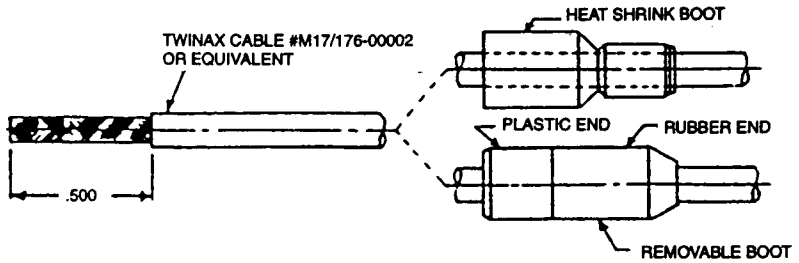
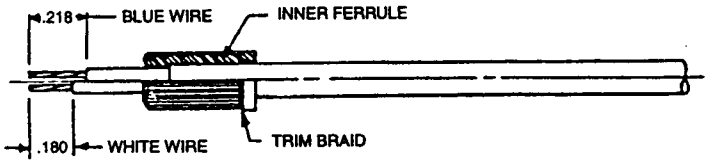
ASSEMBLY INSTRUCTIONS FOR
T3-46T08-LD PIN & T3-47T08-LD SOCKET TWINAX CONTACTS

FIG.1



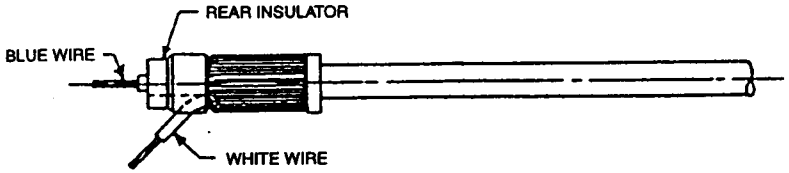
1. SLIDE HEAT SHRINK BOOT (SUPPLIED WITH CONTACT) OR REMOVABLE BOOT (SUPPLIED WITH CONNECTOR) ONTO CABLE AS SHOWN. DISCARD HEAT SHRINK BOOT WHEN USING REMOVABLE BOOT.
2. STRIP OUTER JACKET TO DIMENSION SHOWN (.500). MAKE CUT SQUARE AND SHARP, BEING CAREFUL NOT TO NICK BRAID.

FIG.2



1. SLIDE INNER FERRULE OVER BRAID UNTIL OUTER JACKET TOUCHES INNER SHOULDER OF FERRULE.
2. COMB OUT BRAID AND FOLD BRAID BACK OVER INNER FERRULE. TRIM EXCESS BRAID EVEN WITH SHOULDER.
3. STRIP INNER WIRES AS SHOWN (.218 BLUE WIRE & .180 WHITE WIRE). MAKE CUTS SQUARE AND SHARP, BEING CAREFUL NOT TO NICK CONDUCTORS.

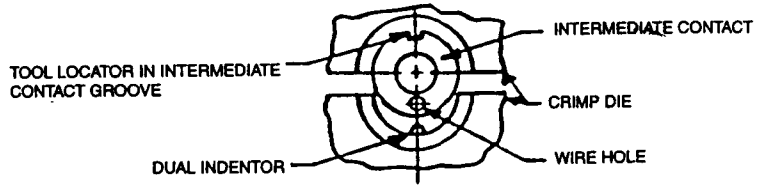
FIG.3



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

TABLE I

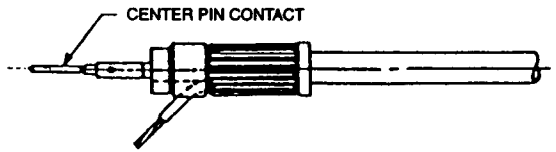
	CENTER CONTACT TOOLING		INTERMEDIATE CONTACT TOOLING		OUTER CRIMP SLEEVE TOOLING	
	Basic Crimping Tool	Contact Positioner	Basic Crimping Tool	Die Part Number	Basic Crimping Tool	Die Part Number
Military Part No.	M22520/2-01	None	M22520/5-01	None	M22520/5-01	None
Daniels Part No.		K709		Y631		Y631



(Pyle-National) Form No. PN-430 3/94

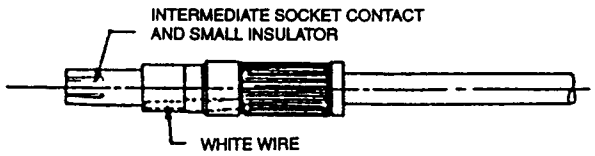
AMPHENOL CORPORATION
Amphenol Aerospace
607-563-5011
40-60 Delaware Avenue
Sidney, New York 13838-1395

FIG 4A



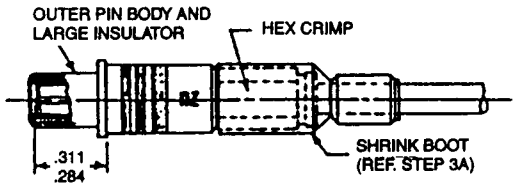
1. SLIDE CENTER PIN CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER PIN CONTACT TO BLUE WIRE USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG 5A



1. SLIDE INTERMEDIATE SOCKET CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER PIN CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

FIG 6A

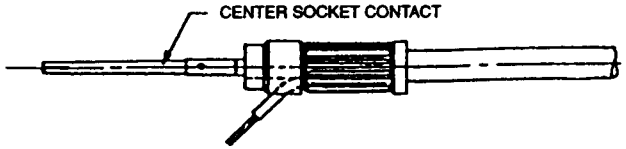


1. SLIDE OUTER PIN BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE SOCKET CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, CENTER PIN CONTACT MUST BE LOCATED WITHIN DIMENSIONS SHOWN.

3A. SLIDE HEAT SHRINK BOOT OVER CRIMPED PORTION OF CONTACT AND APPLY HEAT TO SHRINK BOOT ONTO CONTACT AND CABLE.

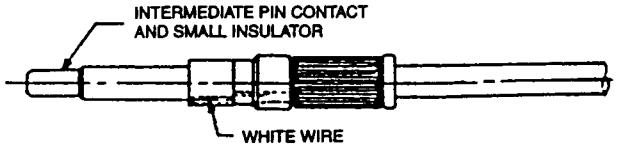
3B. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONTACT CAVITY UNTIL FIRMLY SEATED.

FIG 4B



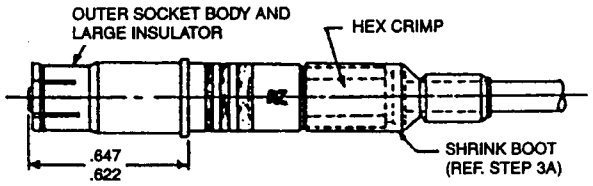
1. SLIDE CENTER SOCKET CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER SOCKET CONTACT TO BLUE WIRE USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG 5B



1. SLIDE INTERMEDIATE PIN CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER SOCKET CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

FIG 6B



1. SLIDE OUTER SOCKET BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE PIN 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, INTERMEDIATE PIN CONTACT MUST BE LOCATED WITHIN DIMENSIONS SHOWN.

3A. SLIDE HEAT SHRINK BOOT OVER CRIMPED PORTION OF CONTACT AND APPLY HEAT TO SHRINK BOOT ONTO CONTACT AND CABLE.

3B. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONTACT CAVITY UNTIL FIRMLY SEATED.

Стандарт Электрон Связь

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