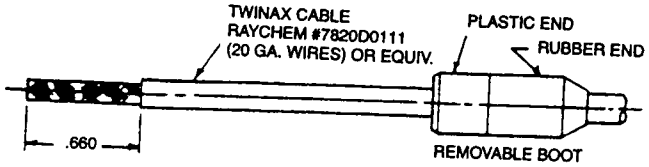
ASSEMBLY INSTRUCTIONS FOR TWINAX CONTACTS

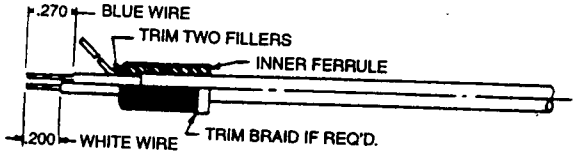
PIN	SOCKET
T3-46TA08-LD T3-46TC08-LD	T3-47TA08-LD T3-47TC08-LD

FIG.1



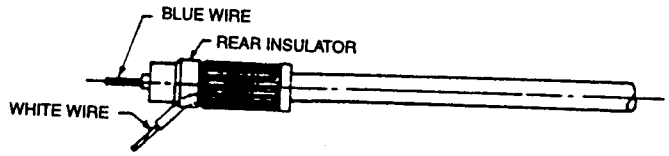
1. SLIDE REMOVABLE BOOT (SUPPLIED WITH CONNECTOR) ONTO CABLE AS SHOWN.
2. STRIP OUTER JACKET TO DIMENSION SHOWN (.660). MAKE CUT SQUARE AND SHARP, BEING CAREFUL NOT TO NICK BRAID.

FIG.2



1. SLIDE INNER FERRULE OVER BRAID UNTIL OUTER JACKET BOTTOMS AGAINST INNER SHOULDER OF FERRULE.
2. COMB OUT BRAID AND FOLD BRAID BACK OVER INNER FERRULE.
3. CUT OFF TWO FILLERS FLUSH WITH FRONT OF INNER FERRULE.
4. STRIP INNER WIRES AS SHOWN (.270 BLUE WIRE & .200 WHITE WIRE). MAKE CUTS SQUARE AND SHARP, BEING CAREFUL NOT TO NICK CONDUCTORS.

FIG.3



1. BEND WHITE WIRE OUTWARD AND INSTALL BLUE WIRE THRU CENTER HOLE OF REAR INSULATOR.

TABLE I

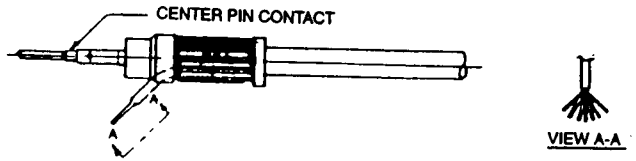
	CENTER CONTACT TOOLING		INTERMEDIATE CONTACT TOOLING and OUTER BODY CRIMP TOOLING	
	Basic Crimping Tool	Contact Positioner	Basic Crimping Tool	Crimp Die
Military Part No.	M22520/2-01	None	M22520/5-01	None
Daniels Part No.		K809		Y758

(Pyle-National) Form No. PN-537 3/94

AMPHENOL CORPORATION
Amphenol Aerospace
607-563-5011
40-60 Delaware Avenue
Sidney, New York 13838-1395

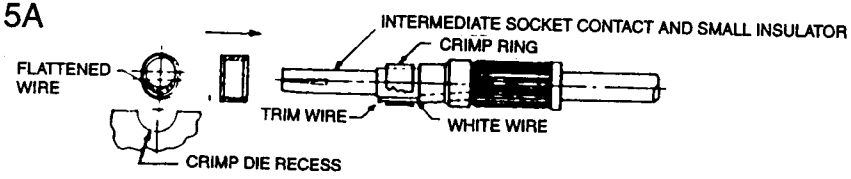
PIN CONTACT

FIG 4A



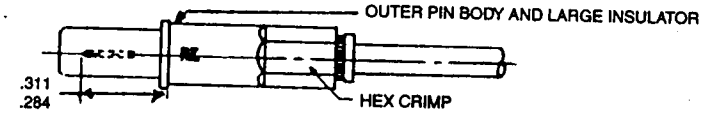
1. SLIDE CENTER PIN CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER PIN CONTACT TO BLUE WIRE USING CRIMP TOOL AND POSITIONER AS SHOWN IN TABLE I.
3. FLATTEN CONDUCTOR OF WHITE WIRE WITH TIP OF LONG NOSE PLIARS OR EQUIVALENT. (SEE VIEW A-A)

FIG 5A



1. SLIDE INTERMEDIATE SOCKET CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER PIN CONTACT.
2. LAY FLATTENED WHITE WIRE OVER BODY OF INTERMEDIATE CONTACT AND SLIDE CRIMP RING OVER WIRE. CENTRALLY LOCATE CRIMP RING ON BODY OF INTERMEDIATE CONTACT.
3. CRIMP WIRE BETWEEN CRIMP RING AND INTERMEDIATE CONTACT USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I. CONTACT TO BE LOCATED IN CRIMP DIE WITH WIRE POSITIONED IN EITHER DIE RECESS. (TOP OR BOTTOM)

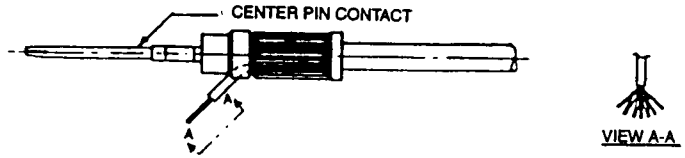
FIG 6A



1. SLIDE OUTER PIN BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE SOCKET CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, CENTER PIN CONTACT MUST BE LOCATED WITHIN DIMENSION SHOWN.
3. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONNECTOR CAVITY UNTIL FIRMLY SEATED.

SOCKET CONTACT

FIG 4B



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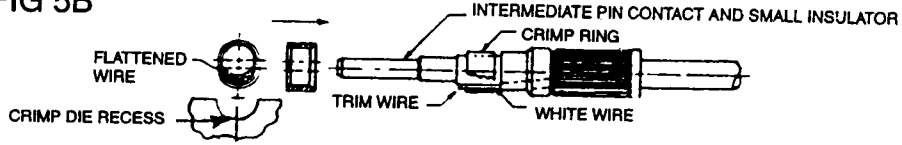
3. FLATTEN CONDUCTOR OF WHITE WIRE WITH TIP OF LONG NOSE PLIARS OR EQUIVALENT. (SEE VIEW A-A)

FIG 5B



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2. LAY FLATTENED WHITE WIRE OVER BODY OF INTERMEDIATE CONTACT AND SLIDE CRIMP RING OVER WIRE. CENTRALLY LOCATE CRIMP RING ON BODY OF INTERMEDIATE CONTACT.
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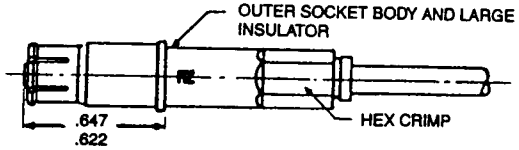
FIG 6B



1. SLIDE OUTER SOCKET BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE PIN CONTACT UNTIL FULLY BOTTOMED.
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