

Tooling required for inner conductor crimping:

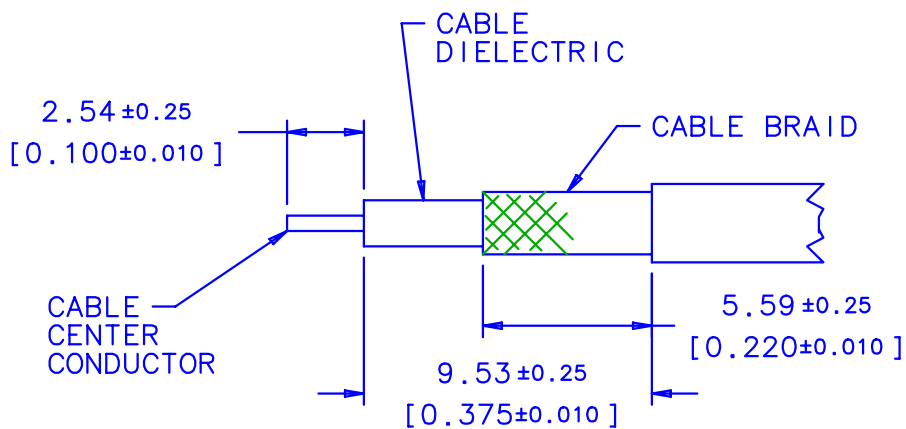
Crimp tool: AMF8 (MIL part no. M22520/2-01) or equivalent.

Positioner: T1957(K1246).

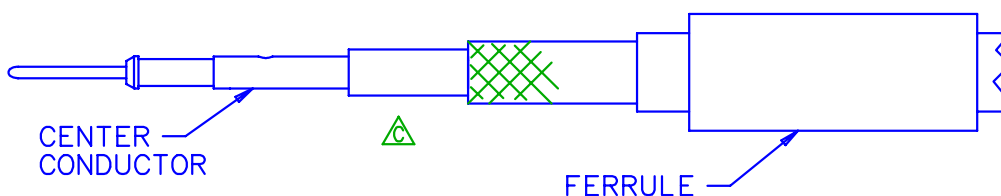
Tooling required for outer conductor crimping:

Crimp tool: HX3 (MIL part no. M22520/10-01) or equivalent.

Die set: T1958 for RG316 or T2019 for RG316DB. [E]



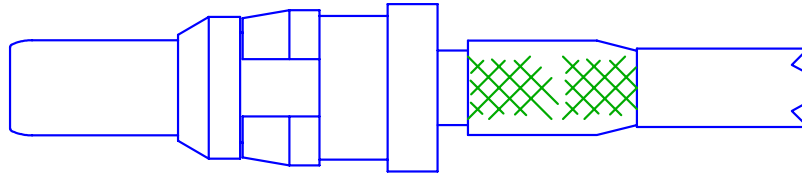
- **STEP 1:** CUT THE CABLE TO DESIRED LENGTH, AND STRIP END TO DIMENSIONS SHOWN. MAKE SURE NOT TO NICK OR CUT THROUGH THE CENTER CONDUCTOR, THE BRAID OR DIELECTRIC WHEN STRIPPING.



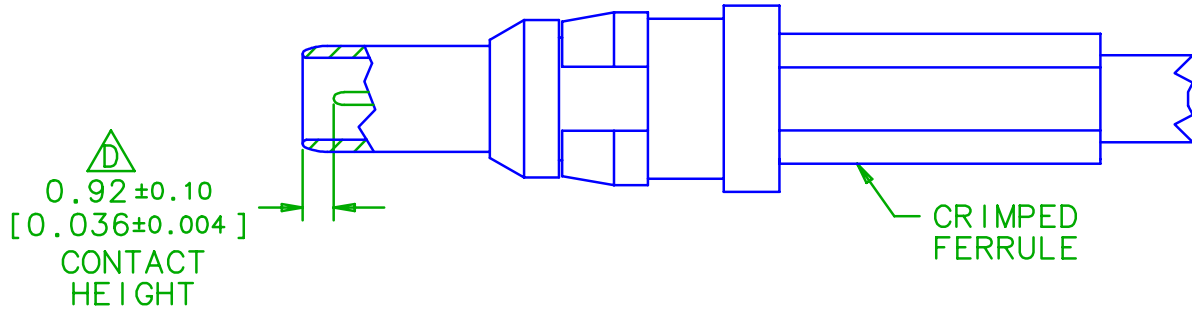
- **STEP 2:** SLIDE THE CONNECTOR CENTER CONDUCTOR ONTO THE CABLE CENTER CONDUCTOR AND BOTTOM IT AGAINST THE CABLE DIELECTRIC. CRIMP INTO PLACE USING AN AMF8 CRIMP TOOL AND POSITIONER T1957(K1246). THE CRIMP TOOL SHOULD BE SET ON

				METRIC	DRAWN: DATE	CABLE ASSEMBLY PROCEDURE FOR YCX0315-004 (CRIMP) HYPERTRONICS CORPORATION 16 BRENT DRIVE, HUDSON, MA 01749 • TEL: 978-568-0451	
E	DCR 12873	7/18/03	SP	CAGE:	FN 5/15/98		
D	DCR 11808	2/25/00	MDL	50541	CHECKED DATE		
C	DCR 11438	4/22/99	MDL				
B	DCR 11174	10/29/98	MDL	<i>This document contains proprietary information and is submitted in confidence. Submission of this document does not convey the right to reproduce, transfer, or disclose any information contained herein or to manufacture items defined except by written permission from Hypertronics corporation.</i>			
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						SHEET 1 of 2	

POSITION NUMBER 5. AFTER CRIMPING, SLIDE THE CRIMP FERRULE ONTO THE CABLE.



- STEP 3: FLARE BACK THE CABLE BRAID AND SLIDE THE CABLE AND CENTER CONDUCTOR ASSEMBLY INTO THE PIN ASSEMBLY, MAKING SURE THAT THE CONNECTOR CENTER CONDUCTOR IS ALIGNED WITH THE CONNECTOR DIELECTRIC HOLE. APPLY A SMALL AMOUNT OF FORCE TO PUSH THE CONTACT THROUGH UNTIL IT SNAPS INTO PLACE. ONCE A SNAP IS FELT, THE CENTER CONDUCTOR IS IN THE PROPER PLACE. COMB THE CABLE BRAID DOWN OVER THE SOCKET HOUSING KNURL.



- STEP 4: SLIDE THE CRIMP FERRULE OVER THE BACK END OF THE SOCKET, MAKING SURE THAT IT BOTTOMS AGAINST THE BACK FLANGE. HOLD THE CABLE FIRMLY, AND CRIMP IN PLACE USING CRIMP TOOL HX3 ALONG WITH PROPER DIE SET FOR CABLE BEING USED, CAVITY A. AFTER CABLE ATTACHMENT, THE ASSEMBLY SHOULD APPEAR AS SHOWN AND THE CONTACT HEIGHT SHOULD MEASURE AS SHOWN. [E]

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