

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly procedures for Golden Crimp and Crimp Silver Right-Angle Connectors. See Figure 1.

NOTE Dimensions on this sheet are in inches [with millimeters in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

CAUTION Extreme care must be taken to avoid nicking or cutting shield wires when trimming jacket.

NOTE For assembly to cable with "Mini-Noise" coating, Mini-Noise coating must be removed from surface of cable dielectric as follows:

1. Painted Coatings: Wipe off dielectric surface with a dry cloth. Wipe again using paint thinner or trichloroethane. Do not immerse cable in solvent.
2. Tape or Fused Coatings: Remove with sandpaper, file, or scraping action of razor blade. Do not damage dielectric.

DANGER To prevent personal injury, use caution when handling file or razor blade.

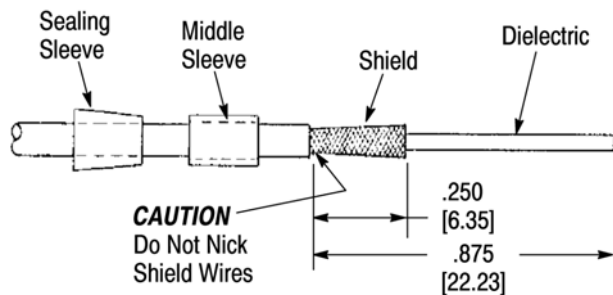


Figure 2

Step 1

Slip sealing sleeve and middle sleeve on cable and strip to dimensions shown in Figure 2.

Fan shield slightly, but do not unbraided.

Step 2

Slide inner sleeve, small end first, over dielectric and under the shield until shield wires are flush with shoulder.

Trim excess shield if necessary.

Slide middle sleeve flush with shoulder of inner sleeve. Slide sealing sleeve until it butts against the middle sleeve as shown in Figure 3.

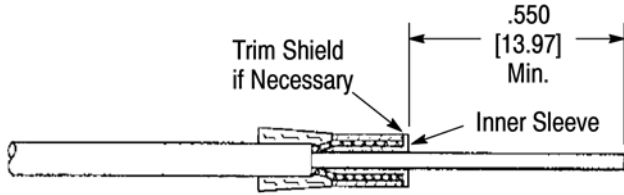


Figure 3

Step 3

Insert assembled components into rear of housing subassembly. Make sure it is properly fitted and in as far as possible. Rotate while pushing to secure a tight fit. See Figure 4.

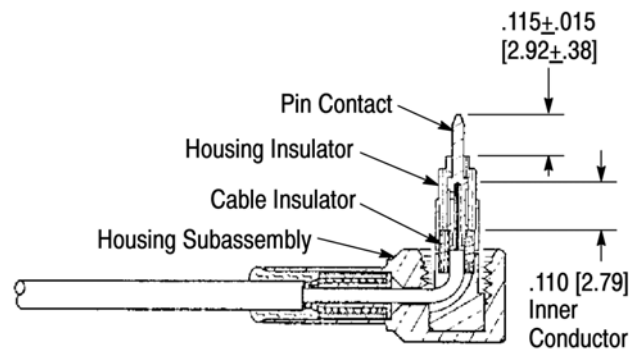


Figure 4

Crimp rear of housing with proper housing crimp tool listed in Figure 5.

| TE CONNECTIVITY PART NO. | MICRODOT* PART NO. | THOMAS & BETTS† PART NO. | CABLE DIA (MAX) |
|--------------------------|--------------------|--------------------------|-----------------|
| 4-1532129-4 | 010-0081-0000 | WT-400 | .088 [2.24] |
| 4-1532129-5 | 010-0082-0000 | WT-402 | .110 [2.79] |
| 3-1532136-7 | 010-0083-0000 | WT-406 | .155 [3.94] |

Figure 5

Step 4

Trim dielectric flush with face of housing subassembly as shown in Figure 4.



Do not nick inner conductor wires.

Step 5

Locate cable insulator over dielectric and press into counterbore of housing assembly.

Trim inner conductor to length as shown in Figure 4.

*THOMAS & BETTS, ASTRO TOOL, and DANIELS are trademarks of their respective owners.
†Consult manufacturer's literature for current information.

Step 6

Locate the pin contact over the inner conductor and press into the cable insulator until the shoulder on the contact is firmly against the cable insulator. See Figure 4.

Inner conductor must be visible through the inspection hole.

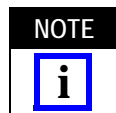
Crimp the contact in place with any one of the contact crimp tools listed in Figure 6.

| TE PART NO. | MICRODOT PART NO. | MFG'S PART NO. |
|----------------------------|---|---|
| 4-1532129-3 | 010-0065-0000 | Astro Tool No. 810D1†† |
| 3-1532136-9 8-1532137-3 | 010-0134-0000 (Setting #1) 001-0104-0000 (Locator) | DANIELS #H750† (Setting #1) #P79 (Locator) |

Figure 6

Step 7

Press the housing insulator over the pin contact until seated in place. See Figure 4.



This applies only for connectors with housing insulator packed loose.

Step 8

The final step is to thread and securely tighten the ferrule or ferrule subassembly in place.

The recommended torque value is 90-100 inch-ounces.

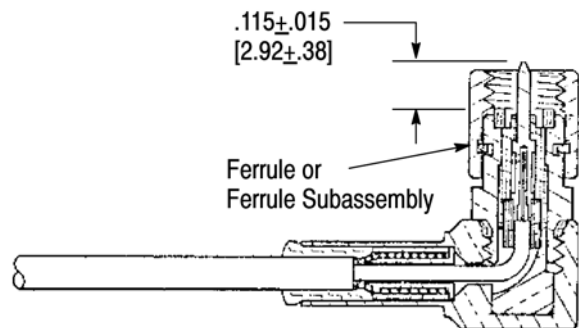


Figure 7

Notes: (Unless otherwise specified)

Test Voltage - 1000 V.R.M.S.

Insulation Resistance - 5.0 x 10⁹ Ohms Min.

2. REVISION SUMMARY

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