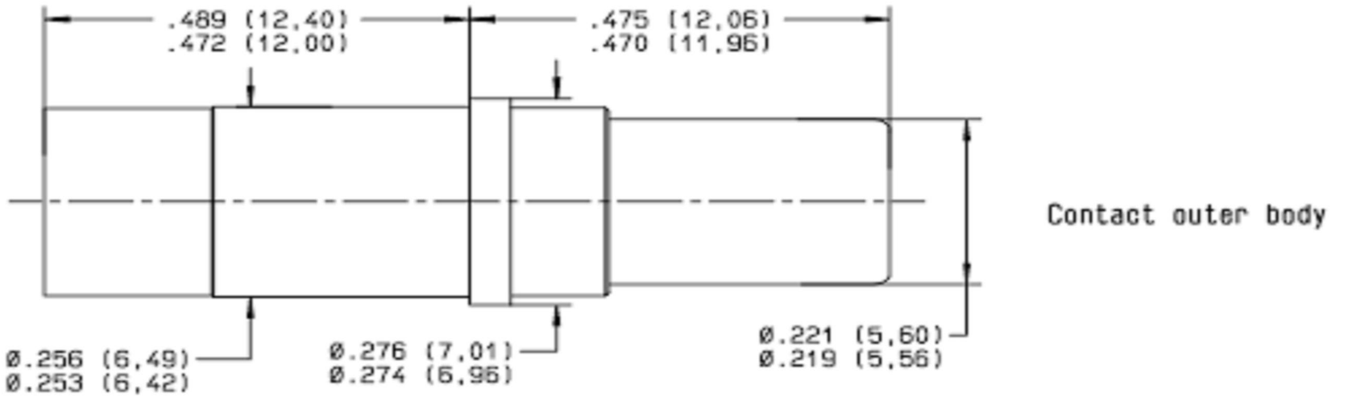
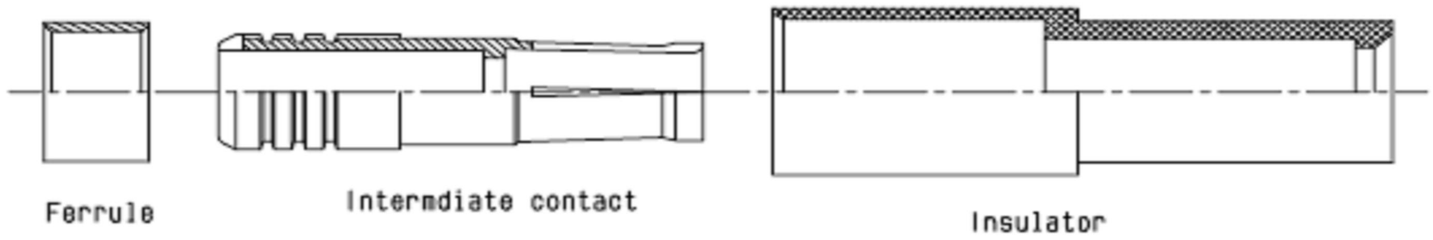
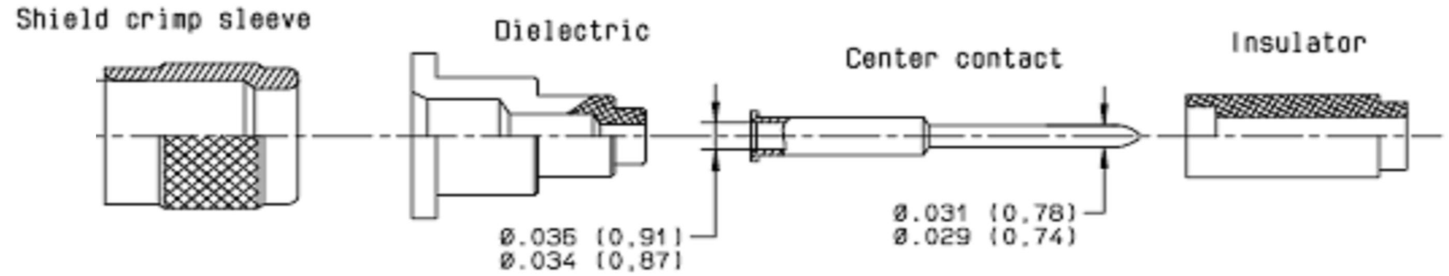
LOC	DIST
-	-

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	3	REV PER ECO 10-010036	5-18-10	CT	KH







△1 MATERIAL:
- OUTER BODY CONTACT AND INTERMEDIATE CONTACT: BERYLLIUM COPPER 1/2 HARDNESS IN KNOOP 140 MAX (126 HV) FOR CRIMP BARREL.
- FERRULE AND SHIELD CRIMP SLEEVE: COPPER ALLOY.
- CENTER CONTACT: C97.
- DIELECTRIC AND INSULATORS: PTFE.

△2 FINISH:
- ALL METALLIC PARTS: GOLD PER MIL-G-45204 TYPE I OR II GRADE C OR D CLASS 1, 50 MICROINCHES OVER NICKEL PLATE PER QQ-N-290.

3. CRIMPING TOOLS: (CRIMPED CONTACTS WILL SHOW NO CRACK WHEN INSPECTED, PER MIL-C-22520, AT 10x)
- CENTER CONTACT:
  BASIC TOOL: M22520/2-01 (REF TE P/N 601966-1)
  SELECTOR SET 3
  POSITIONER (REF TE P/N 1738338-1)
- INTERMEDIATE AND OUTER BODY CONTACTS:
  BASIC TOOL: M22520/5-01 (REF TE P/N 608650-1)
  DIE: M22520/5-05 (REF TE P/N 1738336-1
  DIE CLOSURE: B FOR INTERMEDIATE CONTACT.
  A FOR OUTER BODY CONTACT.

4. EXTRACTION TOOL: M81969/28-01 (REF TE P/N 91074-1)

△5 APPLICABLE CABLES: PAN 6421, M17/176-0002, RAYCHEM 10613

△6 APPLICABLE CABLE: RAYCHEM 10614

7. THIS PRODUCT IS SOLD BY TYCO ELECTRONICS UNDER A LICENSE FROM RADIALL SA.

REMARKS	PART NUMBER
△6	1738033-2
△5	1738033-1

DIMENSIONS: INCHES[mm]

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL - △1
FINISH - △2

DWN	R FLAIG	01FEB2010
CHK	J MOSIER	01FEB2010
APVD	J MOSIER	01FEB2010
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

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PRELIMINARY

CONTACT, PIN, CONCENTRIC TWINAX
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1738033	-

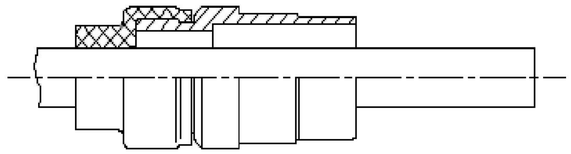
CUSTOMER DRAWING | SCALE N/A | SHEET 1 OF 4 | REV 3

LOC	DIST
DF	A5

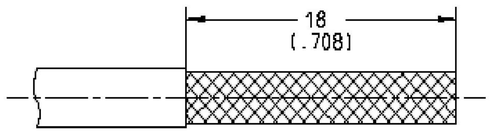
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

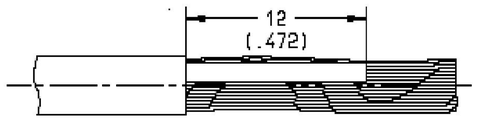
ASSEMBLY INSTRUCTIONS



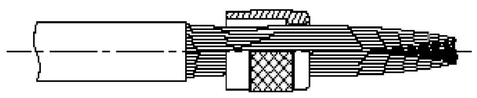
FOR ENVIRONMENTAL CONTACT, SLIDE THE ENVIRONMENTAL SLEEVE OVER THE CABLE BEFORE STRIPPING



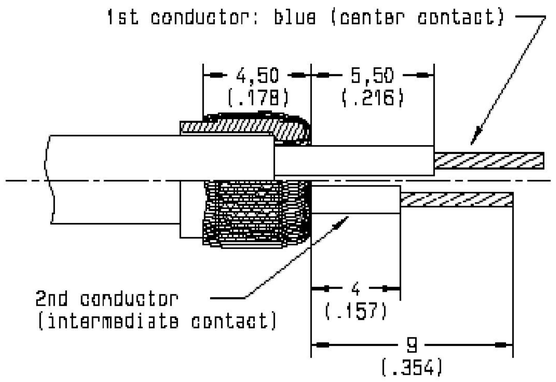
STRIP THE CABLE AS ILLUSTRATED



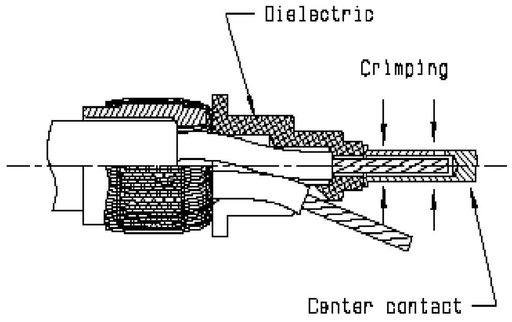
COMB BRAIDS AND CUT THE HIGH IMMUNITY RIBBON.
CUT THE TWO CONDUCTORS TO LENGTH INDICATED



SLIDE SHIELD CRIMP SLEEVE OVER THE BRAID AGAINST THE SHEATH CUT END. FIRST, TWIST THE BRAID END TO FACILITATE THE SLIDING OF THE SHIELD CRIMP SLEEVE



FOLD BACK THE BRAID OVER THE SHIED CRIMP SLEEVE
CUT THE BRAID AND TWO CONDUCTORS AS SHOWN.
CUT THE ROD FILLERS



A: SLIDE THE DIELECTRIC ON THE FIRST CONDUCTOR.
THE SECOND CONDUCTOR COMING IN THE SLOT.

B: SLIDE THE CENTER CONTACT ON THE FIRST CONDUCTOR UNTIL IT BUTTS AGAINST THE BRAID. THE CABLE CONDUCTOR MUST BE VISIBLE THROUGH THE INSPECTION HOLE.

C: CRIMP THE CENTER CONTACT:
- CRIMPING TOOL M22520/2.01 (REF TE P/N 601966-1), SELECTOR 3
- POSITIONER (REF TE P/N 1738338-1).

DIMENSIONS: INCHES[mm]

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL - -
FINISH - -

DWN	R FLAIG	01FEB2010
CHK	J MOSIER	01FEB2010
APVD	J MOSIER	01FEB2010
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

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NAME CONTACT, PIN, CONCENTRIC TWINAX
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1738033	-

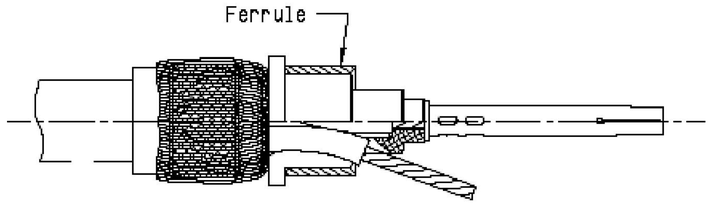
CUSTOMER DRAWING | SCALE N/A | SHEET 2 OF 4 | REV 3

LOC	DIST
-	-

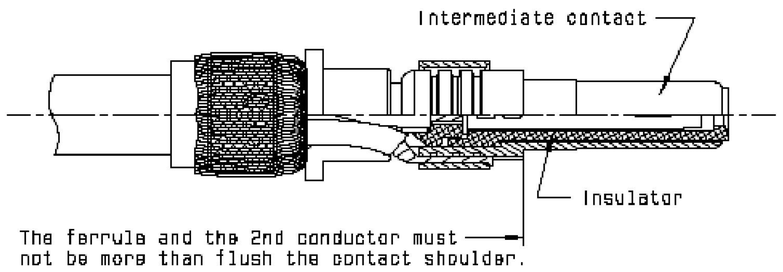
REVISIONS

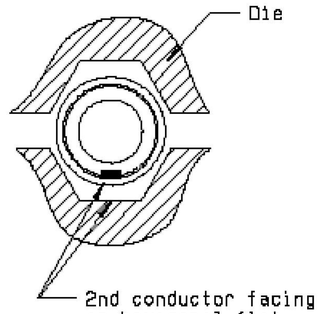
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

ASSEMBLY INSTRUCTIONS (CONT'D)



SLIDE THE FERRULE OVER THE DIELECTRIC UNTIL IT BUTTS AGAINST THE SHOULDER



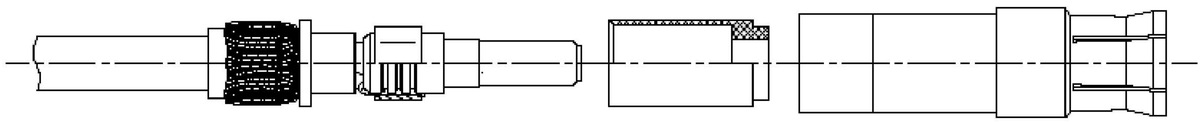


A: SLIDE THE INTERMEDIATE INSULATOR OVER THE CRIMPED CENTER CONTACT. THEN, INTRODUCE THIS SUB-ASSEMBLY INTO THE INTERMEDIATE CONTACT

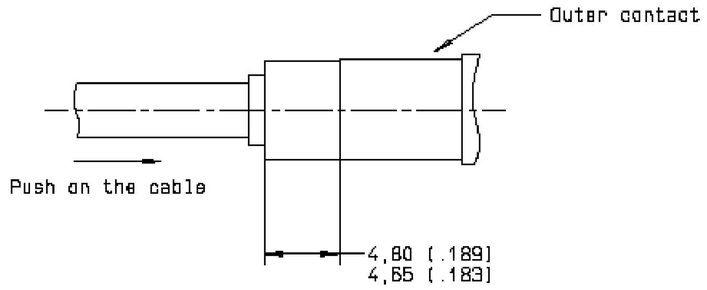
B: PUT THE SECOND CONDUCTOR IN THE BARREL SLOT, SLIDE BACK THE FERRULE OVER THE INTERMEDIATE CONTACT BARREL (AS SHOWN)

C: CRIMP THE FERRULE:
- CRIMPING TOOL M22520/5.01 (REF TE P/N 608650-1)
- DIE M22520/5.05 (REF TE P/N 1738336-1), HEX B ((4.5 MM) .178 ON FLATS)

BE SURE THE SECOND CONDUCTOR IS FACING AN HEXAGONAL FLAT BEFORE CRIMP



INTRODUCE THE INTERMEDIATE CONTACT INTO THE INTERMEDIATE INSULATOR, THEN INTO THE CONTACT OUTER BODY



CRIMP THE OUTER CONTACT:
- CRIMPING TOOL M22520/5.01 (REF TE P/N 608650-1)
- DIE M22520/5.05 (REF TE P/N 1738336-1), HEX A ((5.4 MM) .213 ON FLATS)

PRESS LIGHTLY THE OUTER CONTACT BETWEEN DIES, IN THE INDICATED CRIMPING AREA (AS SHOWN) AND PUSH ON THE CABLE TO PUT ALL COMPONENTS IN A GOOD POSITION. THEN CLOSE THE DIES COMPLETLY.

FOR ENVIRONMENTAL CONTACT, BRING BACK THE ENVIRONMENTAL SLEEVE ON THE CONTACT OUTER BODY

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DIMENSIONS: INCHES[mm]

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

MATERIAL -
FINISH -

PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

NAME CONTACT, PIN, CONCENTRIC TWINAX
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1738033	-

CUSTOMER DRAWING | SCALE N/A | SHEET 3 OF 4 | REV 3

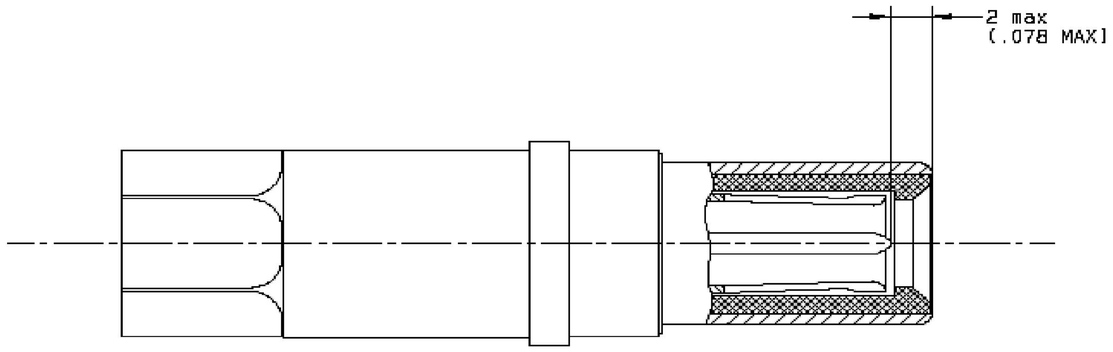
LOC	DIST
-	-

REVISIONS

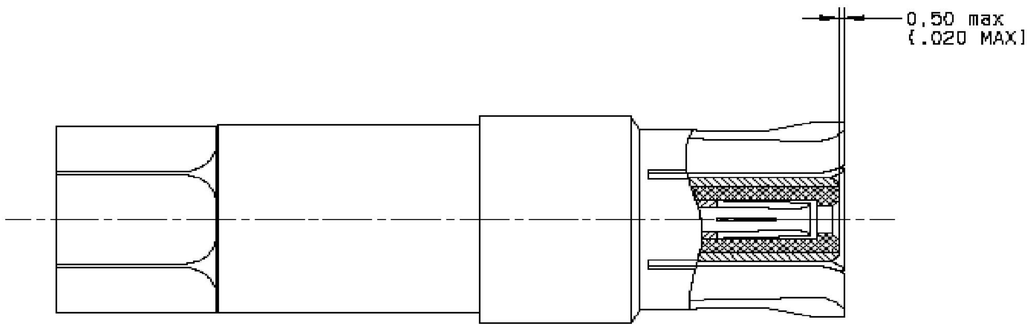
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

- INSPECTION DIMENSIONS AFTER ASSEMBLY -

PIN TWINAX CONTACT:



SOCKET TWINAX CONTACT:



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1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL - -
FINISH - -

DWN R FLAIG 01FEB2010
CHK J MOSIER 01FEB2010
APVD J MOSIER 01FEB2010
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

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NAME CONTACT, PIN, CONCENTRIC TWINAX
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1738033	-

CUSTOMER DRAWING | SCALE N/A | SHEET 4 OF 4 | REV 3