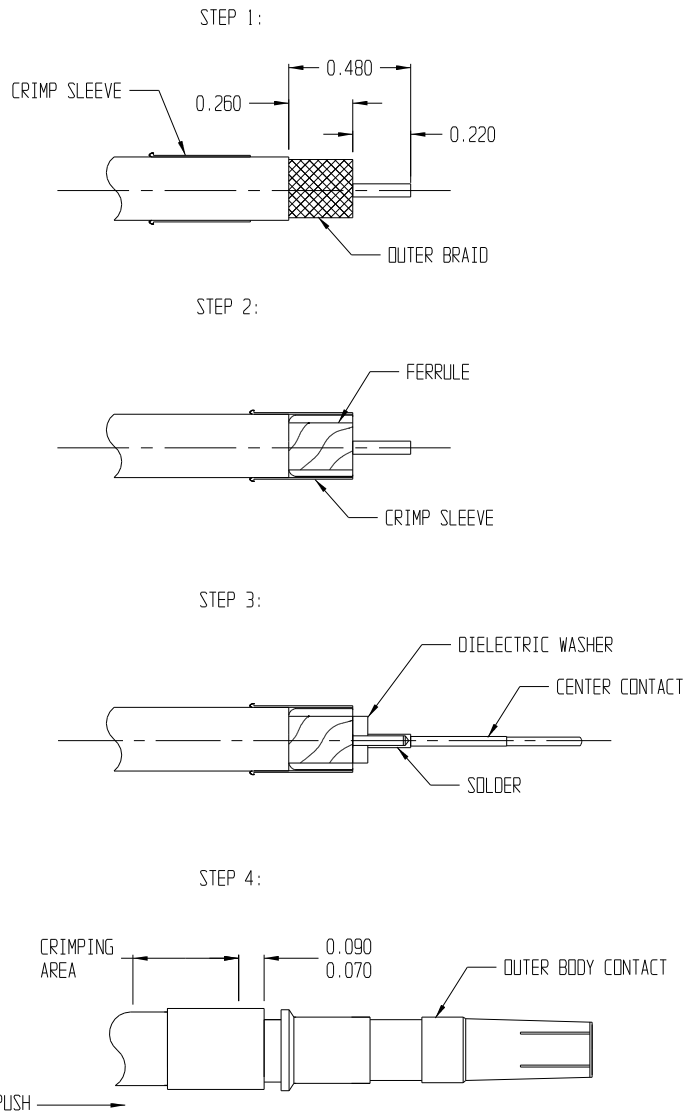


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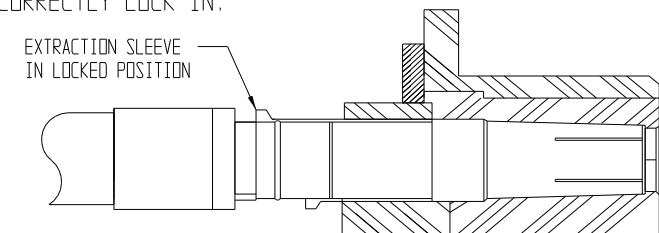
REV	REVISION	DATE	ER#	INTL
A	ADD A65225-1 TO TITLE BLOCK	08/21/2007	7502	VML

ES-105-39 CONTACT TERMINATION INSTRUCTIONS



- 1.) SLIDE ON LABELS AND ATUM HEAT SHRINK. SLIDE CRIMP SLEEVE OVER OUTER JACKET WITH THE LARGER END (INNER DIAMETER) TOWARD END OF CABLE. TRIM CABLE PER DIMENSIONS IN STEP 1.
- 2.) FLARE OUTER BRAID AND SLIDE FERRULE UNDER OUTER BRAID OVER ALUMINUM SHIELD. PUSH FERRULE UNTIL IT BUTTS AGAINST THE BRAID AND JACKET. PUSH CRIMP SLEEVE UNTIL IT BUTTS AGAINST THE FERRULE. SEE STEP 2.
- 3.) SLIDE DIELECTRIC WASHER OVER CENTER CONDUCTOR. INTRODUCE CENTER CONDUCTOR INTO CENTER CONTACT, THEN SOLDER.
- 4.) PUSH CABLE SUBASSEMBLY INTO BODY CONTACT. CRIMP THE OUTER BODY CONTACT BARREL IN THE INDICATED CRIMPING AREA. DURING THE CRIMPING OPERATION, PUSH ON THE CABLE SUBASSEMBLY. CRIMPING TOOL: M22520/5-01 DIE: M22520/5-41 HEXAGONAL DIE CLOSURE A (0.290 ON FLATS).

CONTACT INSTALLATION:
NO TOOL REQUIRED. BE SURE THE EXTRACTING SLEEVE IS IN THE LOCKED POSITION. INSERT THE ASSEMBLED CONTACT INTO THE ASSIGNED CAVITY. PUSH ON THE CRIMPING BARREL TO CORRECTLY LOCK IN.



CONTACT REMOVAL: PUSH ON THE EXTRACTION SLEEVE UNTIL THE EXTRACTION SLEEVE MEETS THE CONTACT RETENTION SHOULDER AND OPENS THE RETENTION LANCES. THEN PULL ON THE CRIMPING BARREL TO GET THE ASSEMBLED CONTACT OUT.

DATE 05/26/2005	EMTEQ 5349 S. EMMER DRIVE NEW BERLIN, WI 53151 (888) 679-6170	CONTACT TERMINATION INSTRUCTIONS FOR A65225-1 AND A65240-1 SIZE 5 CONTACT	SHT 1 OF 1
DRAWN L. LUGO			
DESIGNED			FILE: ES-105-39.prt
CHECKED T. FORST 08/21/2007			
APPROVED B. KOJIS 08/21/2007	CAGE CODE 06WH3	DWG # ES-105-39	