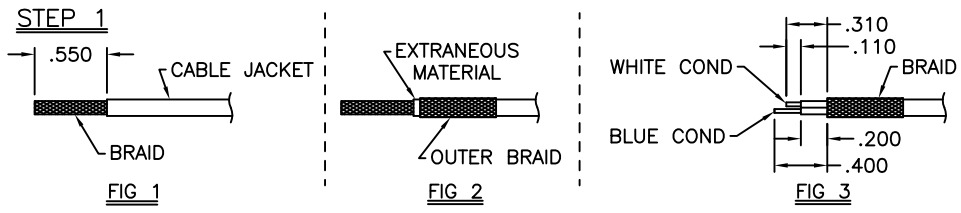
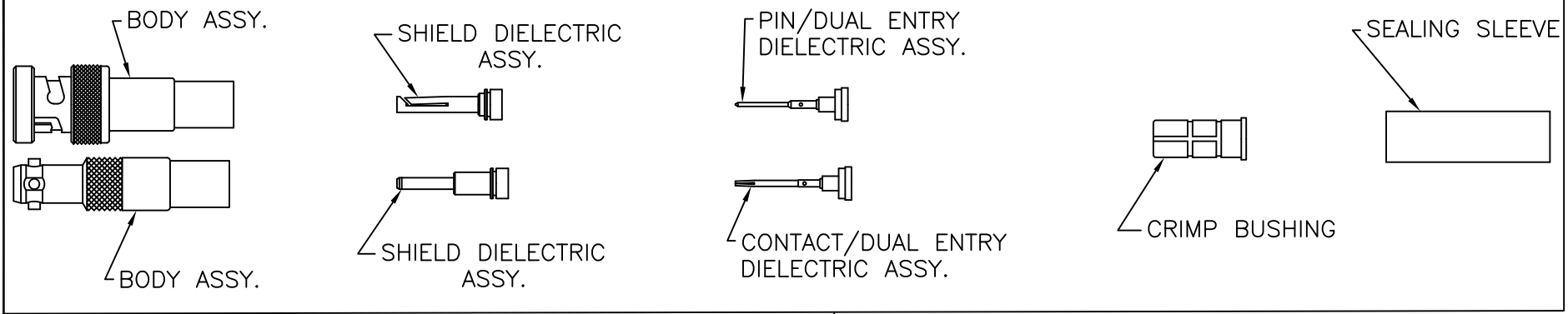
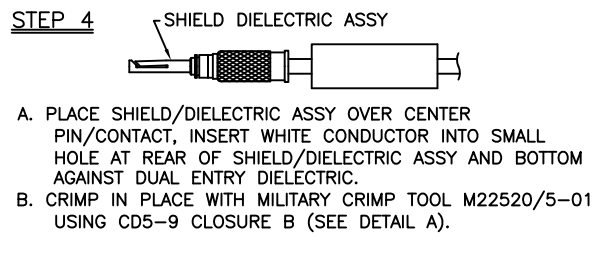


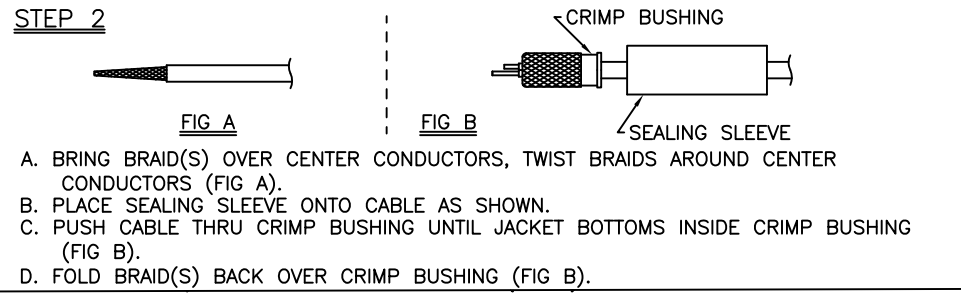
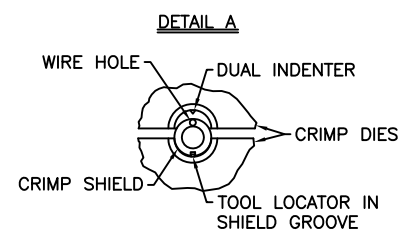
REV	ECO	DATE
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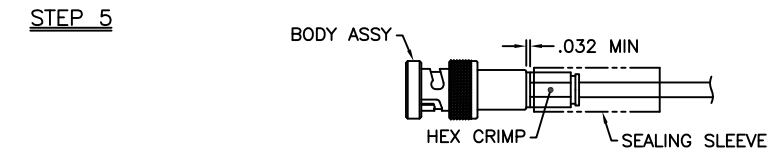
- STEP 1**
- REMOVE CABLE JACKET TO RECOMMENDED DIM SHOWN (FIG 1), FOR DOUBLE SHIELDED OR QUADRAX CABLE FOLD BACK OUTER BRAID AND REMOVE EXTRANEOUS MATERIAL (MYLAR, MU-METAL, ETC.) AS FAR BACK AS POSSIBLE (FIG 2).
 - COMB BACK BRAID(S) AND FOLD BACK OVER OUTER JACKET (FIG 3).
 - STRIP CENTER CONDUCTORS TO RECOMMENDED DIM AS SHOWN (FIG 3), LIGHTLY TIN CENTER CONDUCTORS (RECOMMENDED).



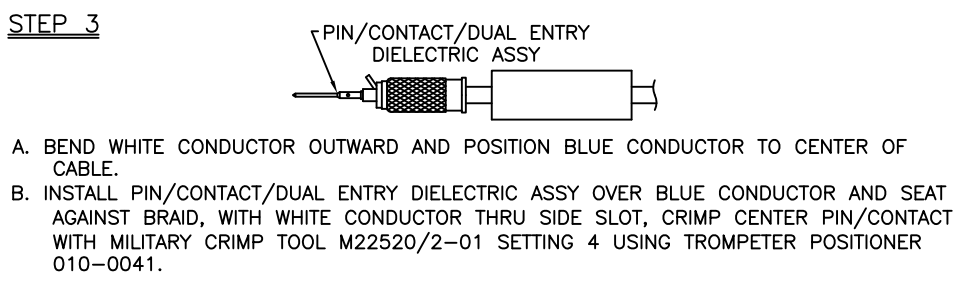
- STEP 4**
- PLACE SHIELD/DIELECTRIC ASSY OVER CENTER PIN/CONTACT, INSERT WHITE CONDUCTOR INTO SMALL HOLE AT REAR OF SHIELD/DIELECTRIC ASSY AND BOTTOM AGAINST DUAL ENTRY DIELECTRIC.
 - CRIMP IN PLACE WITH MILITARY CRIMP TOOL M22520/5-01 USING CD5-9 CLOSURE B (SEE DETAIL A).



- STEP 2**
- BRING BRAID(S) OVER CENTER CONDUCTORS, TWIST BRAIDS AROUND CENTER CONDUCTORS (FIG A).
 - PLACE SEALING SLEEVE ONTO CABLE AS SHOWN.
 - PUSH CABLE THRU CRIMP BUSHING UNTIL JACKET BOTTOMS INSIDE CRIMP BUSHING (FIG B).
 - FOLD BRAID(S) BACK OVER CRIMP BUSHING (FIG B).



- STEP 5**
- PUSH ASSEMBLY INTO BODY ASSEMBLY UNTIL BOTTOMED, VERIFY THAT PIN/CONTACT IS CENTERED WITHIN BODY ASSEMBLY. HOLD ASSEMBLY FIRMLY BOTTOMED UNTIL FULLY HEX CRIMPED AS SHOWN WITH MILITARY CRIMP TOOL M22520/5-01 USING CD5-9 CLOSURE A (.255 HEX).
 - BRING SEALING SLEEVE UP ONTO HEX CRIMPED PORTION OF THE BODY ASSEMBLY NOT TO EXTEND PAST STEP OF BODY



- STEP 3**
- BEND WHITE CONDUCTOR OUTWARD AND POSITION BLUE CONDUCTOR TO CENTER OF CABLE.
 - INSTALL PIN/CONTACT/DUAL ENTRY DIELECTRIC ASSY OVER BLUE CONDUCTOR AND SEAT AGAINST BRAID, WITH WHITE CONDUCTOR THRU SIDE SLOT, CRIMP CENTER PIN/CONTACT WITH MILITARY CRIMP TOOL M22520/2-01 SETTING 4 USING TROMPETER POSITIONER 010-0041.