

# Assembly & Wiring Instructions for Coax & Twinax Contacts

Specification No. 525

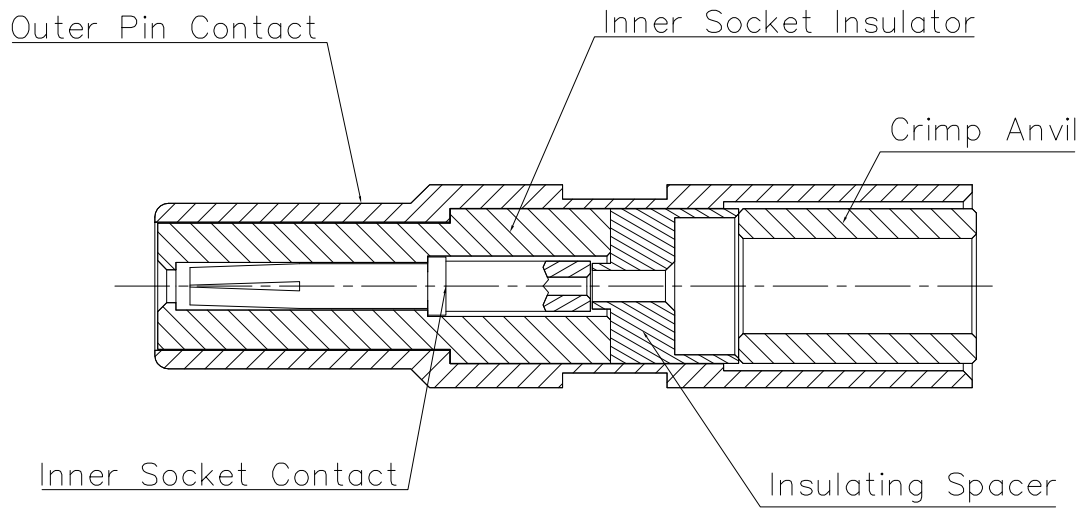


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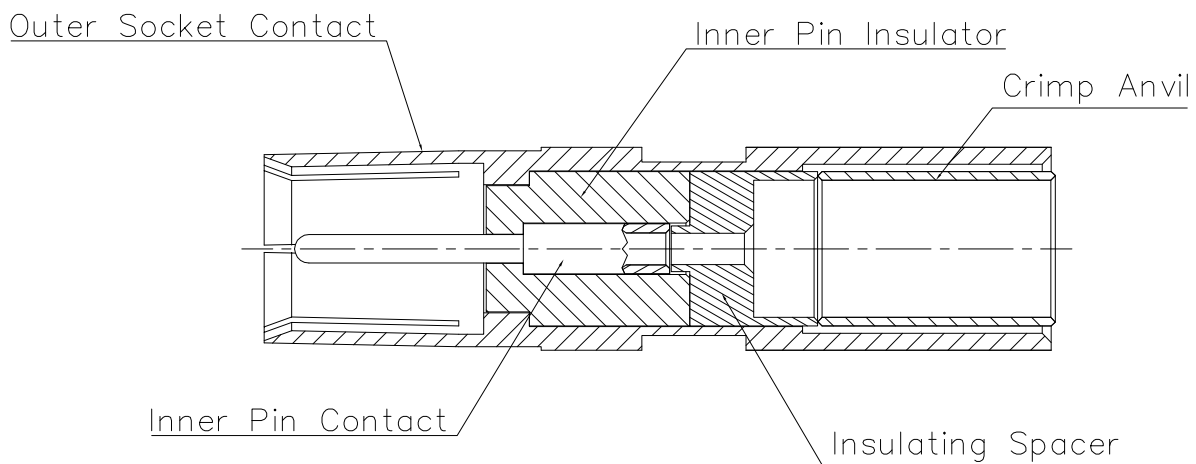
Prepared By:	Sig. / Date	Checked By :	Sig. / Date	Approved By:	Sig. / Date
P.Lineham		T.Lewis		A.Breese	

## Co-ax Contacts Contact Description & Terminology

### Pin Contact



### Socket Contact



## Co-ax

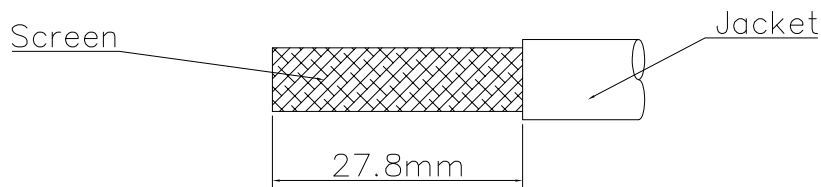
The following assembly method caters for Coax Contacts to be crimped on to  $0.5\text{mm}^2$  Coaxial cable.

Please Note that the procedure is the same for Pin & Socket Contacts.

Contact Part No's: ABB-4-CKPK-F80-P1-001 / ABB-4-CKSK-F80-P1-001  
Cable:  $0.5\text{mm}^2$

Crimping Tools: Inner Contact: AF8 (setting No 4) with TH619 Turret Head  
Outer Contact: D55E/D51 with 31038 Die Set

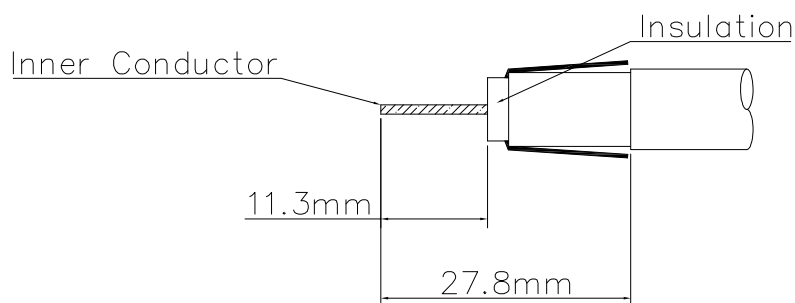
1. Cut the end of the cable squarely, do not crush.
2. Strip the Outer Jacket to 27.8mm. Use care not to nick the screen.



3. Slide the crimp anvil over the screen until it hits the outer jacket. Fold screen back over crimp anvil and tape in position.

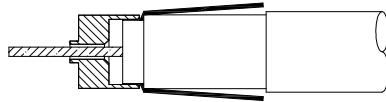


4. Cut back the insulation to expose 11.3mm of the inner conductor.

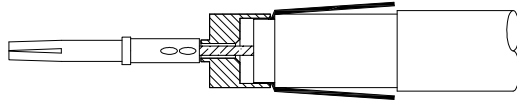


## Co-ax

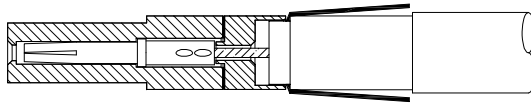
5. Slide Insulating Spacer over the inner conductor.



6. Place the Inner Pin or Socket contact over the conductor and crimp using the specified crimp tool.

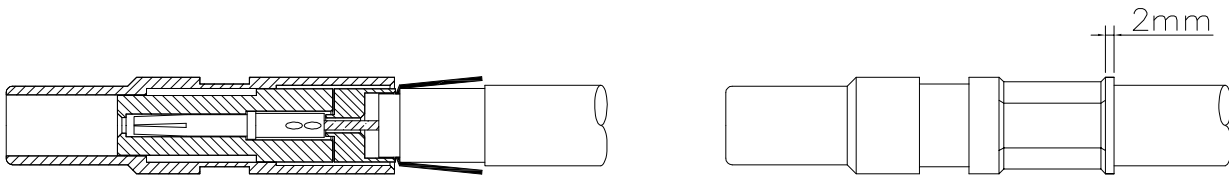


7. Slide the Inner Pin or Socket Insulator over the Inner Contact.



8. Slide the Outer Contact over the whole assembly, ensure that the screen is trapped between the Outer Contact and the Crimp Anvil. Firmly press all components together. Crimp outer contact using specified crimp tool, approximately 2mm in from the end of the contact.

NB Due to the various screen thickness available it may be necessary to only partially close the crimp tool. Once a setting has been established a piece of shim can be used to set the required gap.



9. Trim of any excess screen protruding from the back of the contact.

Co-ax

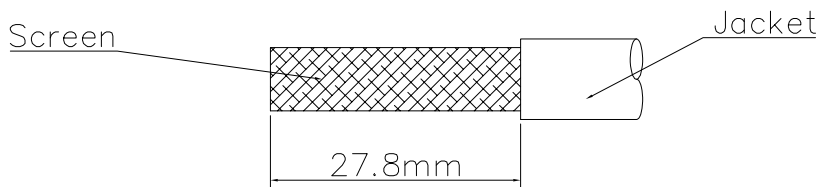
The following assembly method caters for Coax Contacts to be crimped on to 1.0mm<sup>2</sup> Coaxial cable.

Please Note that the procedure is the same for Pin & Socket Contacts.

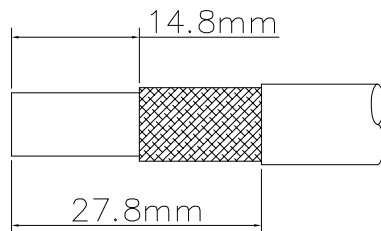
Contact Part No's: ABB-4-CKPK-F80-P1-002 / ABB-4-CKSK-F80-P1-002  
Cable: 1.0mm<sup>2</sup>

Crimping Tools: Inner Contact: AF8 (setting No 4) with TH619 Turret Head  
Outer Contact: D55E/D51 with HD51-150 Die Set

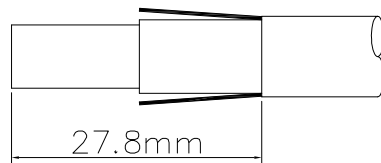
1. Cut the end of the cable squarely, do not crush.
2. Strip the Outer Jacket to 27.8mm. Use care not to nick the screen.



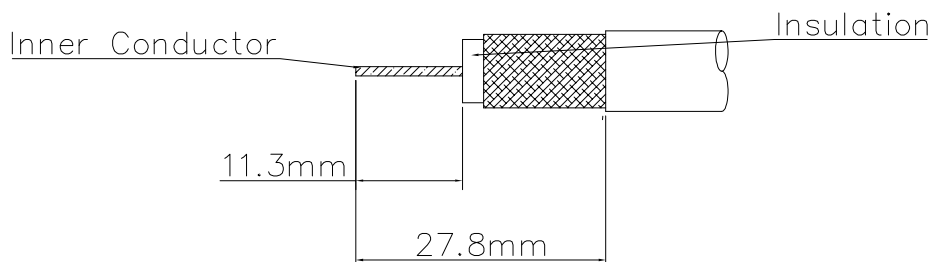
3. Cut the screen back to 14.8mm



4. Slide the crimp anvil over the insulation but under the screen.

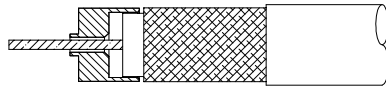


5. Cut back the insulation to expose 11.3mm of the inner conductor.

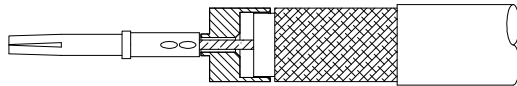


## Co-ax

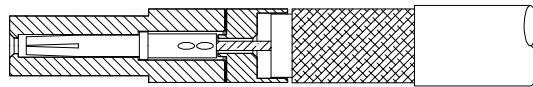
6. Slide Insulating Spacer over the inner conductor.



7. Place the Inner Pin or Socket contact over the conductor and crimp using the specified crimp tool.

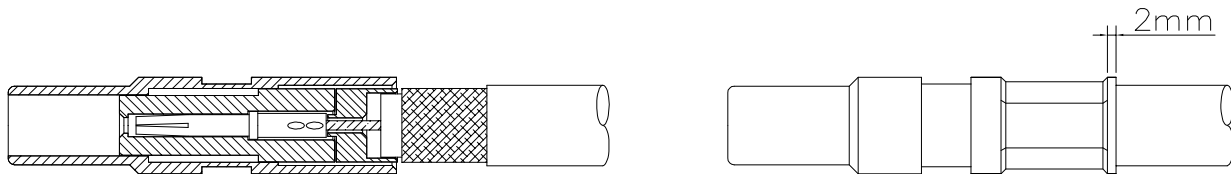


8. Slide the Inner Pin or Socket Insulator over the Inner Contact.



9. Slide the Outer Contact over the whole assembly, ensure that the screen is trapped between the Outer Contact and the Crimp Anvil. Firmly press all components together. Crimp outer contact using specified crimp tool, approximately 2mm in from the end of the contact.

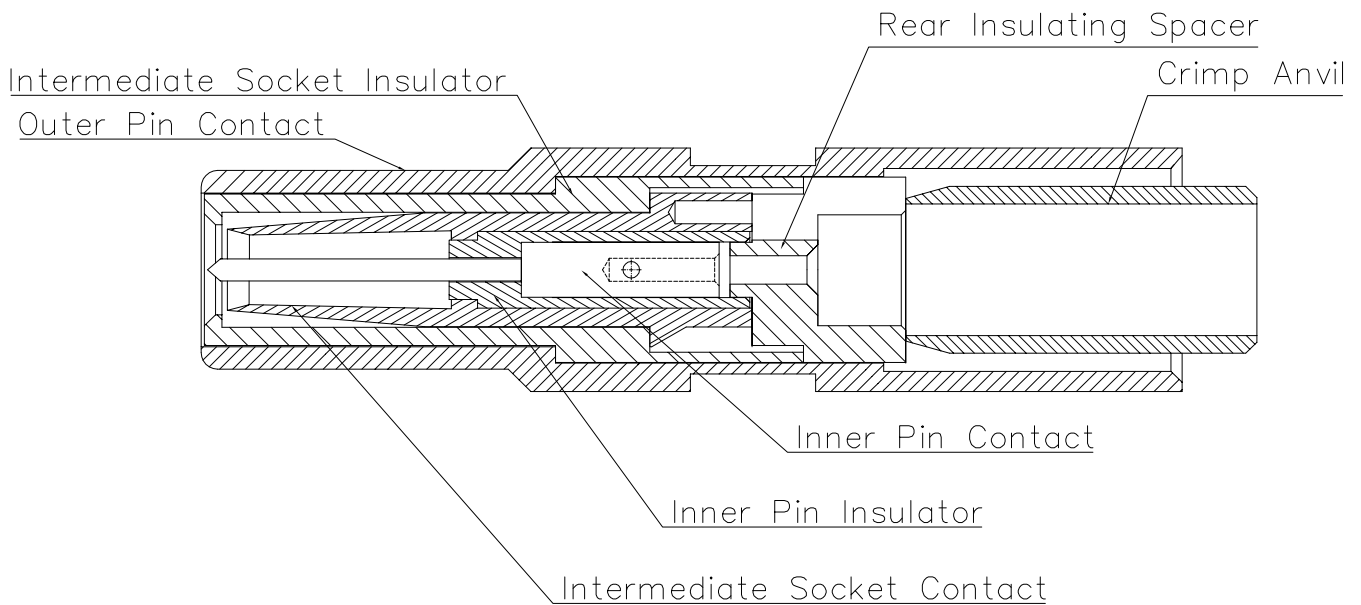
NB Due to the various screen thickness available it may be necessary to only partially close the crimp tool. Once a setting has been established a piece of shim can be used to set the required gap.



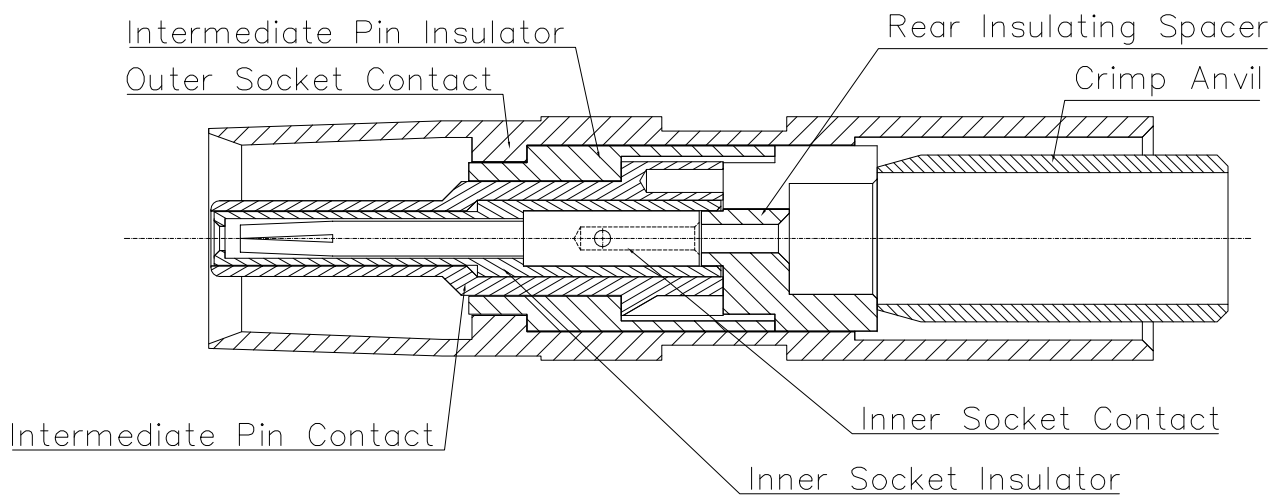
10. Trim of any excess screen protruding from the back of the contact.

## Twin-ax Contacts Contact Description & Terminology

### Pin Contact



### Socket Contact



### Twin-ax

The following assembly method caters for Twinax Contacts to be crimped on to 0.5/0.6/0.75/1.0mm<sup>2</sup> Twinaxial cable.

Please Note that the procedure is the same for Pin & Socket Contacts.

Contact Part No's: ABB-4-TKPK-F80-P1 / ABB-4-TSK-F80-P1  
 ABB-4-TKPK-F80-P1-001 / ABB-4-TSK-F80-P1-001

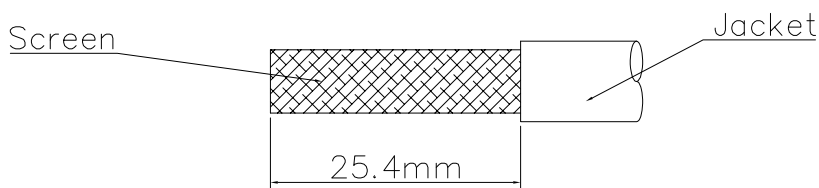
Cable: 0.5mm<sup>2</sup> / 0.6mm<sup>2</sup> / 0.75mm<sup>2</sup> / 1.0mm<sup>2</sup>

Crimping Tools: Inner Contact: AF8 (setting No 4) with TH608 Turret Head

Intermediate Contact: HX4 with Y946 Die Set

Outer Contact: D55E/D51 with HD51-150 Die Set

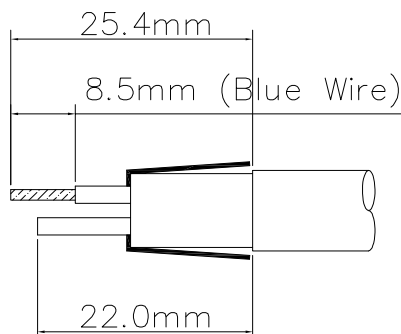
1. Cut the end of the cable squarely, do not crush.
2. Strip the Outer Jacket to 25.4mm. Use care not to nick the screen.  
 At this point peel back screen and cut away any protective tape covering the inner conductors, also cut back as far as possible any drain wires in the inner core.



3. Slide the crimp anvil over the screen until it hits the outer jacket. Fold screen back over crimp anvil and tape in position.



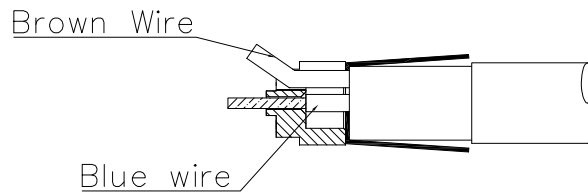
4. Cut back the inner wires (Blue & Brown) to the dimensions shown.



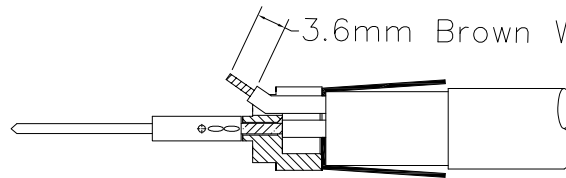


## Twin-ax

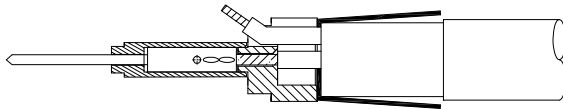
5. Separate both wires, push the blue wire through the hole in the Rear Insulating Spacer. Push spacer back until it touches the crimp anvil.



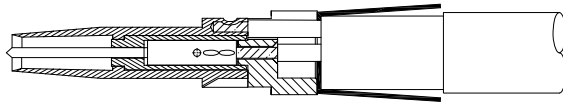
6. Place the Inner Pin or Socket contact over conductor and crimp using the specified crimp tool. Strip Brown wire to dimension shown.



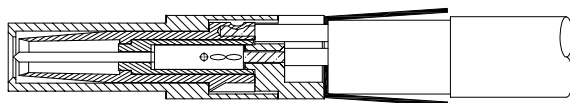
7. Push inner Pin or socket insulator firmly over the inner contact.



8. Fit the intermediate Pin or Socket contact over the inner contact assembly. Press the brown wire into the slot in the insulating spacer and push its conductors into the hole in the intermediate contact. Crimp using the specified tool and dies, ensuring to locate the slot in the contact onto the key in the crimp die.



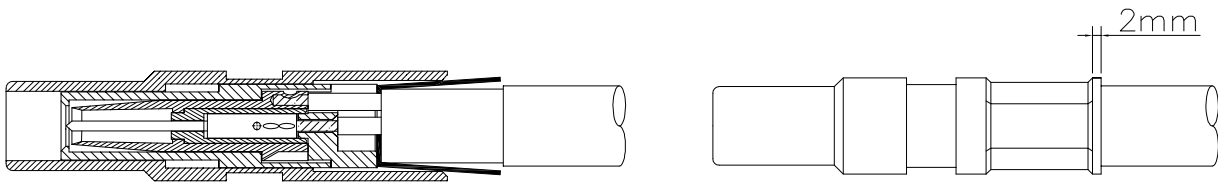
9. Fit the intermediate pin or socket insulator over the intermediate contact. Make sure the brown wire is tucked inside the insulator.



### Twin-ax

10. Remove the tape from the screen. Push the outer contact over the whole assembly, ensure that the screen is trapped between the outer contact and the crimp anvil. Firmly press all components together. Crimp using the specified tool, approximately 2mm in from the end of the contact.

NB Due to the various screen thickness available it may be necessary to only partially close the crimp tool. once a setting has been established a piece of shim can be used to set the required gap.



11. Trim of any excess screen protruding from the back of the contact.