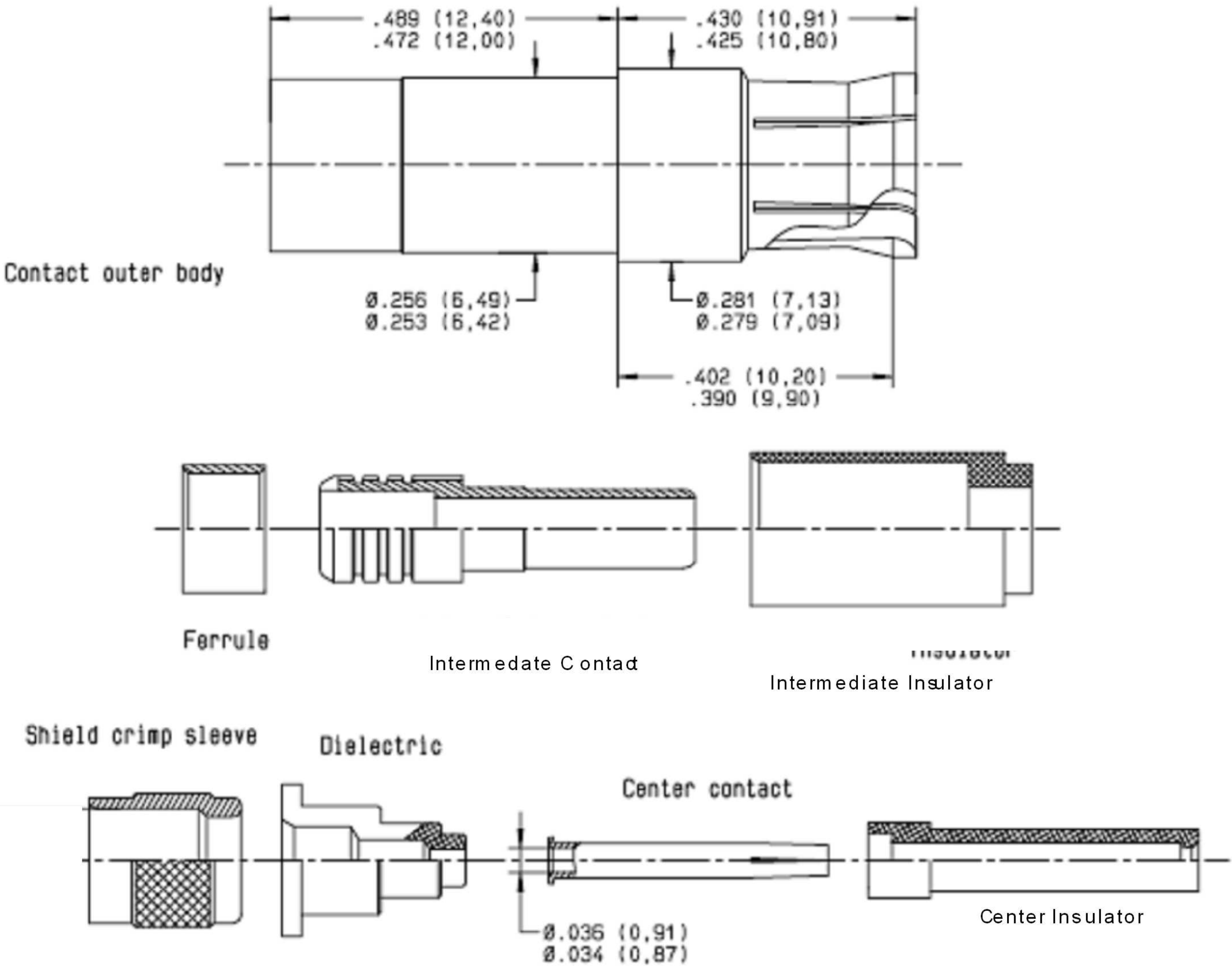


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-		A	REV PER ECO 11-006858	4-5-11	CT	KH



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

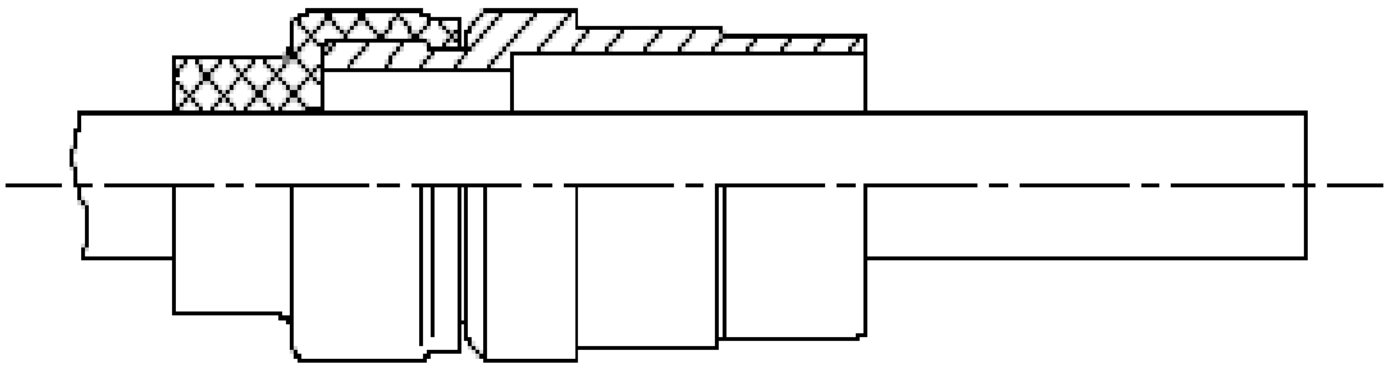
7. THIS PRODUCT IS SOLD BY Tyco Electronics UNDER LICENSE FROM RADIALL SA.

6	1738034-2
5	1738034-1
REMARKS	PART NUMBER

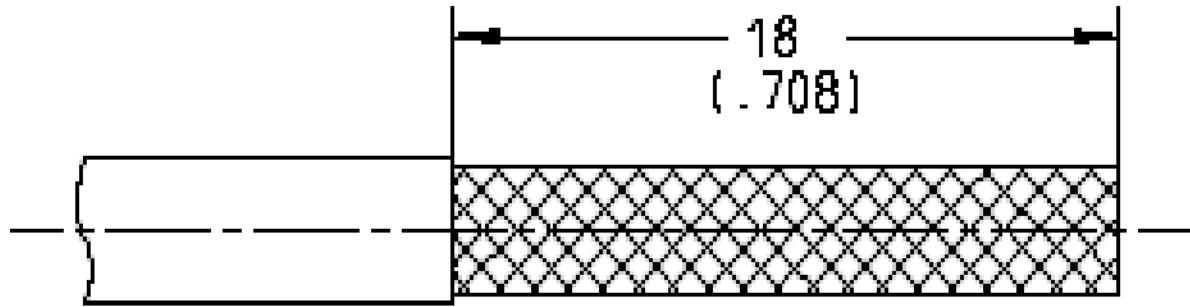
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN FLAIG 01FEB2010	 TE Connectivity			
DIMENSIONS: [NCHES[mm]		CHK MOSIER 01FEB2010				
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD MOSIER 01FEB2010	NAME			
		PRODUCT SPEC	CONTACT, SOCKET, CONCENTRIC TWINAX			
		APPLICATION SPEC				
		WEIGHT				
MATERIAL		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
-		A1	00779	C-1738034	-	
CUSTOMER DRAWING		SCALE		N/A	SHEET 1 of 4	REV A

ASSEMBLY INSTRUCTIONS

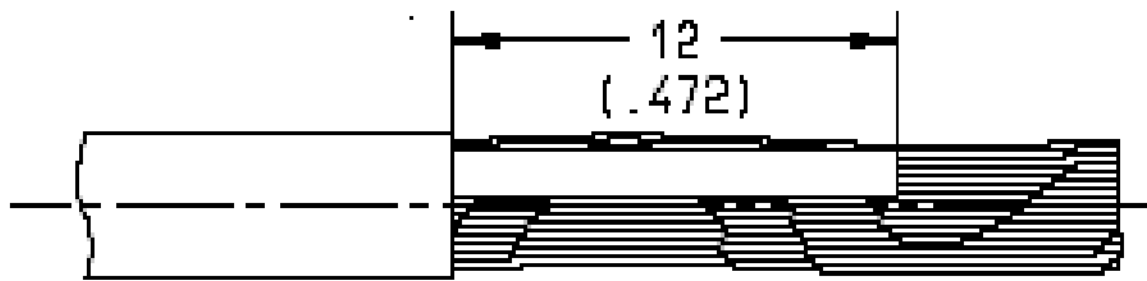
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-



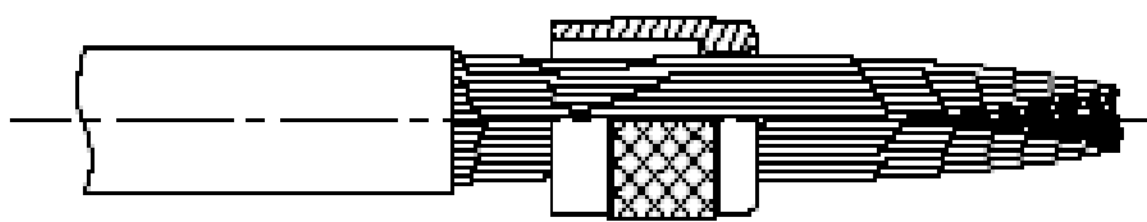
FOR ENVIRONMENTAL CONTACT, SLIDE THE ENVIRONMENTAL SLEEVE OVER THE CABLE BEFORE STRIPPING



STRIP THE CABLE AS ILLUSTRATED

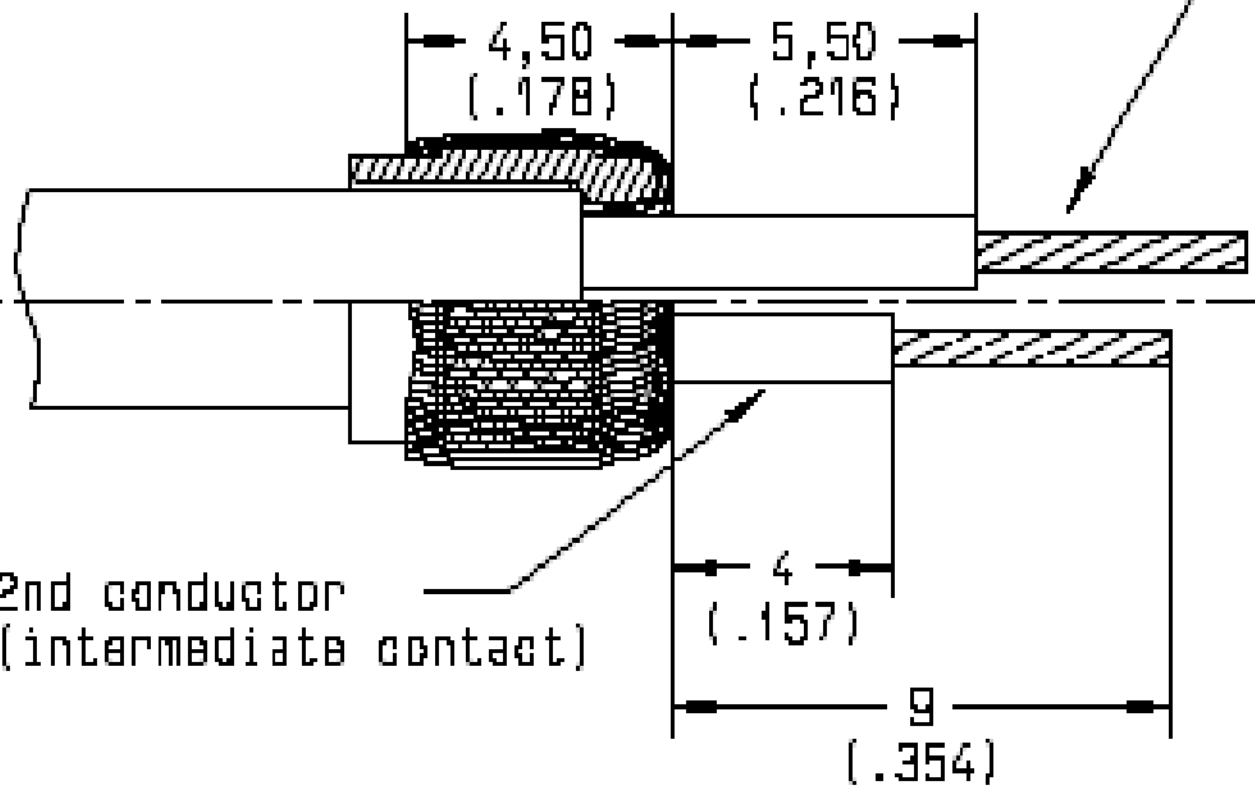


COMB BRAIDS AND CUT THE HIGH IMMUNITY RIBBON. CUT THE TWO CONDUCTORS TO LENGTH INDICATED



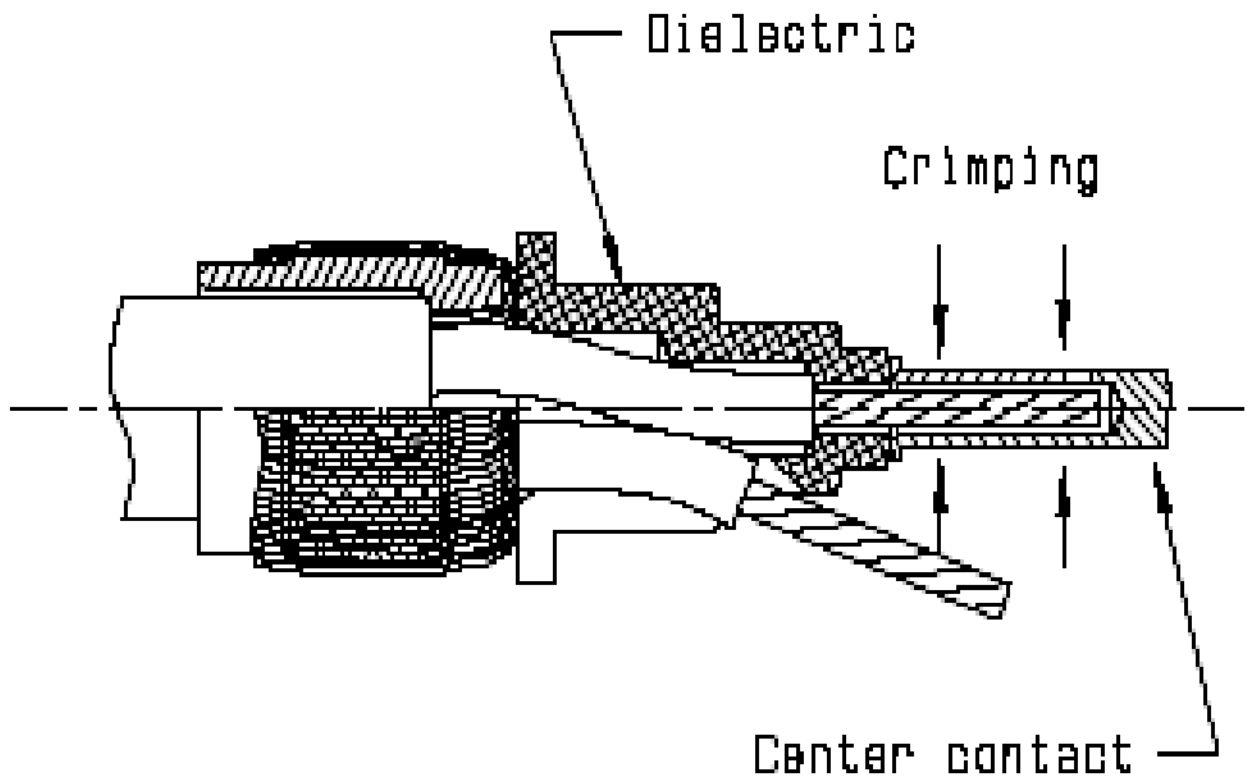
SLIDE SHIELD CRIMP SLEEVE OVER THE BRAID AGAINST THE SHEATH CUT END. FIRST, TWIST THE BRAID END TO FACILITATE THE SLIDING OF THE SHIELD CRIMP SLEEVE

1st conductor: blue (center contact)



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

2nd conductor (intermediate contact)



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

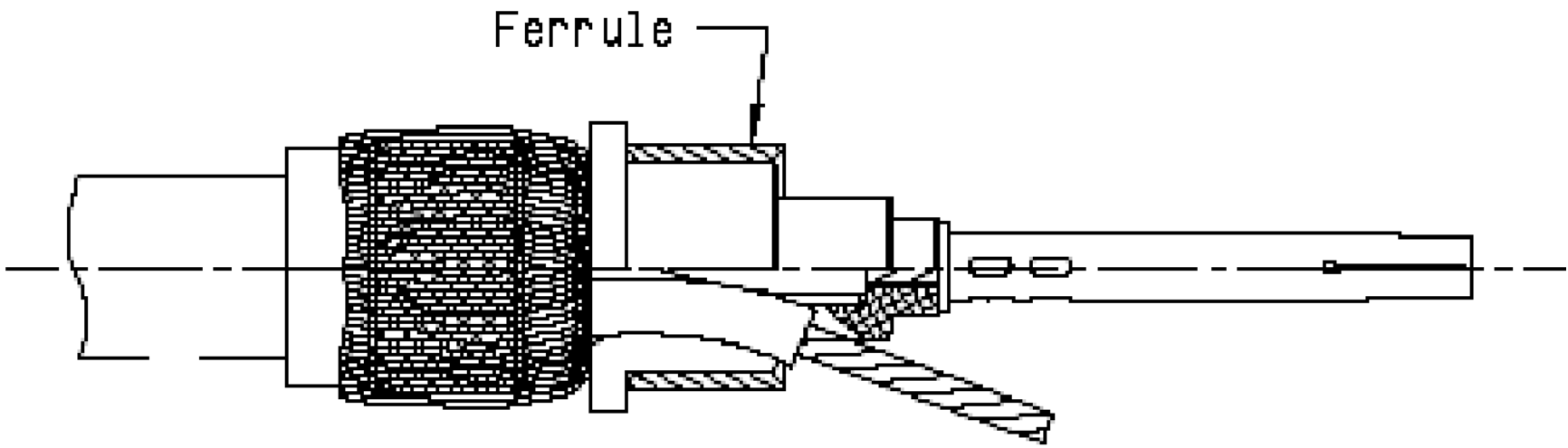
B: SLIDE THE CENTER CONTACT ON THE FIRST CONDUCTOR UNTIL IT BUTTS AGAINST THE BRAID. THE CABLE CONDUCTOR MUST BE VISIBLE THROUGH THE INSPECTION HOLE.

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).

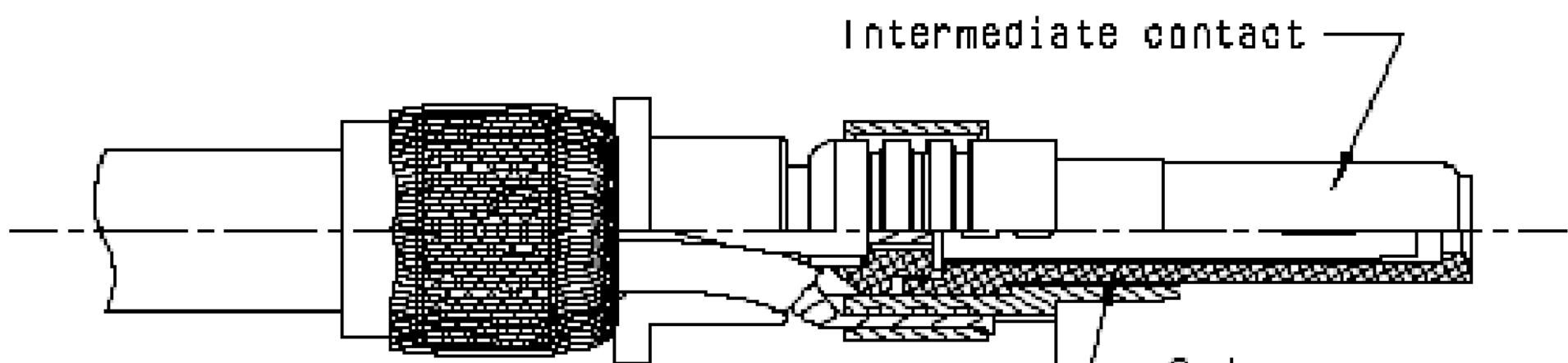
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R FLAIG 01FEB2010	 Tyco Electronics Corporation Pittsburgh, PA 15105-3608	
DIMENSIONS: INCHES[mm]		CHK J MOSIER 01FEB2010		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J MOSIER 01FEB2010	NAME CONTACT, SOCKET, CONCENTRIC TWINAX	
9 PLC ± 3 PLC ± 3 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING	SIZE A100779C=1738034	
MATERIAL -		RESTRICTED TO -		SCALE N/A
		SHEET 2 OF 4		REV A

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

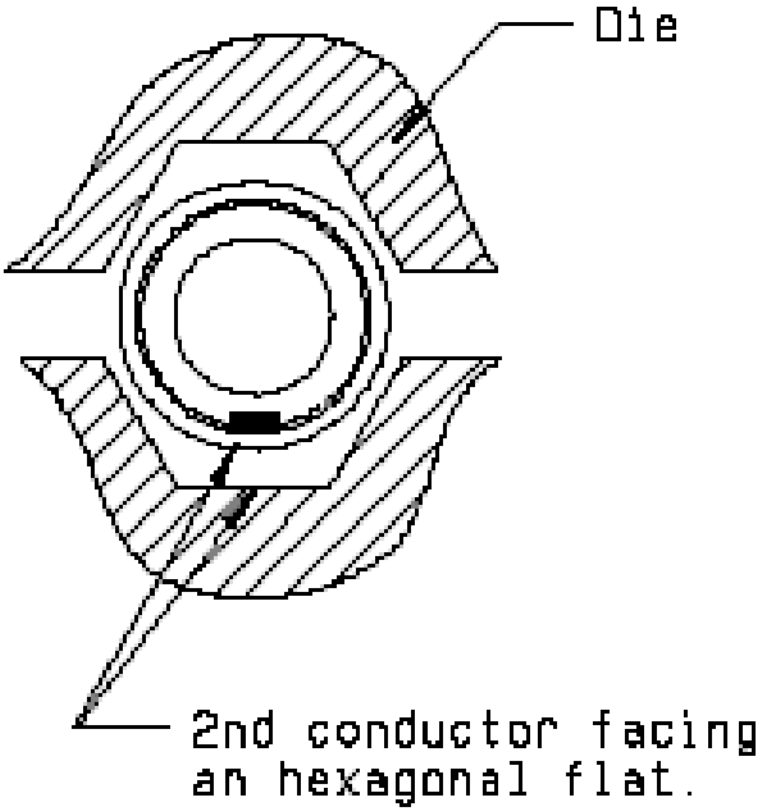
ASSEMBLY INSTRUCTIONS (CONT'D)



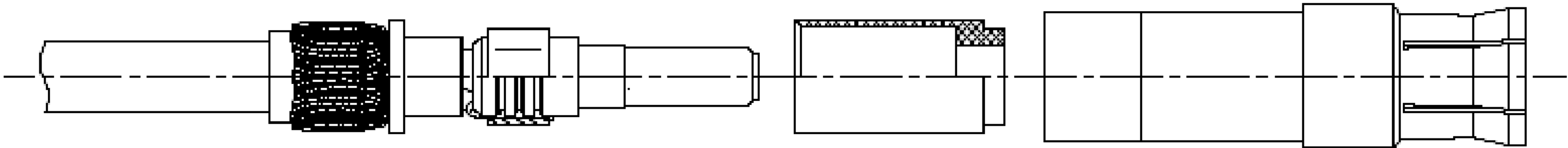
SLIDE THE FERRULE OVER THE DIELECTRIC UNTIL IT BUTTS AGAINST THE SHOULDER



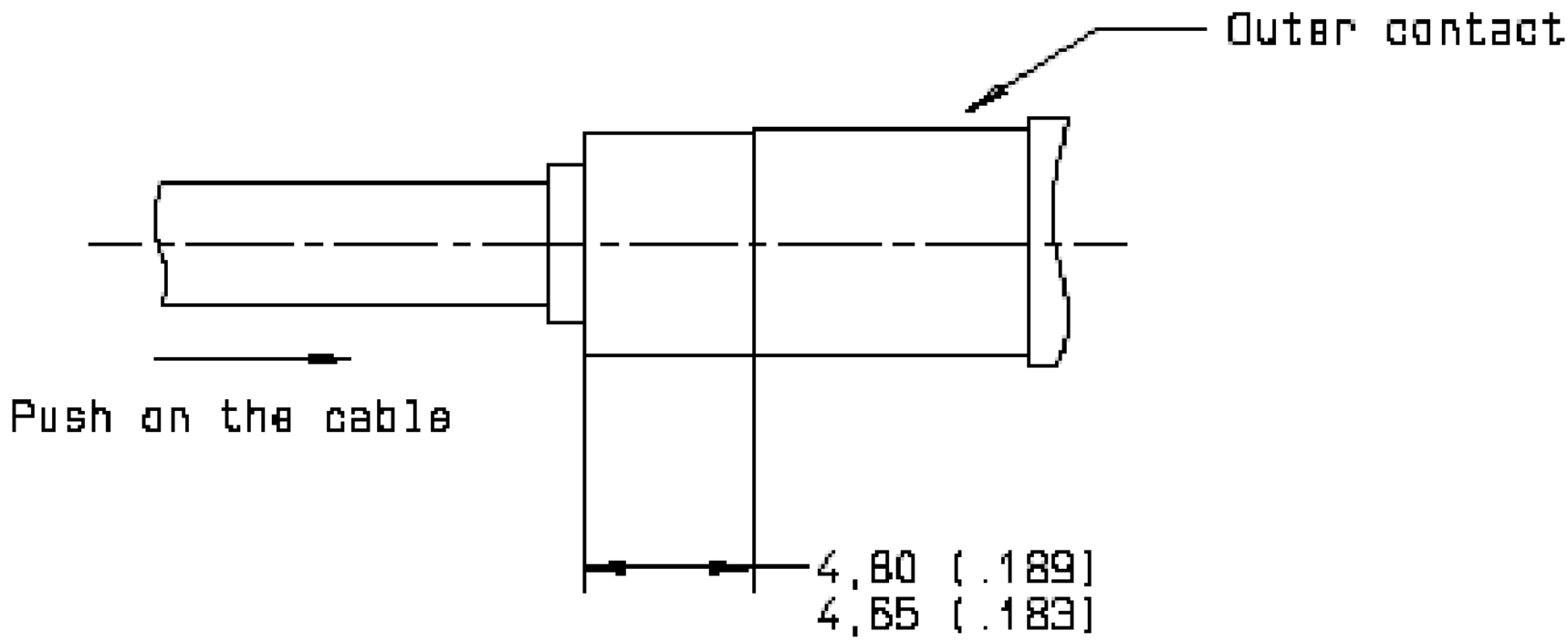
The ferrule and the 2nd conductor must not be more than flush the contact shoulder.



- A: SLIDE THE CENTER 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 COMPLETELY.

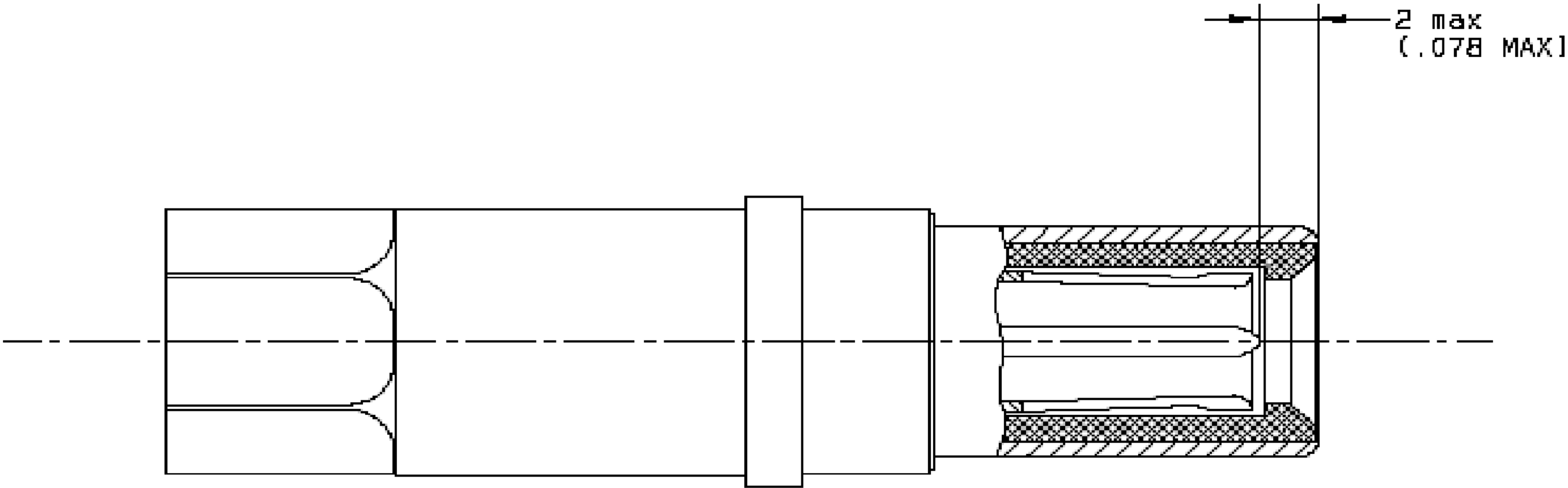
FOR ENVIRONMENTAL CONTACT, BRING BACK THE ENVIRONMENTAL SLEEVE ON THE CONTACT OUTER BODY

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R FLAIG 01FEB2010	 Tyco Electronics Corporation TE Connectivity Pittsburg, PA 15105-3608	
DIMENSIONS: INCHES[mm]		CHK J MOSIER 01FEB2010		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J MOSIER 01FEB2010	NAME CONTACT, SOCKET, CONCENTRIC TWINAX	
9 PLC ±.01 3 PLC ±.01 2 PLC ±.01 5 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	SIZE A100779C-1738034	
MATERIAL -		CUSTOMER DRAWING		RESTRICTED TO -
		SCALE N/A		SHEET 3 OF 4 REV A

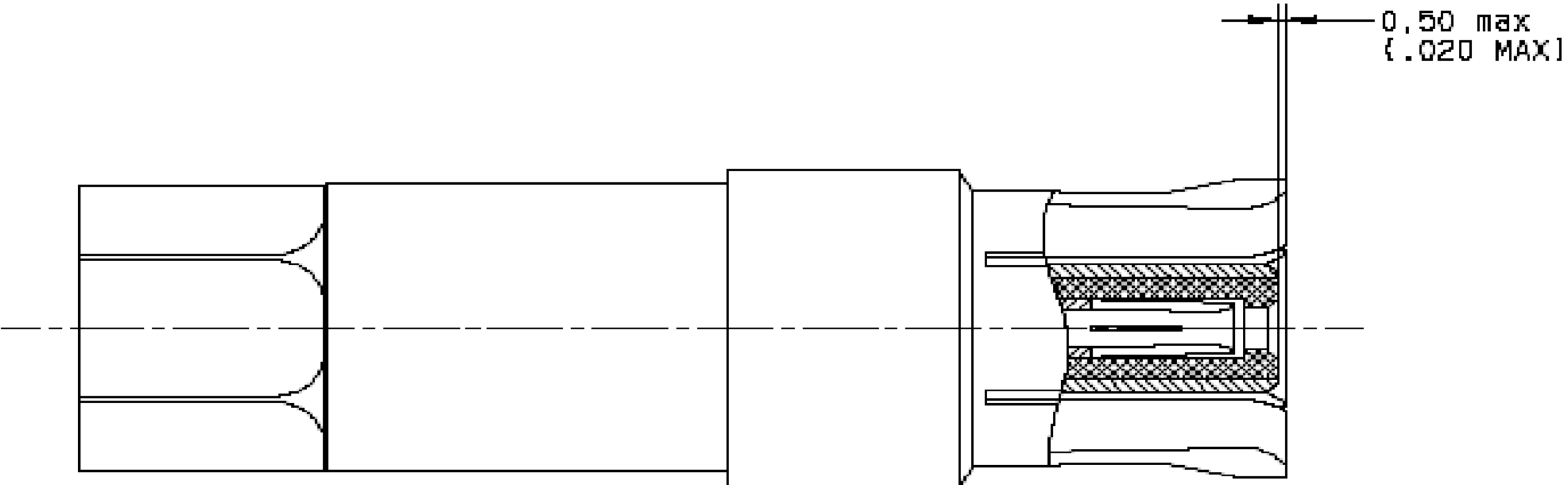
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

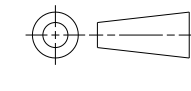
- INSPECTION DIMENSIONS AFTER ASSEMBLY -

PIN TWINAX CONTACT:



SOCKET TWINAX CONTACT:



THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R. FLAIG	01FEB2010	 Tyco Electronics Corporation Pittsfield, PA 17055-3608	
DIMENSIONS: INCHES[mm]		CHK J. MOSIER	01FEB2010		
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
		0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH -		CONTACT, SOCKET, CONCENTRIC TWINAX	
MATERIAL -		APVD J. MOSIER		SIZE CAGE CODE DRAWING NO	
		PRODUCT SPEC		A100779C-1738034	
		APPLICATION SPEC		RESTRICTED TO	
		WEIGHT		-	
		CUSTOMER DRAWING		SCALE N/A SHEET 4 OF 4 REV A	