

NOTE: Current production hand tools are identified by the model letter designations shown in Figure 1. See instruction sheet IS 1772-2 for crimping instructions, maintenance and inspection procedures for those tools. See instruction sheet IS 1772-3 for crimping procedure for the interchangeable dies listed.

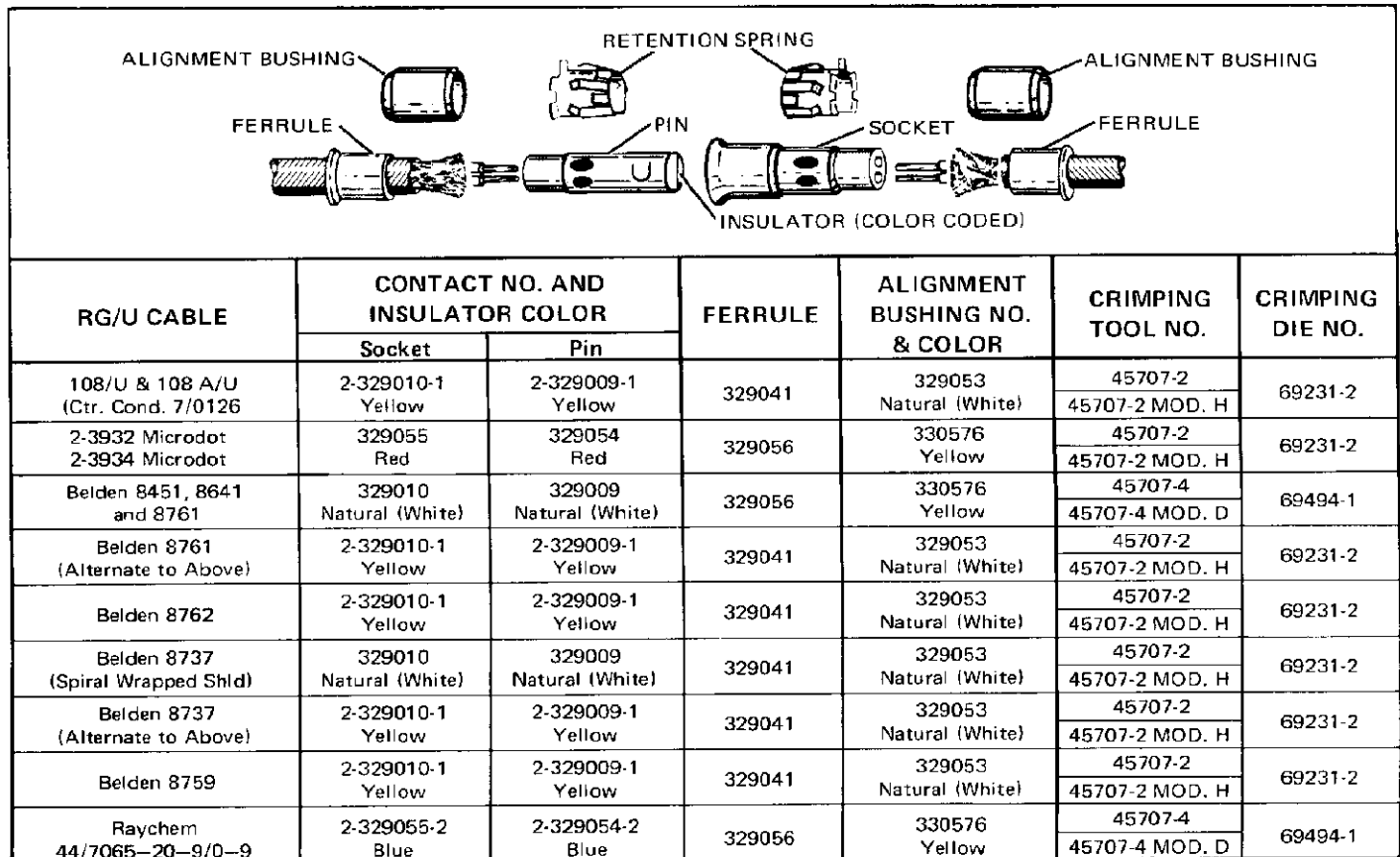


Figure 1

1. PREPARATION & ASSEMBLY (Braided Shielded Cable)

1.1 CABLE PREPARATION

- Slide braid ferrule, "folded" end first, over cable as shown in Figure 2.
- Strip cable to dimensions specified in Figure 2.

1.2 ASSEMBLY PROCEDURE

- Hold cable and rotate conductors to flare braid as shown in Figure 3.
- Insert conductors into contact wire barrel as far as they will go. Braid passes over and around support sleeve on contact. See Figure 3.

NOTE: Contacts have numbers 1 and 2 formed on ends of inner insulator. This feature permits polarization of conductors. Wire barrel crimping ports of corresponding size can also be used for this purpose. See Figure 3.

- Slide braid ferrule forward and over braid until ferrule is even with shoulder on contact. See Figure 3.
DO NOT PUSH END OF FERRULE PAST THE SHOULDER OF CONTACT.
- Assembly is ready to be crimped.

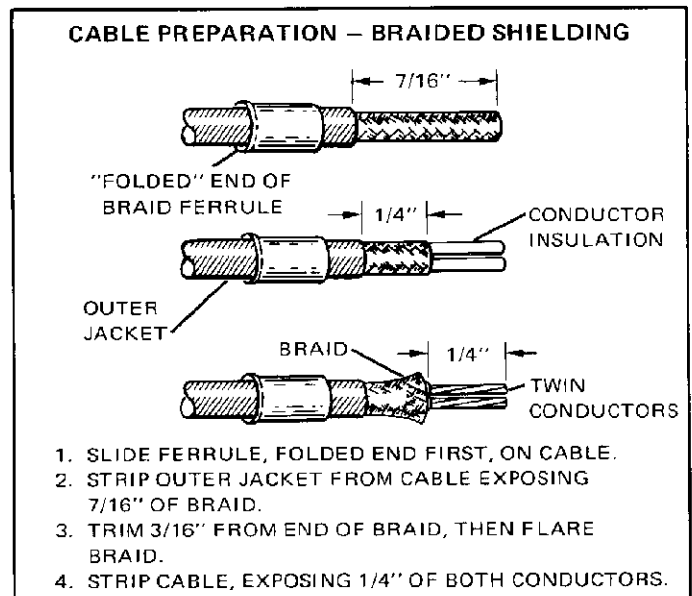


Figure 2

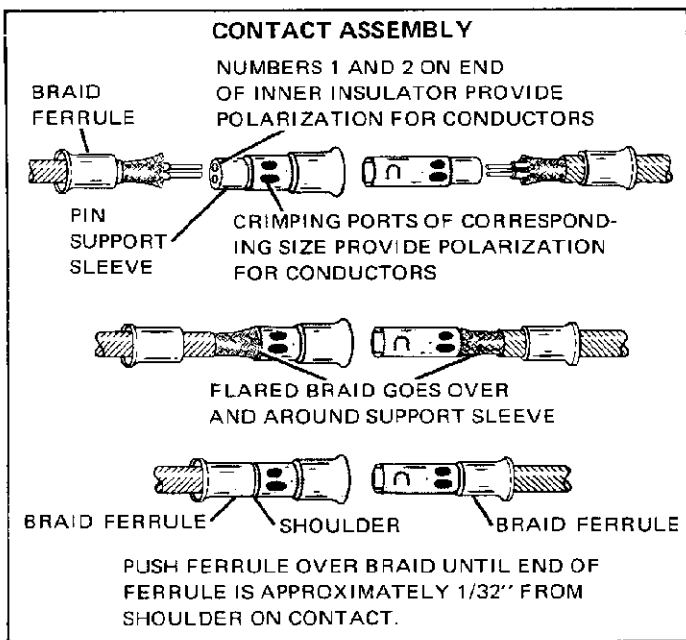


Figure 3

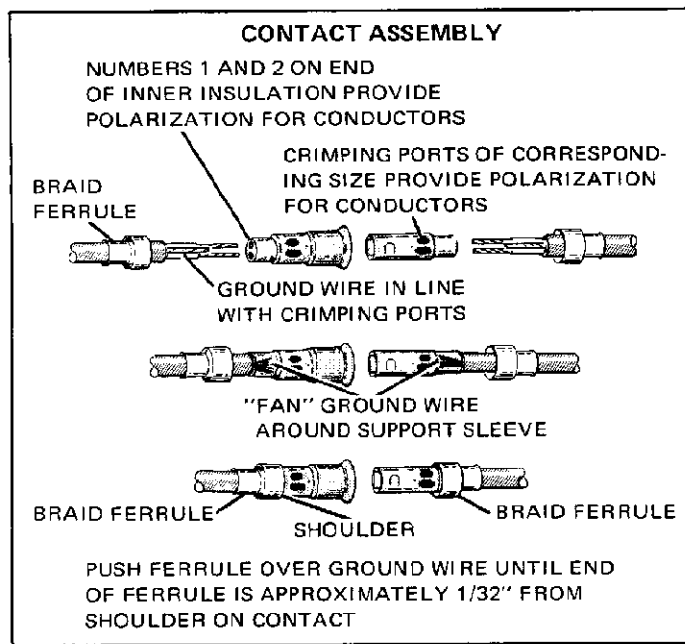


Figure 5

2. PREPARATION & ASSEMBLY (Non-braided Shielded Cable)

2.1 CABLE PREPARATION

- Slide ferrule on cable, small end first.
- Strip cable to dimensions specified in Figure 4.
- Trim off foil shielding back against outer jacket.

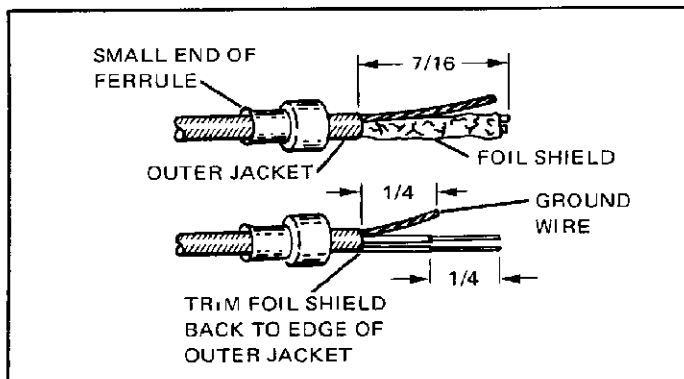


Figure 4

2.2 ASSEMBLY PROCEDURE

- Insert conductors into contact wire barrels as far as they will go. (Contacts have numbers 1 and 2 formed on ends of inner insulator. This feature permits polarization of conductors. Wire barrel crimping ports of corresponding size can also be used for this purpose. See Figure 5.)
- Fan ground wire around support sleeve on contact.
NOTE: *Ground wire should always be located in line with crimping ports.*
- Slide ferrule forward over ground wire and contact support sleeve until ferrule is even with shoulder on contact. See Figure 5.
- Assembly is ready to be crimped.

3. CRIMPING PROCEDURE

After contacts have been assembled on wire, they can be crimped by hand tools or interchangeable dies in the appropriate tool. As noted on page 1, refer to IS 1772-2 for instructions on the use of current production hand tools. See IS 1772-3 for procedure to use interchangeable dies.

4. ATTACHING RETENTION SPRING

- Retention springs are attached to contacts after contacts are crimped, but before they are inserted into connector housing. These parts not only retain contacts in connector cavities but hold them in correct alignment. Although retention springs can be used on any twin COAXICON contact, specific use will depend upon connector housing. Refer to Figure 6 for selection of springs.

4.1 SPRINGS NO. 51413-1 & 51413-3

- Begin assembly by spreading front corners of spring over contact into the two LARGE crimping ports. See Figure 7.
- Snap spring downward over contact. Holding lugs (indents) on retention spring must fit into LARGE crimping ports.

RETENTION SPRING NUMBER	WHERE USED	CONTACT EXTRACTION TOOL NO.
329042	12 POS. CONNECTOR	305141-2
51413-3	10 POS. CONNECTOR	305141-4
	8 POS. SERIES "W" CONNECTOR	
51413-1	10 POS. "T" CONN.	

Figure 6

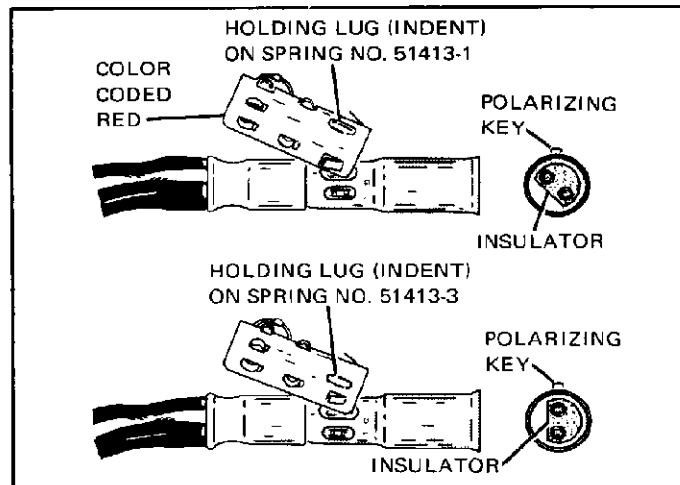


Figure 7

- (c) Insulators will appear at an angle when spring No. 51413-1 is properly assembled (for use in 10 position "T" connector). See Figure 7.
- (d) Insulators will be in alignment with key when spring No. 51413-3 is properly assembled (for use in 10 position connector and 8 position series "W" connectors).

4.2 SPRING NO. 329042

- (a) Place open side of spring against section containing large crimping ports. See Figure 8.
- (b) Push spring down so that it spreads slightly and snaps over contact, then rotate it until indents fit into large crimping ports on contact.
- (c) Spring should fit firmly against contact.

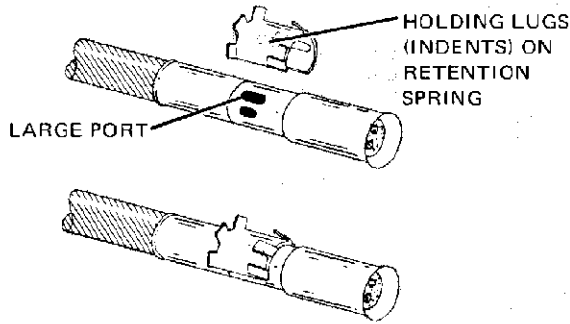


Figure 8

4.2.1 Attaching Alignment Bushing

NOTE: Alignment bushings are used only on contacts with retention spring No. 329042.

- (a) Alignment bushing should be positioned as shown in Figure 9 before attaching it to contact.
- (b) Place section of bushing containing slot against crimped ferrule.
- (c) Push bushing down until it spreads open and slides over ferrule.

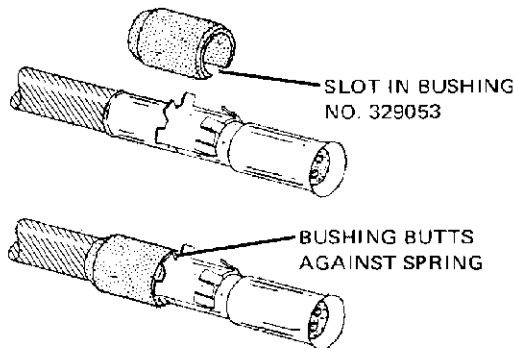


Figure 9

- (d) Bushing must butt against retention spring. See Figure 9.
- (e) Bushing No. 330576 (yellow) has tab protruding from end. Tab fits into open side of retention spring. See Figure 9.

5. INSERTION & EXTRACTION INSTRUCTIONS

Insert contacts into cavity in housing as shown in Figure 10. To extract contacts from housing, use tool as shown in Figure 11. Extraction tool part numbers are listed in Figure 6.

Extract contacts in the following manner:

- (a) Place end of tool over end of contact. See Figure 11.
- (b) Push sleeve into cavity as far as it will go. Note that push rod button will "back out" of handle when tip of contact is engaged.
- (c) Rotate handle several times.
- (d) Hold handle down firmly with thumb and forefinger and push button with palm of hand.
- (e) As button is pressed down, contact will be ejected.

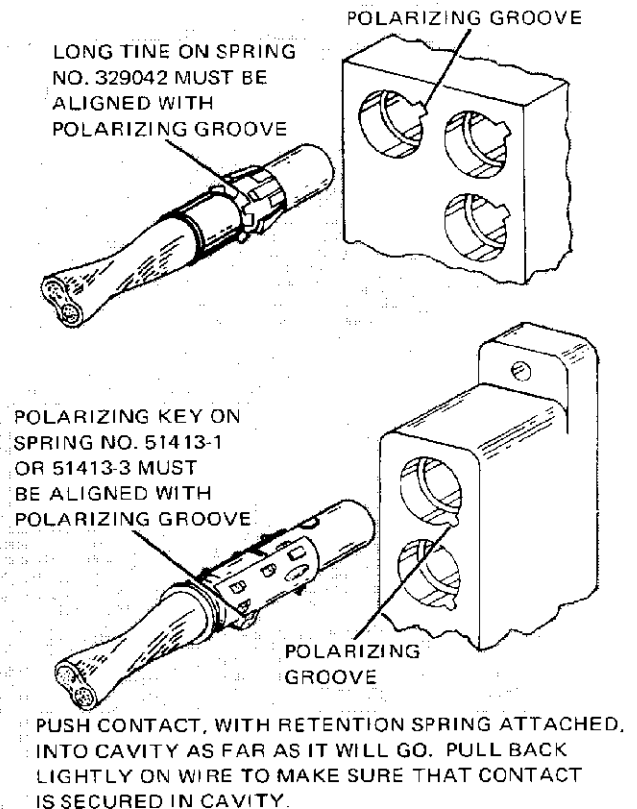
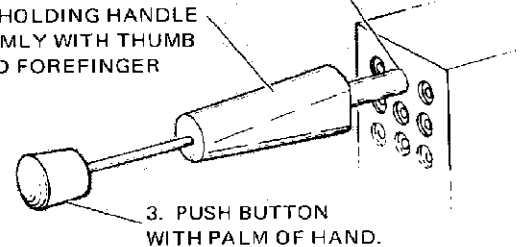


Figure 10

1. PUSH END OF TOOL ALL THE WAY INTO CAVITY. ROTATE TOOL SEVERAL TIMES.

2. KEEP END OF TOOL BOTTOMED IN CAVITY BY HOLDING HANDLE FIRMLY WITH THUMB AND FOREFINGER



3. PUSH BUTTON WITH PALM OF HAND.

Figure 11