21-033468-061 (PLUG)

Transition Adapter, Plug, Quadrax
Type High Speed, to Board,
Installation Instructions

See table on reverse side for quadrax cable recommended, tool selector settings, crimping tool and positioner information.

A 1. Cut cable for assembly of transition adapter plug.
B 1. Strip cable jacket to expose cable outer braid as illustrated. Ends must be cut cleanly and at right angles to the axial plane of the cable. Cable must not be deformed while making cuts.
2. Comb and flair exposed cable braid. Remove indicated length of inner wire bundle. Do not trim cable braid.
C 1. Bring cable braid back to cable then "bullet-nose" the front of the cable braid.
2. Slide and rotate crimp bushing, large diameter end first, over cable braid until cable jacket butts inside shoulder of crimp bushing.
D 1. Flair cable braid back over crimp bushing as illustrated to expose inner wire pairs. Trim excess cable braid.
2. Cut inner wire pairs with foils in place to dimension shown. All wires must be cut to equal length. It may be helpful to cut one wire pair to length. Then cut remaining wire pair to equal length as the first wire pair.
E 1. Strip individual differential pair foil shields and wraps as close to flaired cable braid as possible. Do not trim drain wires at this time.
2. Fold drain wires over crimp bushing & flair out to reduce build-up. Trim excess wire.
3. Strip inner wires to expose center conductors as illustrated. All wires must be stripped to equal length.
F 1. Carefully splay inner wires perpendicular to the axis of the cable as illustrated.
2. Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through the contact's wire inspection hole, to make certain conductor is properly positioned.
3. Crimp inner contact to center conductor using crimp tools listed in table on back. Repeat steps F2 and F3 until all inner contacts are crimped.

Continued on back

L-2119-FV **FSCM77820**
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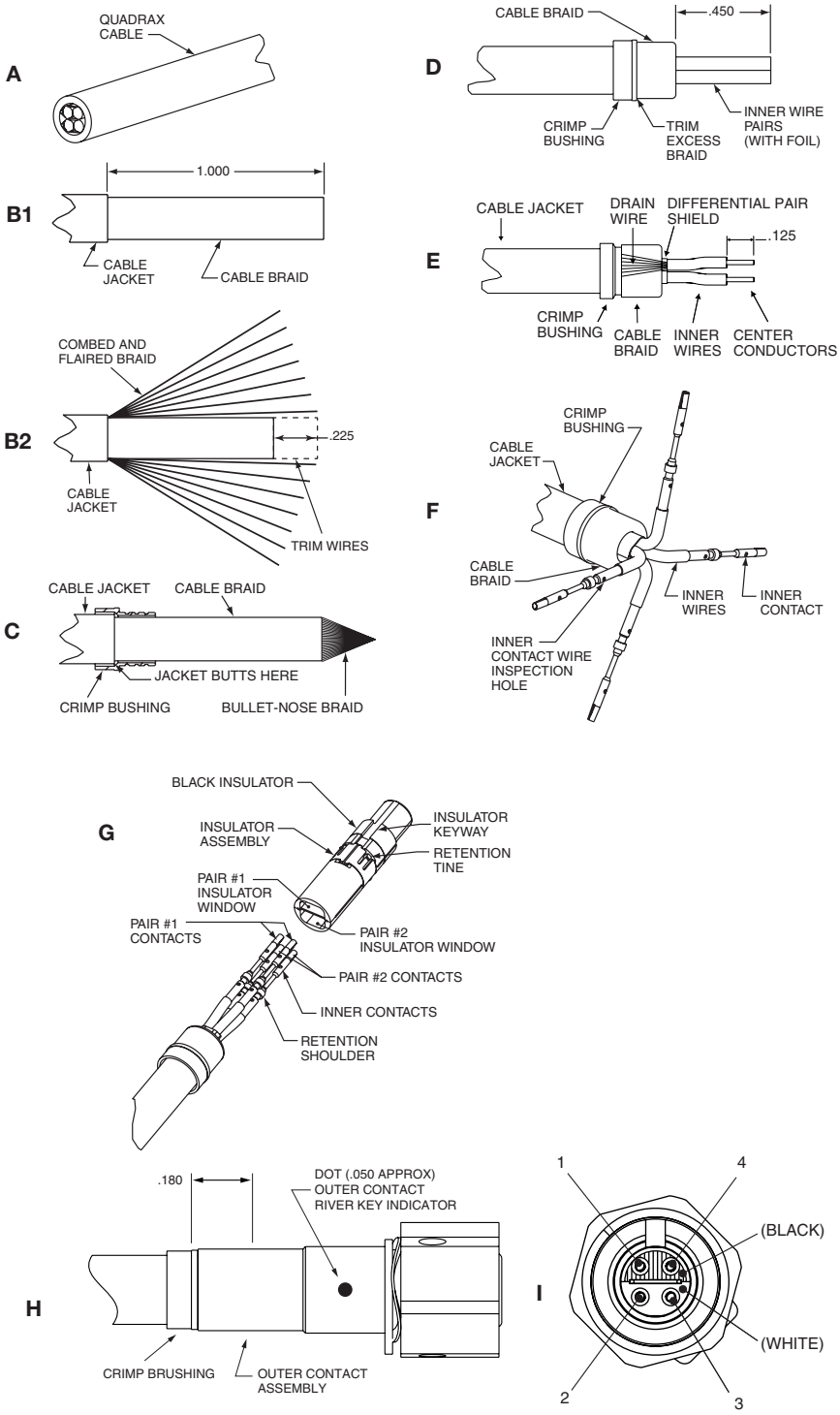
G 1. Observe the black insulator's keyway. When the inner assembly is held in the vertical position (with inner contacts on top), the inner contact with the black insulator keyway to its left will be positioned at the inner ID#1 position shown in View I.
2. With inner contacts positioned in their approximate final locations (pair #1 contacts aligned with pair #1 insulator window, pair #2 contacts aligned with pair #2 insulator window with the inner contacts approximately lined up with contact cavities), assemble front insulator over the inner contacts as shown, being careful to guide the inner contacts through the insulators. The insulator must butt the crimp ferrule, and inner contact retention shoulders must click in front of the retention tines. (Inner contacts will lock in place.)
H 1. Align black insulator keyway with the outer contact's rivet key. Slide the inner contact assembly inside the outer contact body until fully seated. Observe the mating end of the assembly to make certain inner contacts are aligned as shown in View I.
2. Crimp outer contact body in the area indicated using crimp tools listed in table below.



Amphenol Part Number	Description	Twinax Cable Recommended	Inner Crimp Tools		Outer Crimp Tools	
			Tool (Setting)	Positioner	Tool	Die Set (Location)
21-033468-061	Quadrax Transition Adapter Plug (100 Ohm)	W.L. GORE RCN 9007-24 (100 Ohm)	M22520/2-01 (4)	Daniels K1777	M22520/5-01	M22520/5-45 (A) or Daniels Y1999 (A

Amphenol Suggested Wiring		
Differential Pair	Inner ID	Wire Color
1	1	Red
	4	Blue
2	2	Yellow
	3	Green

Amphenol
Amphenol Aerospace
40-60 Delaware Avenue
Sidney, New York 13838-1395
Website: www.amphenol-aerospace.com

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2. Fold drain wires over crimp bushing & flair out to reduce build-up. Trim excess wire.
3. Strip inner wires to expose center conductors as illustrated. All wires must be stripped to equal length.

F 1. Carefully splay inner wires perpendicular to the axis of the cable as illustrated.
2. Assemble inner contact over cable center conductor until fully seated against inner wire insulation. Observe center conductor through the contact’s wire inspection hole, to make certain conductor is properly positioned.
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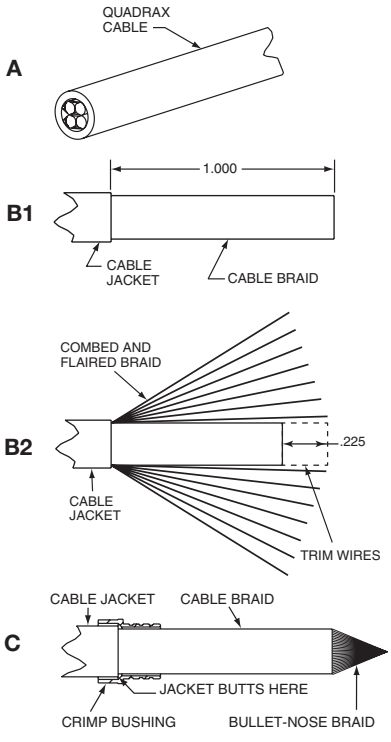

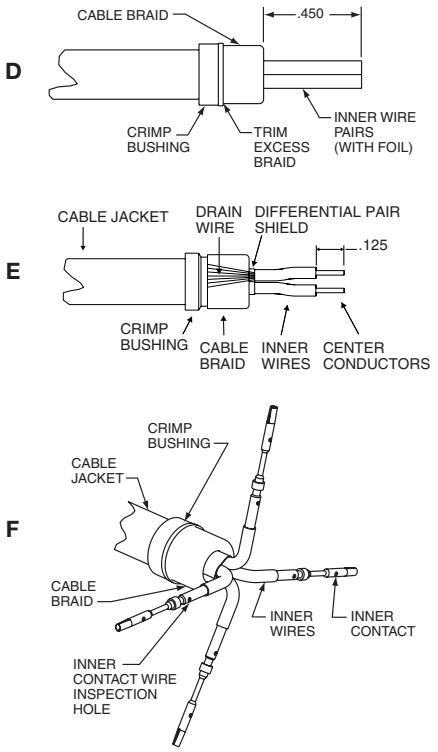

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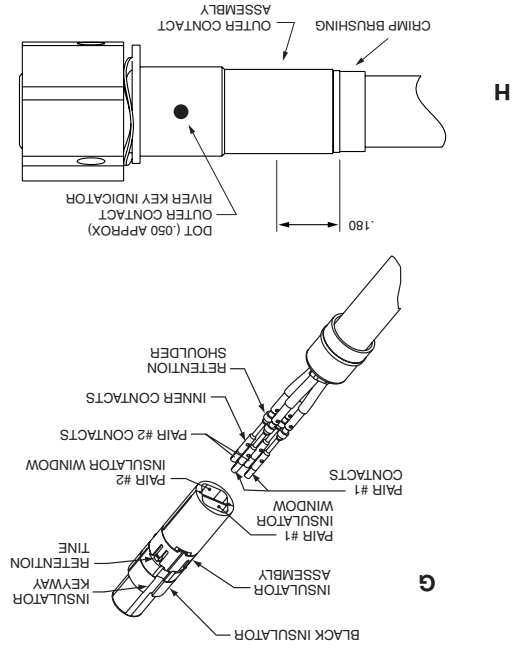

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