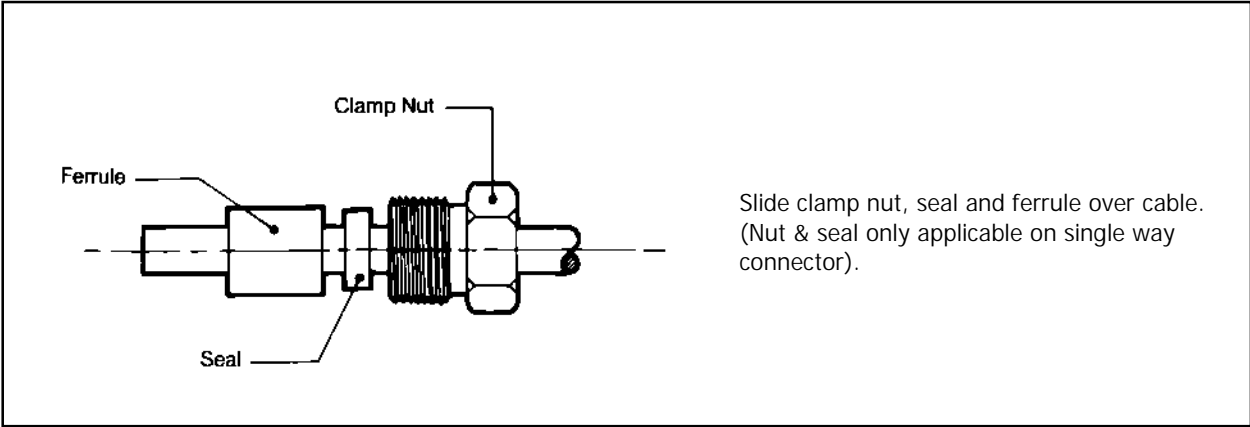
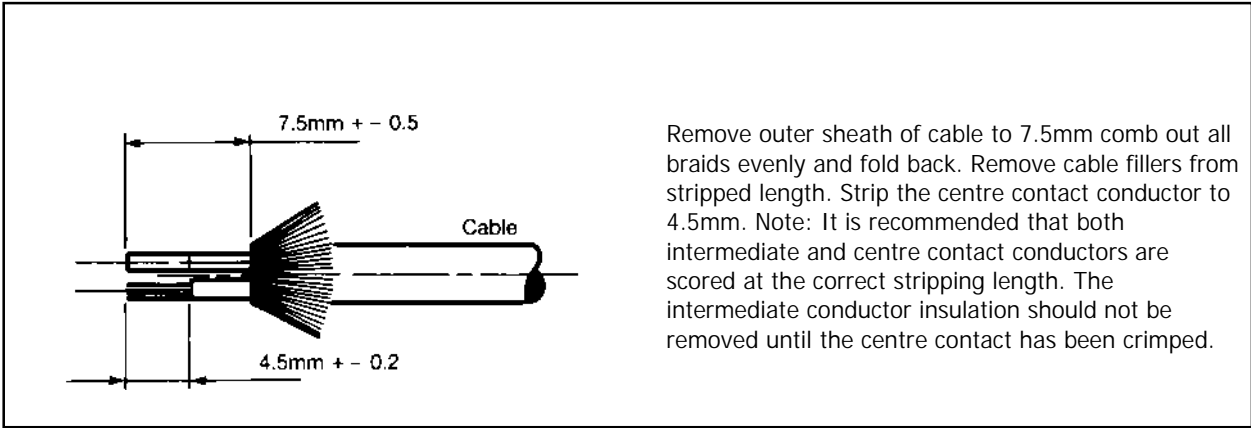


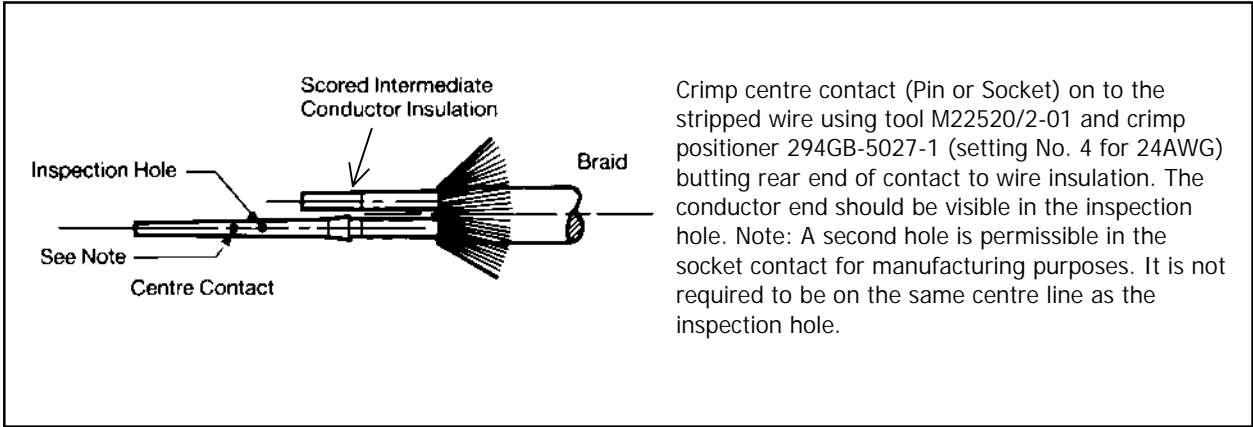
Size #10 Data Bus Contact Assembly Instructions



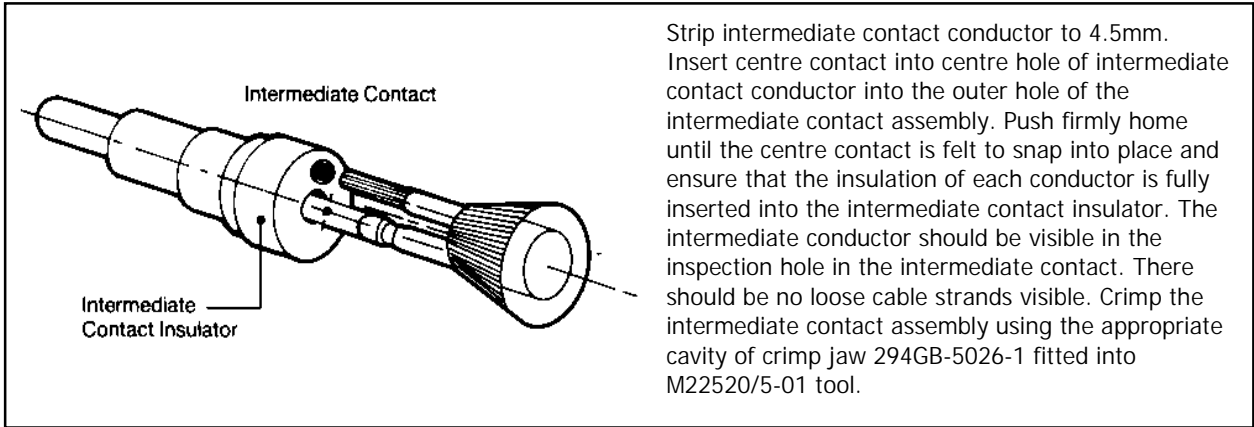
Slide clamp nut, seal and ferrule over cable. (Nut & seal only applicable on single way connector).



Remove outer sheath of cable to 7.5mm comb out all braids evenly and fold back. Remove cable fillers from stripped length. Strip the centre contact conductor to 4.5mm. 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.



Crimp centre contact (Pin or Socket) on to the stripped wire using tool M22520/2-01 and crimp positioner 294GB-5027-1 (setting No. 4 for 24AWG) butting rear end of contact to wire insulation. The conductor end should be visible in the inspection hole. Note: A second hole is permissible in the socket contact for manufacturing purposes. It is not required to be on the same centre line as the inspection hole.



Strip intermediate contact conductor to 4.5mm. Insert centre contact into centre hole of intermediate contact conductor into the outer hole of the intermediate contact assembly. Push firmly home until the centre contact is felt to snap into place and ensure 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-5026-1 fitted into M22520/5-01 tool.

