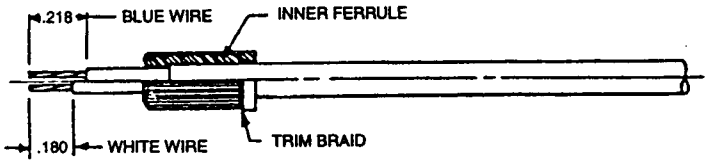
# ASSEMBLY INSTRUCTIONS FOR
# T3-46T08-LD PIN & T3-47T08-LD SOCKET TWINAX CONTACTS

FIG.1



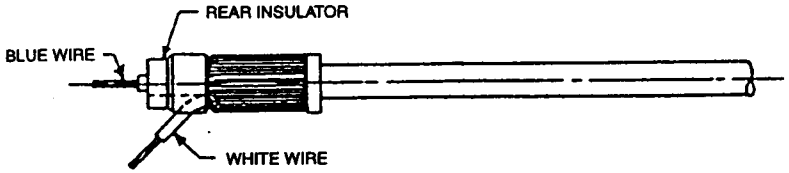

1. SLIDE HEAT SHRINK BOOT (SUPPLIED WITH CONTACT) OR REMOVABLE BOOT (SUPPLIED WITH CONNECTOR) ONTO CABLE AS SHOWN. DISCARD HEAT SHRINK BOOT WHEN USING REMOVABLE BOOT.
2. STRIP OUTER JACKET TO DIMENSION SHOWN (.500). MAKE CUT SQUARE AND SHARP, BEING CAREFUL NOT TO NICK BRAID.

FIG.2




1. SLIDE INNER FERRULE OVER BRAID UNTIL OUTER JACKET TOUCHES INNER SHOULDER OF FERRULE.
2. COMB OUT BRAID AND FOLD BRAID BACK OVER INNER FERRULE. TRIM EXCESS BRAID EVEN WITH SHOULDER.
3. STRIP INNER WIRES AS SHOWN (.218 BLUE WIRE & .180 WHITE WIRE). MAKE CUTS SQUARE AND SHARP, BEING CAREFUL NOT TO NICK CONDUCTORS.

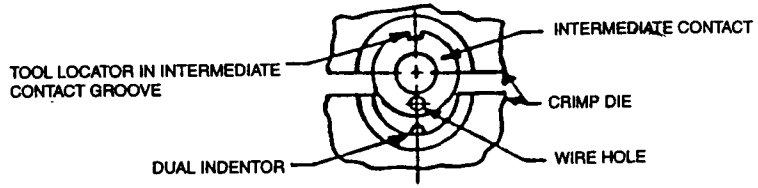
FIG.3




1. BEND WHITE WIRE OUTWARD AND INSTALL BLUE WIRE THRU CENTER HOLE OF REAR INSULATOR.

**TABLE I**

| | CENTER CONTACT TOOLING | | INTERMEDIATE CONTACT TOOLING | | OUTER CRIMP SLEEVE TOOLING | |
|---|---|---|---|---|---|---|
| | Basic Crimping Tool | Contact Positioner | Basic Crimping Tool | Die Part Number | Basic Crimping Tool | Die Part Number |
| Military Part No. | M22520/2-01 | None | M22520/5-01 | None | M22520/5-01 | None |
| Daniels Part No. | | K709 | | Y631 | | Y631 |




(Pyle-National) Form No. PN-430 3/94

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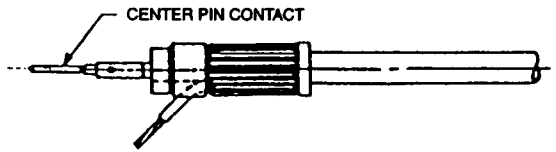
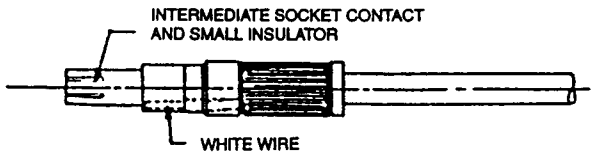
FIG 4A



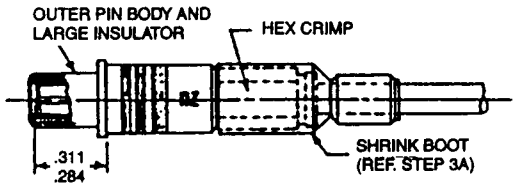

1. SLIDE CENTER PIN CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER PIN CONTACT TO BLUE WIRE USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG 5A




1. SLIDE INTERMEDIATE SOCKET CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER PIN CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

FIG 6A

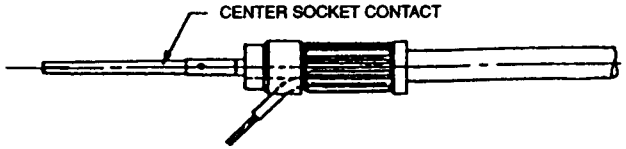



1. SLIDE OUTER PIN BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE SOCKET CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, CENTER PIN CONTACT MUST BE LOCATED WITHIN DIMENSIONS SHOWN.

3A. SLIDE HEAT SHRINK BOOT OVER CRIMPED PORTION OF CONTACT AND APPLY HEAT TO SHRINK BOOT ONTO CONTACT AND CABLE.

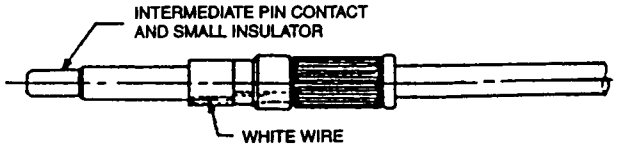
3B. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONTACT CAVITY UNTIL FIRMLY SEATED.

FIG 4B



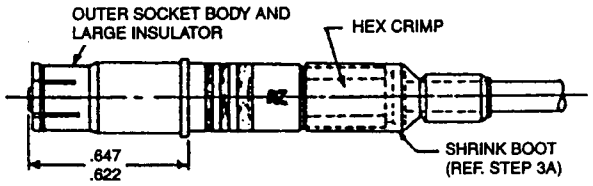

1. SLIDE CENTER SOCKET CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER SOCKET CONTACT TO BLUE WIRE USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG 5B




1. SLIDE INTERMEDIATE PIN CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER SOCKET CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

FIG 6B




1. SLIDE OUTER SOCKET BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE PIN CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, INTERMEDIATE PIN CONTACT MUST BE LOCATED WITHIN DIMENSIONS SHOWN.

3A. SLIDE HEAT SHRINK BOOT OVER CRIMPED PORTION OF CONTACT AND APPLY HEAT TO SHRINK BOOT ONTO CONTACT AND CABLE.

3B. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONTACT CAVITY UNTIL FIRMLY SEATED.

Компания «ЭлектроПласт» предлагает заключение долгосрочных отношений при поставках импортных электронных компонентов на взаимовыгодных условиях!

Наши преимущества:

- Оперативные поставки широкого спектра электронных компонентов отечественного и импортного производства напрямую от производителей и с крупнейших мировых складов;
- Поставка более 17-ти миллионов наименований электронных компонентов;
- Поставка сложных, дефицитных, либо снятых с производства позиций;
- Оперативные сроки поставки под заказ (от 5 рабочих дней);
- Экспресс доставка в любую точку России;
- Техническая поддержка проекта, помощь в подборе аналогов, поставка прототипов;
- Система менеджмента качества сертифицирована по Международному стандарту ISO 9001;
- Лицензия ФСБ на осуществление работ с использованием сведений, составляющих государственную тайну;
- Поставка специализированных компонентов (Xilinx, Altera, Analog Devices, Intersil, Interpoint, Microsemi, Aeroflex, Peregrine, Syfer, Eurofarad, Texas Instrument, Miteq, Cobham, E2V, MA-COM, Hittite, Mini-Circuits,General Dynamics и др.);

Помимо этого, одним из направлений компании «ЭлектроПласт» является направление «Источники питания». Мы предлагаем Вам помощь Конструкторского отдела:

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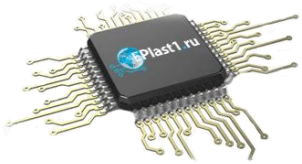
- Подбор аналогов;
- Консультации по применению компонента;
- Поставка образцов и прототипов;
- Техническая поддержка проекта;
- Защита от снятия компонента с производства.




**Как с нами связаться**

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