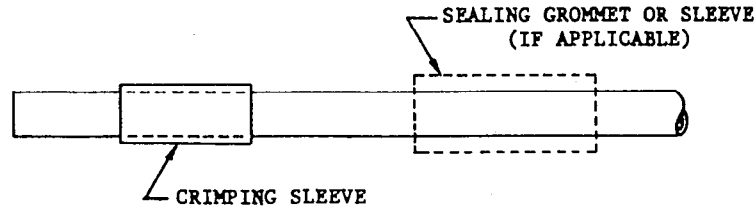


ASSEMBLY PROCEDURE FOR DS COAXIAL CONTACTS

STEP 1 Slide the sealing grommet (basic and -9 only) or sealing sleeve (-11 and -13 only) and/or the crimping sleeve on the cable before stripping.

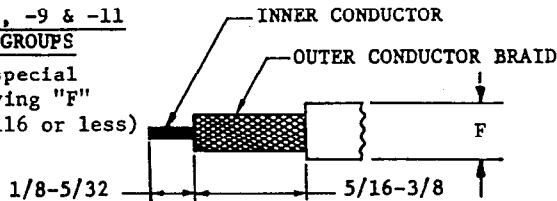
NOTE: The sealing sleeve must be installed small I.D. first. Use isopropyl alcohol to lubricate the cable and sleeve or grommet for ease of assembly.



STEP 2 Prepare the cable as shown using a hot wire stripper and surgical scissors.

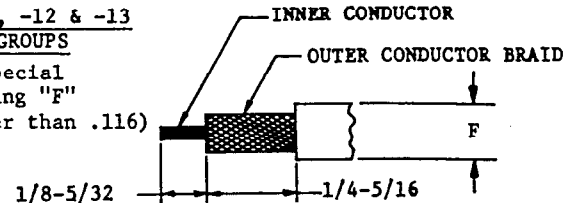
**FOR BASIC, -9 & -11
CABLE GROUPS**

(and all special cables having "F" max. of .116 or less)



**FOR -1, -5, -12 & -13
CABLE GROUPS**

(and all special cables having "F" min. greater than .116)



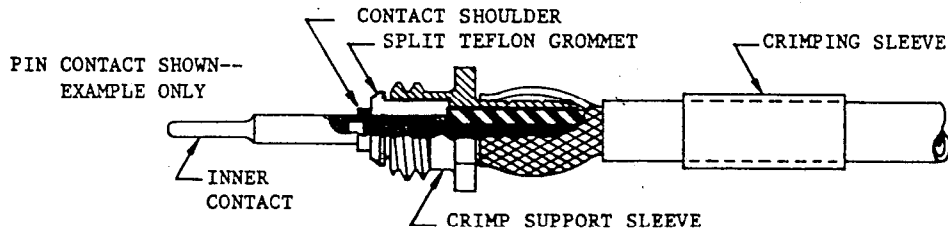
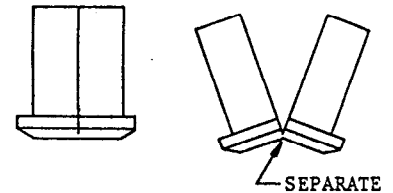
NOTE: Dielectric (under braid) to be stripped flush with end of braid.

STEP 3 Terminate the inner contact to the cable inner conductor using a 15500-25-1 crimping tool. The dielectric will butt against the end of the contact and the inner conductor will be visible in the contact inspection hole if the cable preparation and termination is properly done.

STEP 4 Place the crimp support sleeve over the dielectric and under the outer braid (see Step 5 illustration).

STEP 5 Separate the two halves of the split teflon grommet. Install one half of the grommet into the support sleeve bore, pushing the grommet half into the bore until it snaps behind the contact shoulder. Install the remaining grommet half in the same manner.

CAUTION NOTE: AFTER BOTH GROMMET HALVES ARE INSTALLED, THE CONTACT SHOULDER MUST BE FULLY EXPOSED FORWARD OF THE GROMMET HALVES.



STEP 6 Insert the terminated inner contact assembly into the threaded end of the contact outer body and tighten the outer body to the crimp support sleeve to 6 inch pounds maximum using a 13/64 open end wrench to hold the support sleeve.

IMPORTANT NOTE: DO NOT TURN CRIMP SUPPORT SLEEVE ON CABLE DURING STEP 6.

STEP 7 Push the crimping sleeve over the exposed outer conductor braid and butt against the crimp support sleeve shoulder. Use the surgical scissors to trim any braid wires which may be between the crimping sleeve and the support sleeve shoulder. Crimp the sleeve to the support sleeve using the proper crimping tool shown on information drawing 4725-1-0000.

IMPORTANT NOTE: DO NOT CRIMP SLEEVE PRIOR TO COMPLETING STEP 6. CRIMPING PRIOR TO THIS STEP MAY RESULT IN IMPROPER INNER CONDUCTOR LOCATION WHICH COULD CAUSE INTERMITTENCY DURING ACTUAL OPERATING CONDITIONS.

STEP 8 When the sealing sleeve is used (see Step 1), slide the sleeve over the crimping sleeve and against the crimp support sleeve shoulder (use isopropyl alcohol for lubrication).

STEP 9 Place the assembled contact in the proper rear insert cavity. Position the insertion tool around the crimping sleeve and against the shoulder of the support sleeve. Push gently keeping the contact, tool and cable straight until the contact snaps into place. (With some larger cables the tool is placed around the cable and against the rear of the crimping sleeve or the insertion tool may not be required at all.)

STEP 10 When the sealing grommet is used (see Step 1), slide the grommet forward into the cavity until it snaps into the rear insert of the connector (use isopropyl alcohol for lubrication).