Pin, Triaxial Contact, Size 12
Installation Instructions

A. 1. Strip cable as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. The cable must not be deformed while making the cuts.

B. 1. Assemble outer ferrule back over cable jacket.
2. Flare cable outer shield as shown.
3. Strip cable interlayer insulation and inner shield as shown.

C. 1. Assemble inner ferrule over cable interlayer and flare cable inner shield as shown.
2. Strip inner cable core insulation as shown.

D. 1. Slide inner insulator over cable inner conductor until insulator butts cable inner core.
2. Slide inner pin contact over cable inner conductor until it butts against inner insulator.
3. Cable inner conductor must be visible through the inspection hole in the inner pin contact wire well.
4. Crimp inner pin contact wire well using a M22520/2-01 crimp tool and a DANIELS K803-1 positioner.

E. 1. Slide intermediate socket contact and insulator assembly over the inner pin contact and inner insulator assembly until inner pin contact is seated in the intermediate contact insulator.
2. Form cable inner shield over intermediate socket contact and slide inner ferrule forward as shown. Observe .170 – .190 dimension.
3. Crimp intermediate contact and ferrule assembly with a DANIELS GS212 tool and a DANIELS TH553 positioner.
Crimp as follows:
Crimp once, rotate the contact assembly 45° and crimp a second time. After crimping the second time, the diameter over the shield crimp sleeve must not be greater than .095.

F. 1. Slide outer pin contact and insulator assembly over intermediate socket contact assembly until the intermediate contact is seated against the outer pin contact insulator inside shoulder as shown.

G. 1. Form cable outer shield over the outer pin contact assembly. Bring outer ferrule forward over cable outer shield and outer pin assembly.
Observe .260 – .290 dimension.
Trim excess shield ahead of the outer crimp ferrule.
2. Crimp outer ferrule and outer pin contact assembly using a DANIELS GS200-1 crimp tool and a DANIELS GP959 positioner.
Crimp as follows:
Crimp once, rotate the contact assembly 45° and crimp a second time. After crimping the second time, the diameter over the outer crimp ferrule must not be greater than .152.

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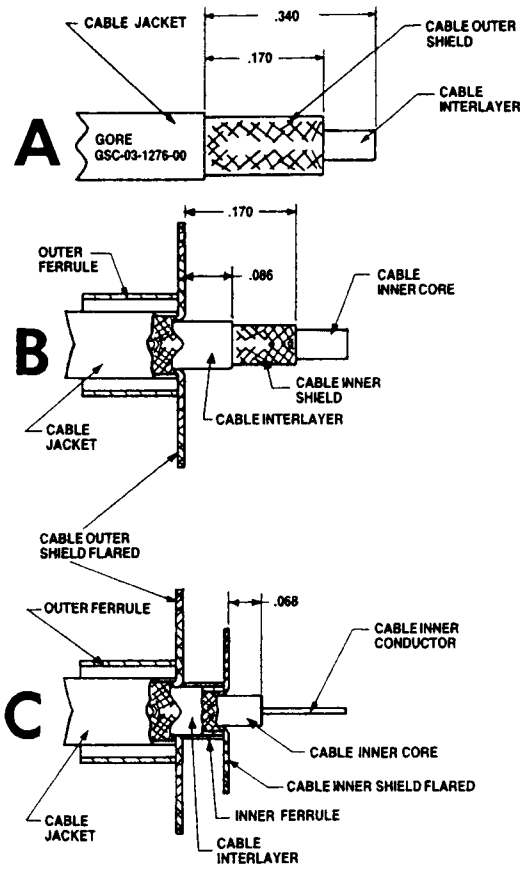

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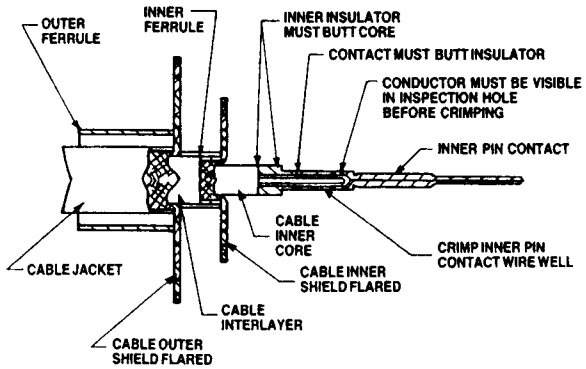
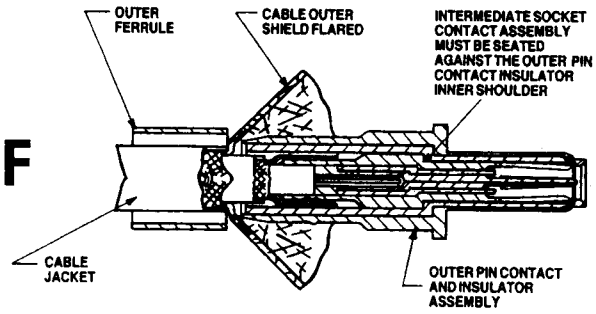
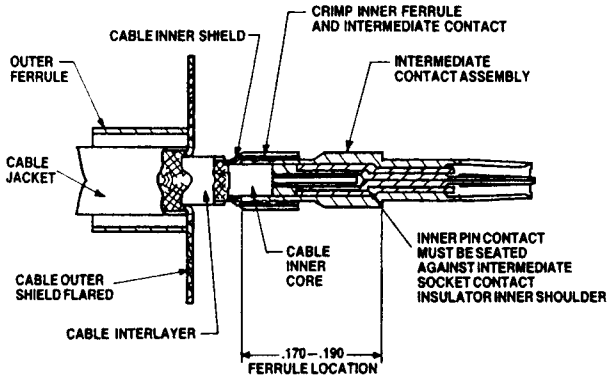

OUTER FERRULE
INNER FERRULE
INNER INSULATOR MUST BUTT CORE
CONTACT MUST BUTT INSULATOR
CONDUCTOR MUST BE VISIBLE IN INSPECTION HOLE BEFORE CRIMPING
INNER PIN CONTACT
CABLE INNER CORE
CRIMP INNER PIN CONTACT WIRE WELL
CABLE JACKET
CABLE INNER SHIELD FLARED
CABLE INTERLAYER
CABLE OUTER SHIELD FLARED

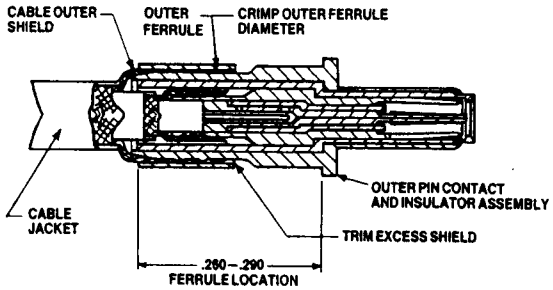
F


OUTER FERRULE
CABLE OUTER SHIELD FLARED
INTERMEDIATE SOCKET CONTACT ASSEMBLY MUST BE SEATED AGAINST THE OUTER PIN CONTACT INSULATOR INNER SHOULDER
CABLE JACKET
OUTER PIN CONTACT AND INSULATOR ASSEMBLY

E


CRIMP INNER FERRULE AND INTERMEDIATE CONTACT
CABLE INNER SHIELD
OUTER FERRULE
INTERMEDIATE CONTACT ASSEMBLY
CABLE JACKET
CABLE INNER CORE
INNER PIN CONTACT MUST BE SEATED AGAINST INTERMEDIATE SOCKET CONTACT INSULATOR INNER SHOULDER
CABLE OUTER SHIELD FLARED
CABLE INTERLAYER
.170–.190
FERRULE LOCATION

G


CABLE OUTER SHIELD
OUTER FERRULE
CRIMP OUTER FERRULE DIAMETER
CABLE JACKET
OUTER PIN CONTACT AND INSULATOR ASSEMBLY
TRIM EXCESS SHIELD
.280–.290
FERRULE LOCATION