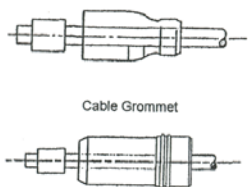


Amphenol

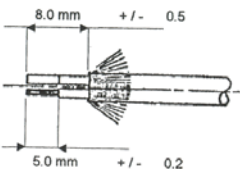
Amphenol Limited
Thanet Way, Whitstable, Kent, CT5 3JF, England.
Tel: 01227 773200 Fax: 01227 276571

SIZE #8 DATABUS CONTACT ASSEMBLY INSTRUCTIONS

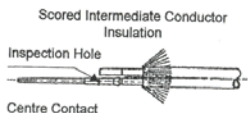
Ferrule Shrink Boot Cable A



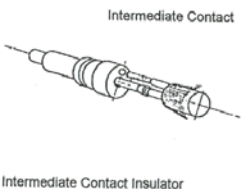
Slide sealing device and ferrule over cable.
(H/Shrink sleeve - Applicable for use on Mil-Std 1760 connectors. Cable Grommet - Applicable only for deployment in 38999 connectors.)



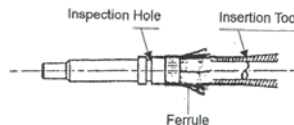
B
Remove outer sheath of cable to 8.0 mm. Comb out all braids evenly and fold back. Remove cable fillers from stripped length. Strip the centre contact conductor to 5.0 mm.
Note: It is recommended that both intermediate and centre contact conductors are scored at the correct stripping length. The intermediate conductor insulation should not be removed until the centre contact has been crimped.



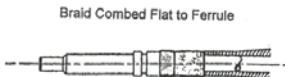
C
Scored Intermediate Conductor Insulation
Crimp centre contact, (Pin or Socket) onto the stripped wire using tool No. M22520/2-01 and crimp positioner 294GB-5049 (setting No.5 for 24 AWG), butting rear end of contact wire insulation. The conductor end should be visible in the inspection hole.



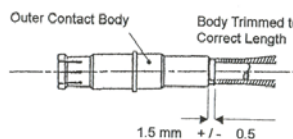
D
Strip intermediate contact conductor to 5.0 mm. Insert centre contact into centre hole of intermediate contact assembly. At the same time insert the intermediate contact conductor into the outer hole of the intermediate contact assembly. Push firmly home until the centre contact is felt firstly to snap into place and secondly to butt the intermediate insulator, ensuring that the insulation of each conductor is fully inserted into the intermediate contact insulator. The intermediate conductor should be visible in the inspection hole in the intermediate contact. There should be no loose cable strands visible. Crimp the intermediate contact assembly using the appropriate cavity of crimp jaw 294GB-5050 fitted into tool No. M22520/5-01.



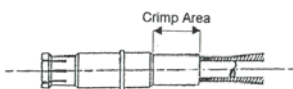
E
Slide the ferrule forward under the braid to trap the braid against the rear of the intermediate contact insulator. For all succeeding operations keep the ferrule firmly against the rear of the insulator using a suitable tool.



F
Comb the braid back evenly and flatten it onto the ferrule.



G
Slide the outer contact body over the intermediate contact assembly and ferrule until approximately 1.5 mm of the ferrule is visible. Trim off the excess braid using the rear of the outer contact body as a guide. Ensure that there are no loose braid clippings at the rear of the ferrule.



H
Place the outer contact body into the hexagonal cavity of crimp jaws 294GB-5050. Slide the intermediate contact assembly and ferrule tool. The rear of the ferrule should be 0.5 mm +/- 0.5 mm to the rear of the outer contact body when fully inserted. Complete the hexagonal crimp.

AMFORM GB-0090

ISSUE	1	2		
DATE	16.3.90	15.2.96		
SIG				