



DEUTSCH ECD

ENGINEERED CONNECTING DEVICES

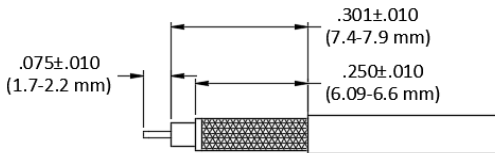
SIZE 12 COAX PIN CONTACT MIL-C-39029/102-558
DEUTSCH PART NUMBER 6162-324-1231

TERMINATION INSTRUCTIONS

TOOLS REQUIRED

OUTER CRIMP CONTACT TOOLING	
CRIMPING TOOL	DIE PART NO.
M22520/5-01	M22520/5-03

INNER CRIMP CONTACT TOOLING	
CRIMPING TOOL	DIE PART NO.
MH992	K1303S



STEP 1. SLIDE FERRULE OVER CABLE AND STRIP OUTER JACKET TO THE DIMENSIONS SHOWN. ALL CUTS TO BE SHARP AND SQUARE. IF SOLDER TERMINATION TO BE USED, TIN CENTER CONDUCTOR USING SOFT SOLDER (60/40). AVOID EXCESSIVE HEAT. DO NOT OVERTIN. **IMPORTANT: DO NOT NICK BRAID, DIELECTRIC, OR CENTER CONDUCTOR.**



STEP 2. SLIDE THE OUTER FERRULE INTO THE CABLE AS SHOWN. FLARE OF CABLE BRAID SLIGHTLY (AS ILLUSTRATED), TO FACILITATE INSERTION OF OUTER BODY. **IMPORTANT: DO NOT COMB OUT BRAID.** PLACE CONTACT ON CABLE CENTER CONDUCTOR SO THAT IT BUTTS AGAINST THE CABLE DIELECTRIC. THE CENTER CONDUCTOR SHOULD BE VISIBLE THROUGH THE INSPECTION HOLE IN THE CONTACT CRIMP CENTER CONTACT USING MH992 TOOL AND POSITIONER K1303S, OR SOFT SOLDER CONTACT TO CABLE CENTER CONDUCTOR. AVOID EXCESSIVE HEAT TO PREVENT SWELLING OF THE DIELECTRIC. DO NOT GET ANY SOLDER ON THE OUTSIDE SURFACE OF THE CONTACT.



STEP 3. INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THE INNER FERRULE SLIDES UNDER THE BRAIDING, PUSH CABLE ASSEMBLY FORWARD UNTIL THE CABLE DIELECTRIC BOTTOMS.



STEP 4. SLIDE THE OUTER FERRULE OVER THE BRAIDING AND UP AGAINST THE CONTACT BODY. CRIMP THE OUTER FERRULE USING CAVITY "A" OF THE M22520/5-03 DIE SET AND TOOL HANDLE M22520/5-01, ENSURING THAT THE CRIMP DOES NOT DISTORT THE BODY OF THE CONTACT.