Recommended Hand Tools: Sharp Razor, Wire Cutters, Cuticle Scissors, Digital Calipers w/ depth gauge

Required Cable Tools: M22520/5-01 Hex Crimp Tool, M22520/5-13, Cavity A, .255" Hex Crimp Die Set, Soldering Equipment, Heat Gun

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1) Make sure end of cable is cut square. Install heat shrink and ferrule over the cable before Cutting. Make Cut A @ .730" from the cable end, through the outer jacket (Fig. 1). Do not nick or cut into the wire braids.

2) Flare out the outer braid to expose the (gold) foil shield. Slit the foil lengthwise in three or 4 places and flare back the same as the outer braid. Carefully flare out the Strip Braid away from the dielectric, away from the dielectric using tweezers or an X-acto knife (Fig 2).

3) Make Cut B .330" from the cable end, through the dielectric (Fig 3.). Do not nick or cut into the center conductor.

4) Slide the center contact onto the center conductor of the cable, ensuring it seats against the cable dielectric. Solder the center contact onto the cable center conductor (Fig. 4).

5) Install the contact body over the center contact and dielectric until it is fully seated (Fig. 5). Fold the strip braid, foil shield, and wire braid (one at a time) over the contact body crimp area. Trim the braids as necessary up to the shoulder of the crimp ferrule area (Fig. 5).

6) Smooth down the braids/foil. Slide the crimp ferrule over the braids, up to the contact shoulder (Fig 6.). Trim any stray braids at the shoulder of the contact body.

7) Verify that the contact body is fully seated onto the cable. Crimp the ferrule using the M22520 / 5-01 Hex Crimp tool with M22520 / 5-13 die set, cavity A - .255" hex (Fig. 7).

8) Remove the extraction sleeve (Fig. 7) before heating the heat shrink tube. Starting at the contact shoulder, heat the ATUM 12/3 dual wall heat shrink, covering the ferrule and cable (Fig. 8). Re-install the extraction sleeve.

Note: Connector Length added to cable = + 1.20" nom.