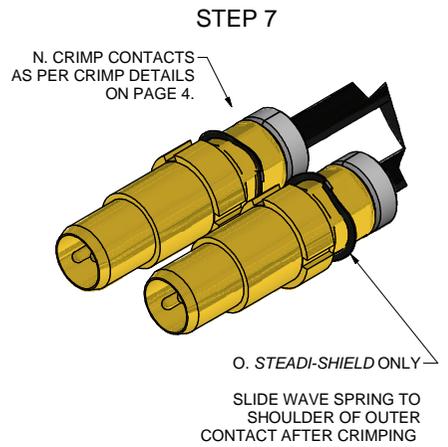
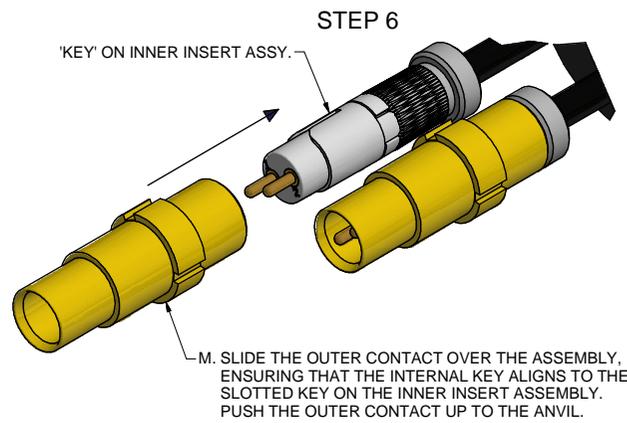
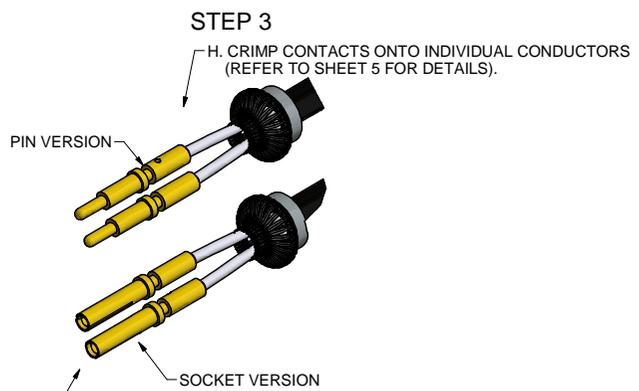
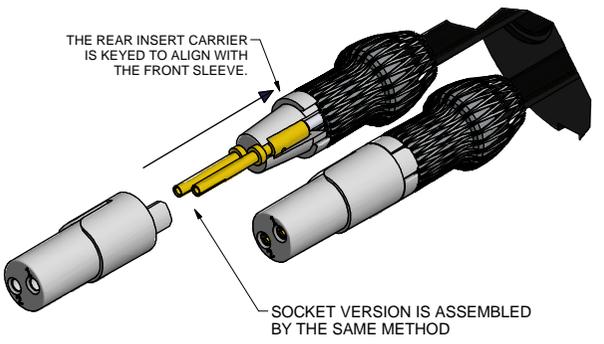
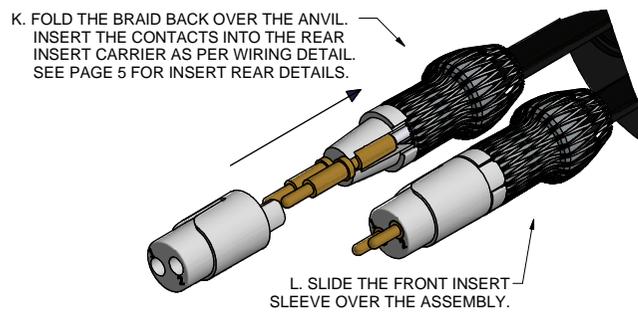
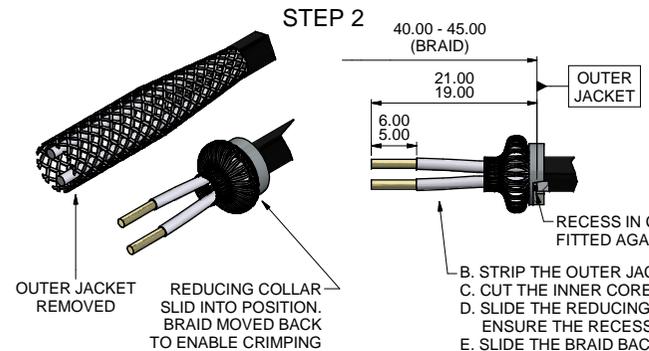
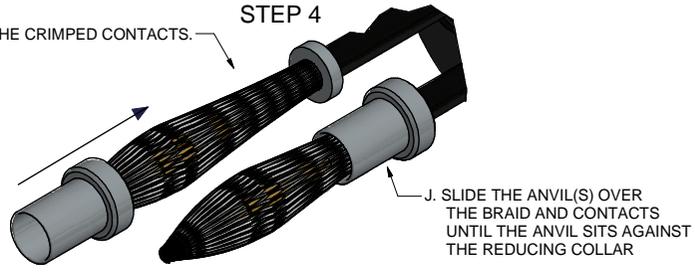


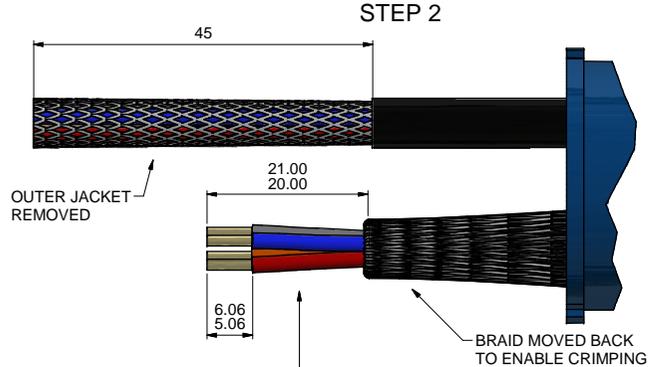
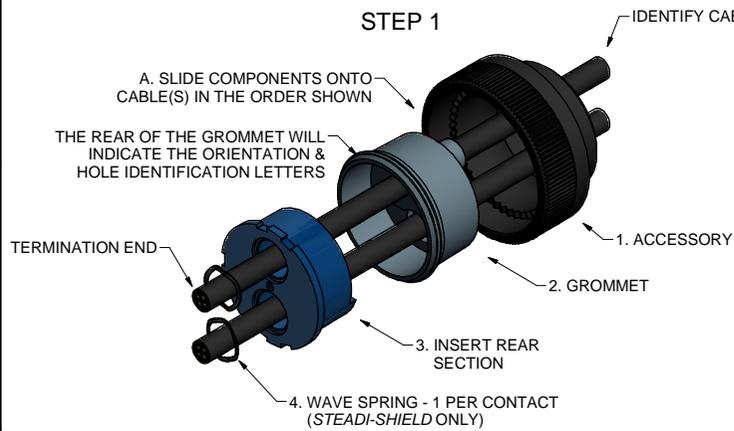
**\*\*TWINAX & TRIAX ASSEMBLY WITH REDUCING COLLAR\*\***  
**FOR THE PURPOSE OF THIS AID A TWINAX MULTIPOLE ASSEMBLY HAS BEEN ILLUSTRATED. THE PROCESS ALSO APPLIES TO TRIAX BUILDS.**



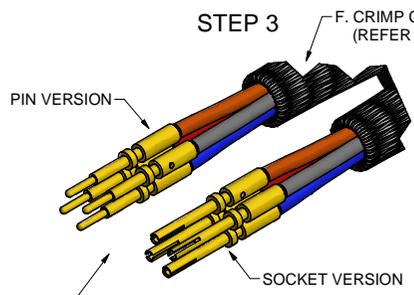
DURING A NORMAL BUILD ONLY 1 GENDER WOULD BE USED.

Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins	Created Date: 28/05/2010	Revision: F	ECN: N/A	Third Angle Projection	Information: Unless otherwise stated, all dimensions are in mm. *V denotes a critical characteristic. *0 denotes a significant characteristic. * Drawing conforms to AB-W07-03-01. * Finishing codes conform to PSD-021. * In the event of conflict between information contained within this drawing, and AB-W07-03-01, the information contained within this drawing takes precedence.		Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID	Material: N/A	Drawing Number: SPEC-595	Sheet: 1 of 7
	Issued By: Darren Tucker	Issued Date: 08/02/2017	Description of last change:								
	Checked By: Rory Watkins	Checked Date: 08/02/2017	(REF: SHIT 5)								
	Approved By: Rory Watkins	Approval Date: 08/02/2017	UPDATED TOOLING INFORMATION TO: MULTICORE CONTACT CRIMP TOOL TABLE. UPDATED NOMENCLATURE								

# QUADRAX CONTACT ASSEMBLY

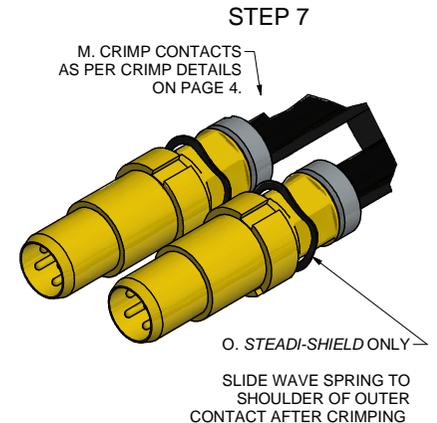
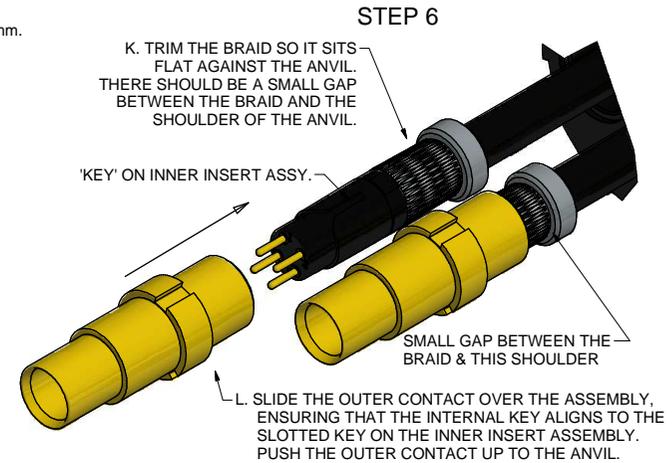
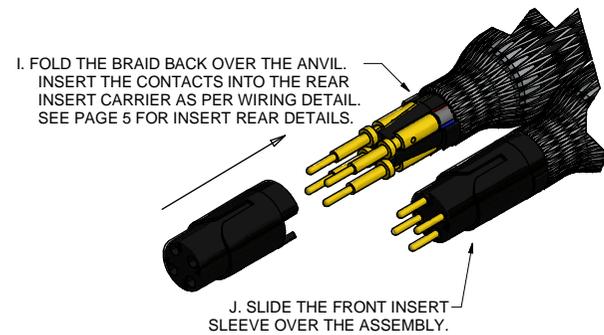


- B. STRIP THE OUTER JACKET(S) TO LENGTH SHOWN.  
 C. SLIDE THE BRAID BACK TOWARDS THE OUTER JACKET. IT CAN BE FOLDED BACK OVER THE JACKET IF THIS IS EASIER.  
 D. REMOVE ANY FOIL AND/OR FILLERS AND CUT THE INNER CORES TO 20-21mm.  
 E. STRIP THE INDIVIDUAL CONDUCTORS TO LENGTH SHOWN.



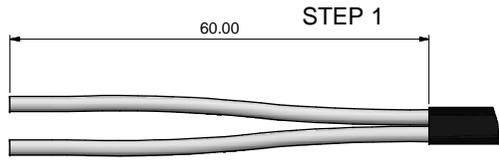
NOTE: STEP 3 FOR THE PURPOSE OF THIS ASSEMBLY AID BOTH MALE AND FEMALE CONTACTS HAVE BEEN ILLUSTRATED TO INDICATE IT IS THE SAME PROCESS FOR BOTH.

DURING A NORMAL BUILD ONLY 1 GENDER WOULD BE USED.



Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins	Created Date: 28/05/2010	Revision: F	ECN: N/A	Third Angle Projection	Information: Unless otherwise stated, all dimensions are in mm. *V denotes a critical characteristic. • denotes a significant characteristic. • Drawing conforms to AB-W07-03-01. • In the event of conflict between information contained within this drawing, and AB-W07-03-01, the information contained within this drawing takes precedence.	<p>ab Connectors</p> <p>Description: MULTICORE CONTACT &amp; MULTI CONTACT CONNECTOR ASSEMBLY AID</p> <p>Material: N/A</p> <p>Drawing Number: SPEC-595</p> <p>Sheet: 2 of 7</p>
	Issued By: Darren Tucker	Issued Date: 08/02/2017	Description of last change:				
	Checked By: Rory Watkins	Checked Date: 08/02/2017	(REF: SHT 5) UPDATED TOOLING INFORMATION TO: MULTI CORE CONTACT CRIMP TOOL TABLE. UPDATED NOMENCLATURE				
	Approved By: Rory Watkins	Approval Date: 08/02/2017					

# INDIVIDUAL SIZE 12 & 16 CONTACT ASSEMBLY



A. STRIP ANY MULTII POLE CABLES TO LENGTH SHOWN. THIS IS TO BE PREFORMED FOR CABLES BEING TERMINATED ONTO INDIVIDUAL SIZE 12 & 16 CONTACTS ONLY.

B. SLIDE COMPONENTS ONTO CABLE(S) IN THE ORDER SHOWN

THE REAR OF THE GROMMET WILL INDICATE THE ORIENTATION & HOLE IDENTIFICATION LETTERS

C. SLIDE THE INDIVIDUAL CORES THROUGH THE GROMMET AND INSERT REAR

TERMINATION END

STEP 2

IDENTIFY CABLES AS REQUIRED

ANY CABLE IDENTS SHOULD BE LOOSELY PLACE OVER THE CABLE BEFORE SLIDING THE ACCESSORIES ON.

1. ACCESSORY

2. GROMMET

3. INSERT REAR SECTION

D. STRIP INNER CONDUCTORS 5-6mm

E. CRIMP CONTACTS AS PER SHEET 5

TERMINATE THE TWINAX, TRIAX OR QUADRAX CONTACT AS SHOWN ON PAGES 1 & 2

STEP 3

NOTE:

IF SHORT LENGTHS OF INDIVIDUAL CORES ARE BEING TERMINATED THE CRIMP OPERATION CAN THEN BE PERFORMED FIRST. THE INDIVIDUAL WIRES CAN THEN BE PUSHED THROUGH THE INSERT REAR AND THEN THROUGH THE GROMMET.

FOR THE PURPOSE OF THIS AID, MALE CONTACTS HAVE BEEN ILLUSTRATED. THE PROCESS IS THE SAME FOR FEMALE CONTACTS.

**ONCE ALL CONTACTS HAVE BEEN CRIMPED PROCEED TO STEP 8 ON PAGE 4.**

Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins	Created Date: 28/05/2010	Revision: F	ECN: N/A	Third Angle Projection
	Issued By: Darren Tucker	Issued Date: 08/02/2017	Description of last change: (REF: SHIT 5) UPDATED TOOLING INFORMATION TO: MULTI CORE CONTACT CRIMP TOOL TABLE. UPDATED NOMENCLATURE		
	Checked By: Rory Watkins	Checked Date: 08/02/2017			
	Approved By: Rory Watkins	Approval Date: 08/02/2017			

Information:  
\*Unless otherwise stated, all dimensions are in mm.  
\*V denotes a critical characteristic.  
\*Ø denotes a significant characteristic.  
\* Drawing conforms to AB-W07-03-01.  
\* Finishing codes conform to PSD-021.  
\* In the event of conflict between information contained within this drawing, and AB-W07-03-01, the information contained within this drawing takes precedence.



Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID	Material: N/A	Drawing Number: SPEC-595	Sheet: 3 of 7
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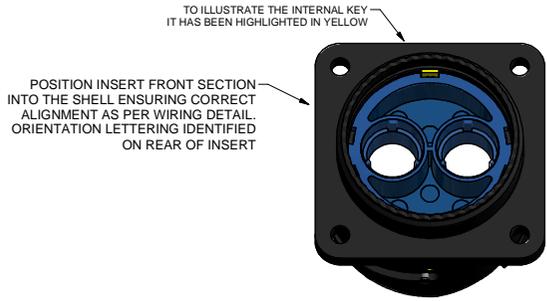
UNCONTROLLED IF PRINTED, it is the responsibility of the user to ensure the correct issue drawing is used. A2 border, DO NOT SCALE.

STEP 8.a - STANDARD ABMP SHELL

SECTION VIEW

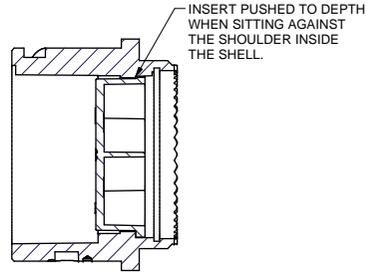
STEP 8.b - STEADI-SHIELD ABMP SHELL

SECTION VIEW

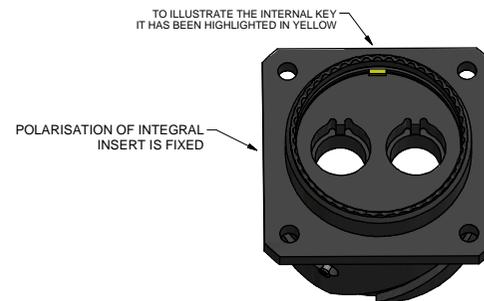


POSITION INSERT FRONT SECTION INTO THE SHELL ENSURING CORRECT ALIGNMENT AS PER WIRING DETAIL. ORIENTATION LETTERING IDENTIFIED ON REAR OF INSERT

TO ILLUSTRATE THE INTERNAL KEY IT HAS BEEN HIGHLIGHTED IN YELLOW

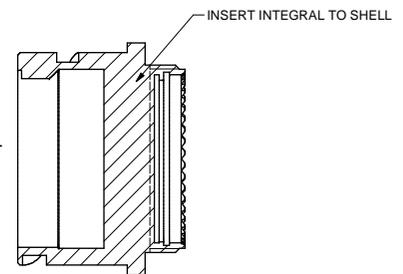


INSERT PUSHED TO DEPTH WHEN SITTING AGAINST THE SHOULDER INSIDE THE SHELL.



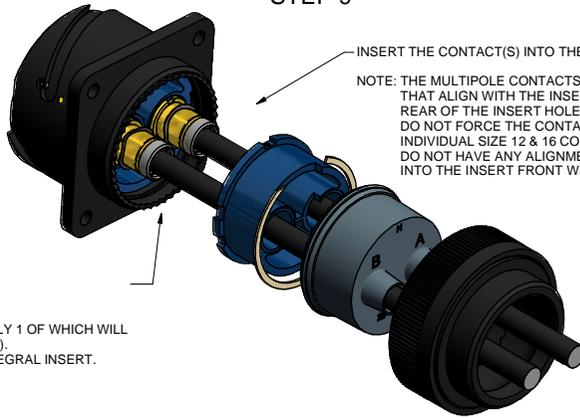
POLARISATION OF INTEGRAL INSERT IS FIXED

TO ILLUSTRATE THE INTERNAL KEY IT HAS BEEN HIGHLIGHTED IN YELLOW



INSERT INTEGRAL TO SHELL

STEP 9



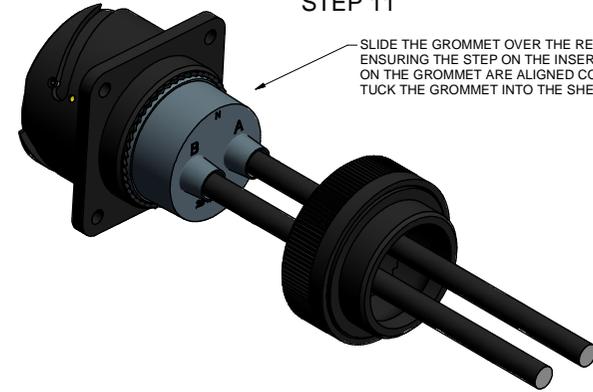
INSERT THE CONTACT(S) INTO THE SHELL AND INSERT ASSEMBLY.

NOTE: THE MULTIPOLE CONTACTS HAVE 3 KEYWAYS THAT ALIGN WITH THE INSERT KEYS IN THE REAR OF THE INSERT HOLE(S). DO NOT FORCE THE CONTACTS INTO THE INSERT. INDIVIDUAL SIZE 12 & 16 CONTACTS (NOT ILLUSTRATED) DO NOT HAVE ANY ALIGNMENT KEYS AND CAN BE PUSHED INTO THE INSERT FRONT WITHOUT THE NEED FOR ALIGNMENT.

STEADI-SHIELD ONLY  
INSERT THE CONTACT(S) INTO THE SHELL.

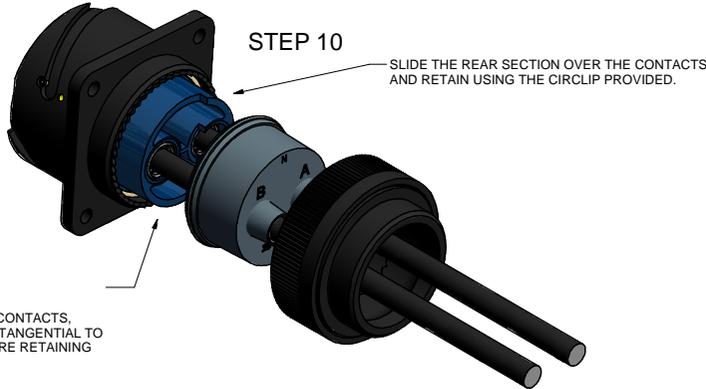
NOTE: THE MULTIPOLE CONTACTS HAVE 3 KEYS, ONLY 1 OF WHICH WILL FIT THE KEY IN THE INTEGRAL INSERT HOLE(S). DO NOT FORCE THE CONTACTS INTO THE INTEGRAL INSERT.

STEP 11



SLIDE THE GROMMET OVER THE REAR OF THE ASSEMBLY, ENSURING THE STEP ON THE INSERT REAR AND THE STEP ON THE GROMMET ARE ALIGNED CORRECTLY. TUCK THE GROMMET INTO THE SHELL.

STEP 10



SLIDE THE REAR SECTION OVER THE CONTACTS AND RETAIN USING THE CIRCLIP PROVIDED.

STEADI-SHIELD ONLY

SLIDE THE REAR SECTION OVER THE CONTACTS, ENSURING THE WAVE SPRING(S) ARE TANGENTIAL TO OUTER CONTACT(S) SHOULDER BEFORE RETAINING USING THE CIRCLIP PROVIDED.

STEP 12



ATTACH THE ACCESSORY TO THE SHELL ENSURING THAT THE GROMMET IS NOT TWISTED AND DAMAGED IN THE PROCESS.

TIP - LIGHTLY PUSHING THE REAR OF THE ACCESSORY WHILE ROTATING THE COUPLING NUT WILL HELP MAINTAIN THE GROMMETS POSITION AND STOP TWISTING AND POTENTIAL DAMAGE TO THE GROMMET DURING ASSEMBLY.

**NOTE:**  
FOR THE PURPOSE OF THIS AID A FIXED SHELL ASSEMBLY HAS BEEN ILLUSTRATED. THE PROCESS ALSO APPLIES TO A FREE SHELL ASSEMBLY.

Tolerance Details (Unless Otherwise Stated): (REF: SHT 0) UPDATED TOOLING INFORMATION TO: MULTICORE CONTACT CRIMP TOOL TABLE. UPDATED NOMENCLATURE.	Created By: <b>Rory Watkins</b>	Created Date: 28/05/2010	Revision: ECN: F N/A	Third Angle Projection	Information: * Unless otherwise stated, all dimensions are in mm. * V denotes a critical characteristic. * 0 denotes a significant characteristic. * Drawing conforms to AB-W07-03/01. * Finishing codes conform to PED-021. * In the event of conflict between information contained within this drawing, and AB-W07-03-01, the information contained within this drawing takes precedence.	Description: <b>MULTICORE CONTACT &amp; MULTI CONTACT CONNECTOR ASSEMBLY AID</b> Material: N/A
	Issued By: <b>Darren Tucker</b>	Issued Date: 08/02/2017	Description of last change: 1. STEADI-SHIELD ASSEMBLY INSTRUCTIONS ADDED 2. CRIMPING CHART UPDATED 3. ILLUSTRATIONS UPDATED TO ILLUSTRATE MOULDED INSERTS			
	Checked By: <b>Rory Watkins</b>	Checked Date: 08/02/2017	Drawing Number: SPEC-595			
	Approved By: <b>Rory Watkins</b>	Approval Date: 08/02/2017	Sheet: 4 of 7			

# Multi Core Contact Crimping Chart

## Nomenclature

**ABMP # ## # A**

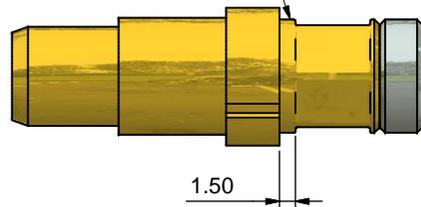
**AB Multi Pole**

**Contact Type:**  
**P = Pin**  
**S = Socket**

**Type:**  
**T = TWINAX**  
**TR = TRIAX**  
**Q = QUADRAX**

**Crimp Size:**  
**16**  
**20**  
**22**

For crimping detail guidance see page 7



Contact Part Number	Wire CSA (mm <sup>2</sup> )	AWG	Tool Required	Tool Setting	Turret Locator / Die Set	Position				
ABMPT16PA	0.93	16	ABB-FT8	4	ABB-UH2-5 (Adjustable)	----				
	1.5			5						
ABMPT16SA	0.93			4						
	1.5			5						
ABMPTR16PA	0.93			4			ABB-TH608	Blue		
	1.5			5						
ABMPTR16SA	0.93			4						
	1.5			5						
ABMPQ16PA	0.93			4						
	1.5			5						
ABMPQ16SA	0.93	4								
	1.5	5								
ABMPT18PA	0.75 - 0.93	18	ABB-FT8	4	ABB-UH2-5 (Adjustable)	----				
ABMPT18SA										
ABMPT20PA	0.50 - 0.60	20	ABB-FT8	3	ABB-UH2-5 (Adjustable)	----				
ABMPT20SA										
ABMPTR20PA					ABB-TH608	Blue				
ABMPTR20SA										
ABMPQ20PA										
ABMPQ20SA										
ABMPT22PA			0.2 - 22	22	ABB-FT8	2	ABB-UH2-5 (Adjustable)	----		
			0.34			3				
ABMPT22SA	0.2 - 22	2								
	0.34	3								
ABMPTR22PA	0.2 - 22	2	ABB-TH608			Blue				
	0.34	3								
ABMPTR22SA	0.2 - 22	2								
	0.34	3								
ABMPQ22PA	0.2 - 22	2								
	0.34	3								
ABMPQ22SA	0.2 - 22	2								
	0.34	3								
ABMP1620KPKP3	0.50 - 0.60	20	ABB-FT8			3			ABB-UH2-5 (Adjustable)	----
ABMP1620KLPK3										
ABMP###PA				Ø8.1	----		ABBPL0550A1130			
ABMP###SA	Max Cable Dia.	----	ABB-D51	----	ABT.00004					

Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins	Created Date: 28/05/2010	Revision: F	ECN: N/A	Third Angle Projection: 
	Issued By: Darren Tucker	Issued Date: 08/02/2017	Description of last change: ABMPT18PA AND SA DETAILS ADDED IN TO TABLE		
	Checked By: Rory Watkins	Checked Date: 08/02/2017			
	Approved By: Rory Watkins	Approval Date: 08/02/2017			

Information:  
 \* Unless otherwise stated, all dimensions are in mm.  
 \* V denotes a critical characteristic.  
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 \* Drawing conforms to AB-W07-03-01.  
 \* Finishing codes conform to PED-021.  
 \* In the event of conflict between information contained within this drawing, and AB-W07-03-01, the information contained within this drawing takes precedence.

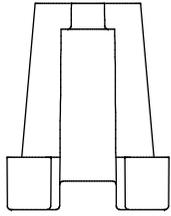


Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID	
Material: N/A	
Drawing Number: SPEC-595	Sheet: 5 of 7

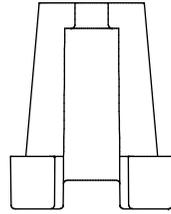
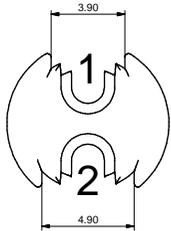
# TWINAX

NOTE:  
REAR VIEW OF ABIC\_013#\_IR  
THIS COMPONENT IS COMMON  
TO BOTH THE PIN & SOCKET  
CONTACT ASSEMBLIES.

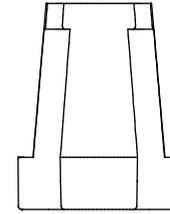
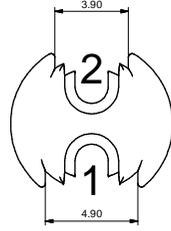
# TRIAx



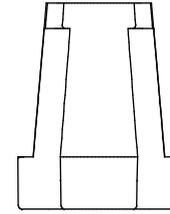
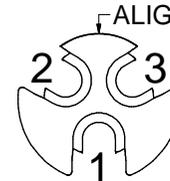
REAR VIEW  
SOCKET INSERT CARRIER



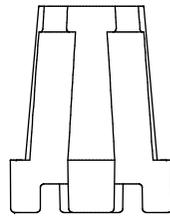
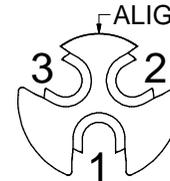
REAR VIEW  
PIN INSERT CARRIER



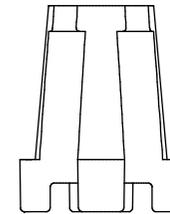
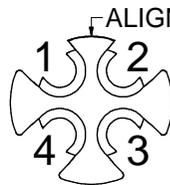
REAR VIEW  
SOCKET INSERT CARRIER



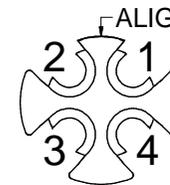
REAR VIEW  
PIN INSERT CARRIER



REAR VIEW  
SOCKET INSERT CARRIER



REAR VIEW  
PIN INSERT CARRIER



# QUADRAX

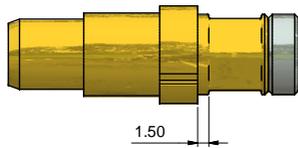
Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins	Created Date: 28/05/2010	Revision: F	ECN: N/A	Third Angle Projection:
	Issued By: Darren Tucker	Issued Date: 08/02/2017	Description of last change: UPDATED TOOLING INFORMATION TO: (REF: SH1 5) MULTICORE CONTACT CRIMP TOOL TABLE. UPDATED NOMENCLATURE		
	Checked By: Rory Watkins	Checked Date: 08/02/2017			
	Approved By: Rory Watkins	Approval Date: 08/02/2017			

Information: * Unless otherwise stated, all dimensions are in mm. * V denotes a critical characteristic. * 0 denotes a significant characteristic. * Drawing conforms to AB-W07-03-01. * Finishing codes conform to PSD-021. * In the event of conflict between information contained within this drawing, and AB-W07-03-01, the information contained within this drawing takes precedence.
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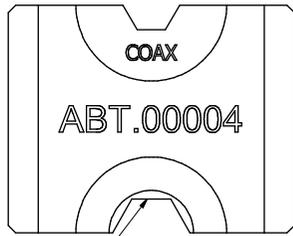
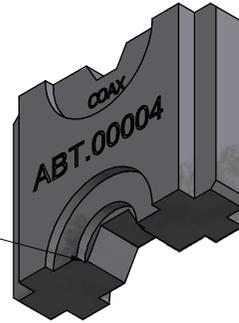


Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID
Material: N/A
Drawing Number: SPEC-595
Sheet: 6 of 7

**FINISHED CRIMP DETAIL**

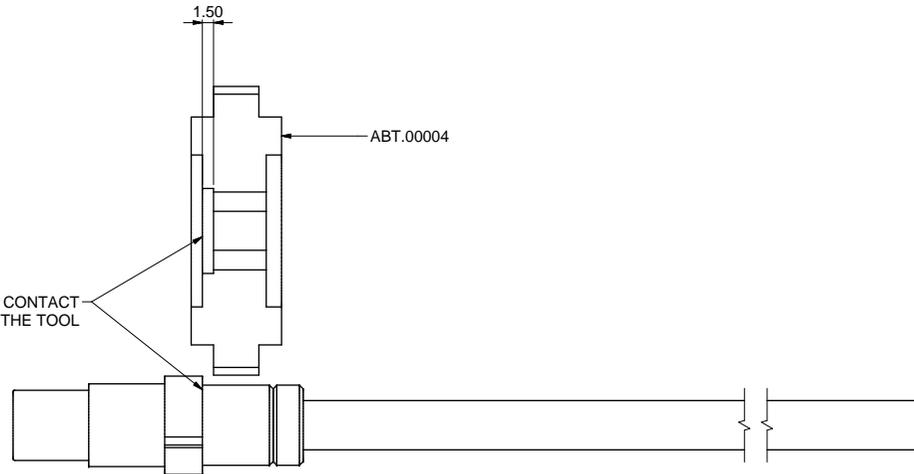


UNDERCUT FOR 1.5mm  
GAP TO SHOULDER ON CONTACT



SHOULDER OF CONTACT TO BE  
ON THIS SIDE OF THE TOOL

SHOULDER OF CONTACT  
TO SIT AGAINST THIS SIDE OF THE TOOL



Tolerance Details (Unless Otherwise Stated):  (REF: SHT.8) UPDATED TOOLING INFORMATION TO: MULTI CORE CONTACT CRIMP TOOL TABLE UPDATED NOMENCLATURE	Created By: <b>Rory Watkins</b>	Created Date: <b>28/05/2010</b>	Revision: ECN: <b>F N/A</b>	Third Angle Projection:	Information: * Unless otherwise stated, all dimensions are in mm. * V denotes a critical characteristic. * 0 denotes a significant characteristic. * Drawing conforms to AB-W07-03/01. * Finishing copies conform to PSD-021. * In the event of conflict between information contained within this drawing, and AB-W07-03-01, the information contained within this drawing takes precedence.		Description: <b>MULTICORE CONTACT &amp; MULTI CONTACT                  CONNECTOR ASSEMBLY AID</b>
	Issued By: <b>Darren Tucker</b>	Issued Date: <b>08/02/2017</b>	Description of last change: ADDED 1. STEADI-SHIELD ASSEMBLY INSTRUCTIONS 2. CRIMPING CHART UPDATED 3. ILLUSTRATIONS UPDATED TO ILLUSTRATE MOULDED INSERTS				Material: N/A
	Checked By: <b>Rory Watkins</b>	Checked Date: <b>08/02/2017</b>					Drawing Number: <b>SPEC-595</b>
	Approved By: <b>Rory Watkins</b>	Approval Date: <b>08/02/2017</b>					Sheet: <b>7 of 7</b>