



****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.

K. FOLD THE BRAID BACK OVER THE ANVIL. INSERT THE CONTACTS INTO THE REAR INSERT CARRIER AS PER WIRING DETAIL. SEE PAGE 5 FOR INSERT REAR DETAILS.

L. SLIDE THE FRONT INSERT SLEEVE OVER THE ASSEMBLY.

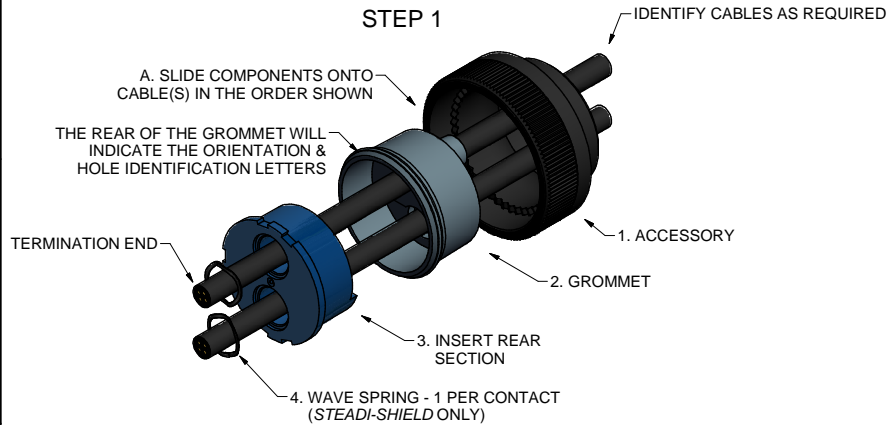
M. SLIDE THE OUTER CONTACT OVER THE ASSEMBLY, ENSURING THAT THE INTERNAL KEY ALIGNS TO THE SLOTTED KEY ON THE INNER INSERT ASSEMBLY. PUSH THE OUTER CONTACT UP TO THE ANVIL.

Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins	Created Date: 28/05/2010	Revision: F	ECH: 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.	 <small>ab Connectors Ltd is a subsidiary of STT Electronics plc. This document and the information contained herein may not be copied, used or disclosed, in whole or in part, except with the prior written permission of ab Connectors Ltd, or if this document has been produced under a contract with another party as expressly authorised under that contract. It is supplied without liability for errors or omissions.</small>	Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID
	Issued By: Darren Tucker	Issued Date: 08/02/2017	Description of last change:					Material: N/A
	Checked By: Rory Watkins	Checked Date: 08/02/2017	(REF: SHT 3) UPDATED TOOLING INFORMATION TO: MULTI CORE CONTACT CRIMP TOOL TABLE. UPDATED NOMENCLATURE					Drawing Number: SPEC-595
	Approved By: Rory Watkins	Approval Date: 08/02/2017						

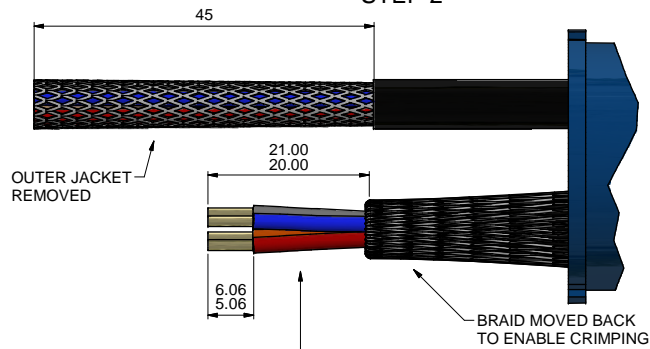
Sheet
1 of 7

QUADRAX CONTACT ASSEMBLY

STEP 1

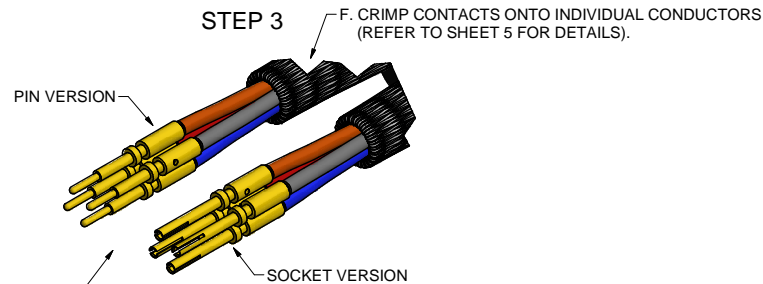


STEP 2



- 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.

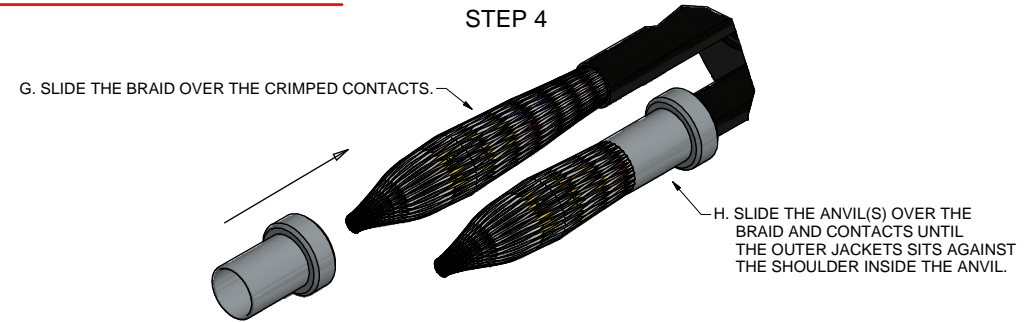
STEP 3



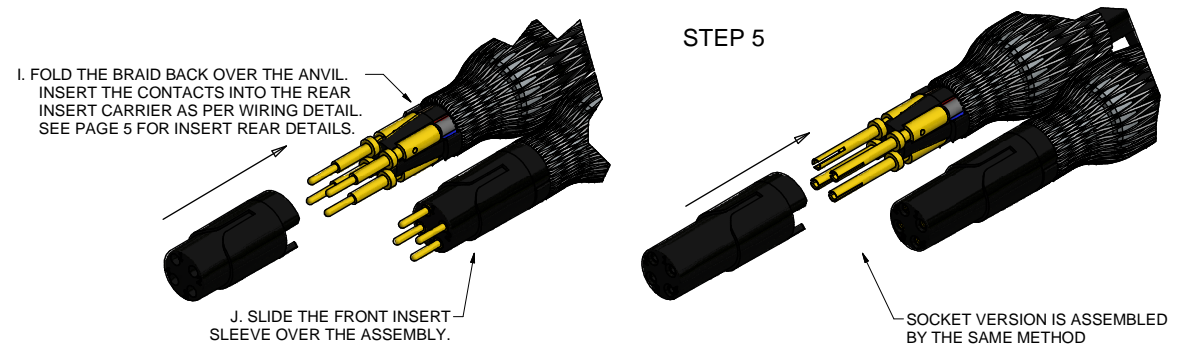
NOTE: STEP 3 FOR THE PURPOSE OF THIS ASSEMBLY AID BOTH MALE AND FEMALE CONTACTS HAVE BEEN ILLUSTRATED TO INDICATE IT IS THE SAME PROCESS FOR BOTH.

DURING A NORMAL BUILD ONLY 1 GENDER WOULD BE USED.

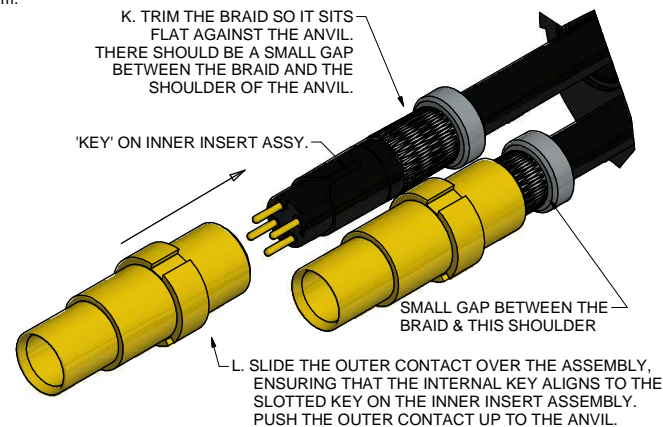
STEP 4



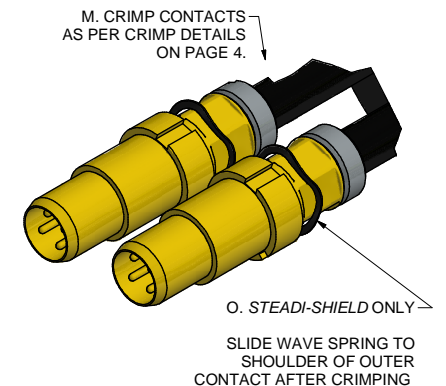
STEP 5



STEP 6



STEP 7



Tolerance Details (Unless Otherwise Stated):

Created By: Rory Watkins
Created Date: 28/05/2010
Issued By: Darren Tucker
Issued Date: 08/02/2017
Checked By: Rory Watkins
Checked Date: 08/02/2017
Approved By: Rory Watkins
Approved Date: 08/02/2017

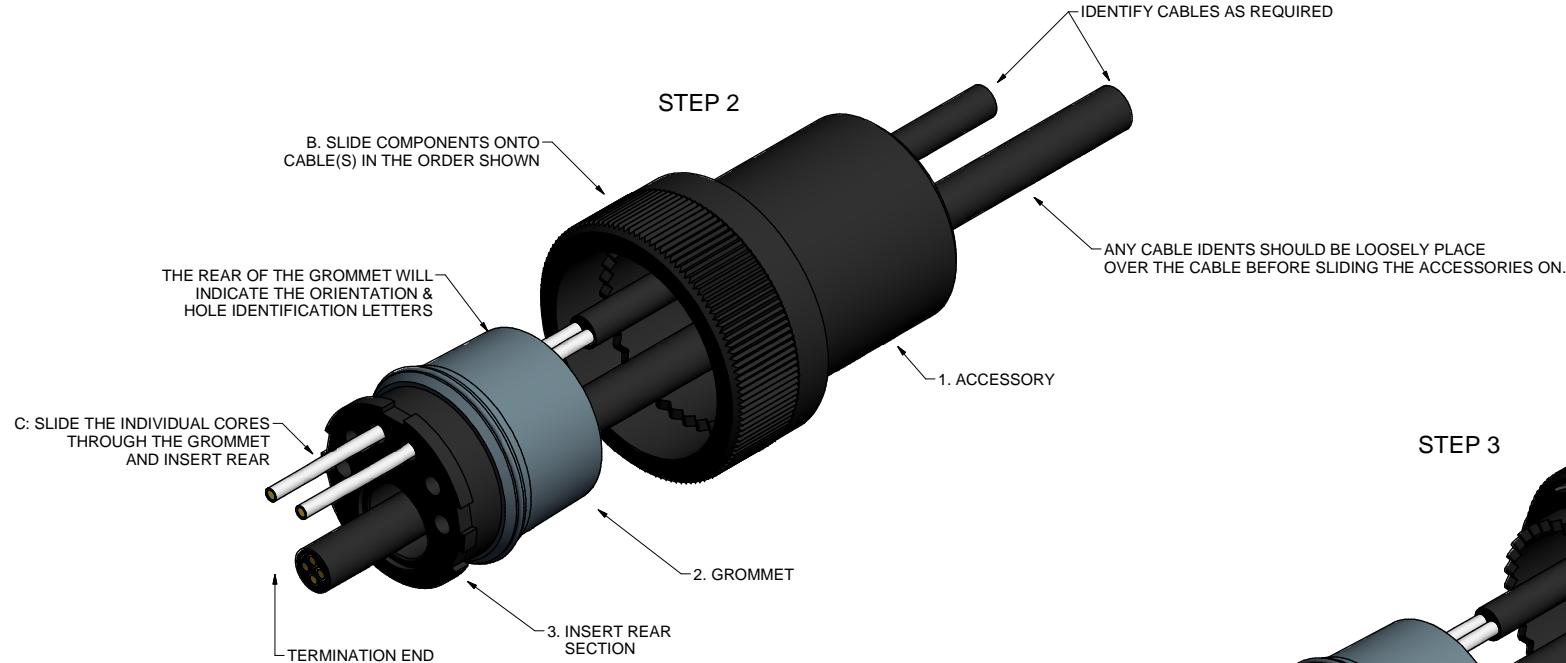
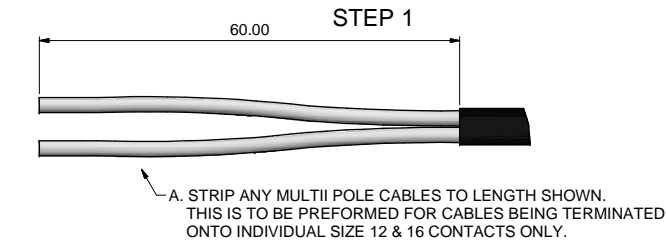
Revision: ECH: F N/A
Description of last change:
(REF: SHT 5)
UPDATED TOOLING INFORMATION TO: MULTI CORE CONTACT CRIMP TOOL TABLE.
UPDATED NOMENCLATURE

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.

ab Connectors
Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID
Material: N/A
Drawing Number: SPEC-595

Sheet: 2 of 7

INDIVIDUAL SIZE 12 & 16 CONTACT ASSEMBLY



NOTE:

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

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

Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins Issued By: Darren Tucker Checked By: Rory Watkins Approved By: Rory Watkins	Created Date: 28/05/2010 Issued Date: 08/02/2017 Checked Date: 08/02/2017 Approval Date: 08/02/2017	Revision: ECH: F N/A Description of last change: (REF: SHT 5) UPDATED TOOLING INFORMATION TO: MULTI CORE CONTACT CRIMP TOOL TABLE UPDATED NOMENCLATURE	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.	<p>ab Connectors is a subsidiary of STT Electronics plc. This document and the information contained herein may not be copied, used or disclosed, in whole or in part, except with the prior written permission of ab Connectors LTD, or if this document has been produced under a contract with another party as expressly authorised under that contract. It is supplied without liability for errors or omissions.</p>	<p>Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID</p> <p>Material: N/A</p> <p>Drawing Number: SPEC-595</p> <p>Sheet: 3 of 7</p>
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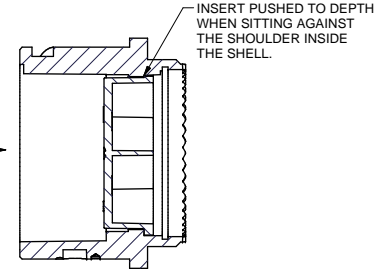
STEP 8.a - STANDARD ABMP SHELL

SECTION VIEW

TO ILLUSTRATE THE INTERNAL KEY
IT HAS BEEN HIGHLIGHTED IN YELLOW



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

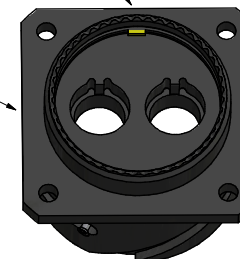


INSERT PUSHED TO DEPTH
WHEN SITTING AGAINST THE
SHOULDER INSIDE THE SHELL.

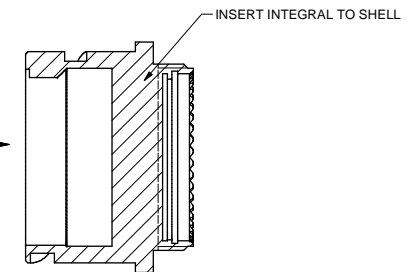
STEP 8.b - STEADI-SHIELD ABMP SHELL

SECTION VIEW

TO ILLUSTRATE THE INTERNAL KEY
IT HAS BEEN HIGHLIGHTED IN YELLOW

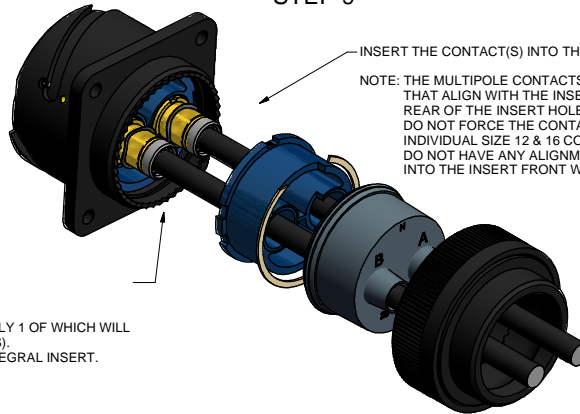


POLARISATION OF INTEGRAL
INSERT IS FIXED



INSERT INTEGRAL TO SHELL

STEP 9



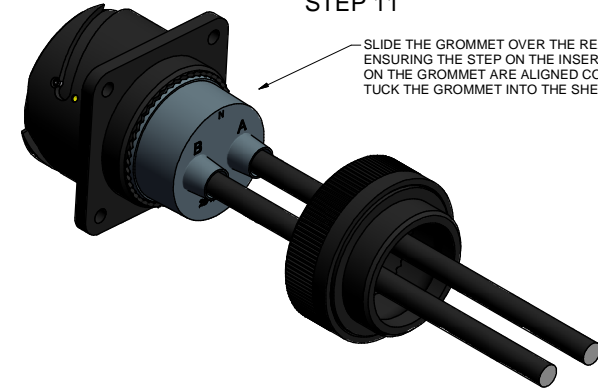
INSERT THE CONTACT(S) INTO THE SHELL AND INSERT ASSEMBLY.

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.

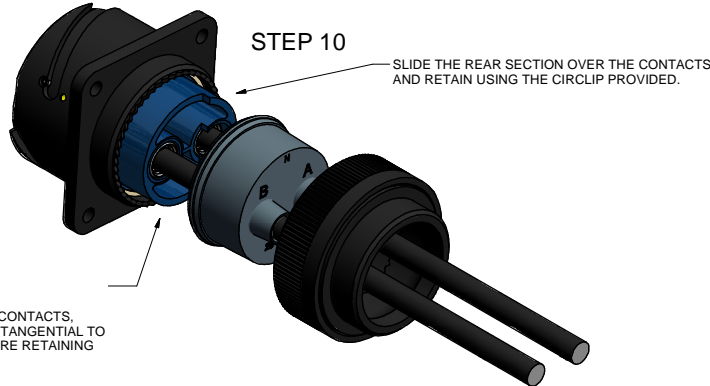
NOTE: THE MULTIPOLE CONTACTS HAVE 3 KEYS, ONLY 1 OF WHICH WILL
FIT THE KEY IN THE INTEGRAL INSERT HOLE(S).
DO NOT FORCE THE CONTACTS INTO THE INTEGRAL INSERT.

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:
MULTI-CORE CONTACT CRIMP TOOL TABLE.
UPDATED NOMENCLATURE.

Created By:
Rory Watkins
Issued By:
Darren Tucker
Checked By:
Rory Watkins
Approved By:
Rory Watkins

Created Date:
28/05/2010
Issued Date:
08/02/2017
Checked Date:
08/02/2017
Approval Date:
08/02/2017

Revision: ECH:
F N/A
Description of last change:
1. STEADI-SHIELD ASSEMBLY INSTRUCTIONS
ADDED
2. CRIMPING CHART UPDATED
3. ILLUSTRATIONS UPDATED TO ILLUSTRATE
MOULDED INSERTS

Third Angle
Projection



Information:
• Unless otherwise stated, all dimensions are in mm.
• V denotes a critical characteristic.
• D 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
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Description:
MULTICORE CONTACT & MULTI CONTACT
CONNECTOR ASSEMBLY AID
Material:
N/A
Drawing Number:
SPEC-595

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

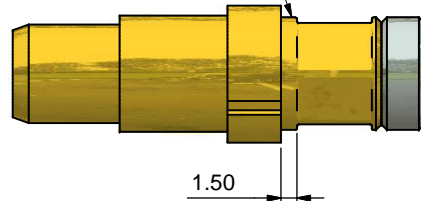
Crimp Size:

16



20

22

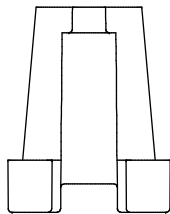
For crimping detail guidance see page 7



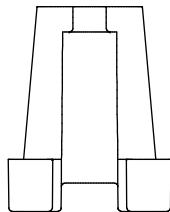
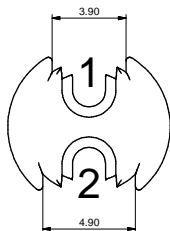
Contact Part Number	Wire CSA (mm²)	AWG	Tool Required	Tool Setting	Turret Locator / Die Set	Position
ABMPT16PA	0.93	16	ABB-FT8	4	ABB-UH2-5 (Adjustable)	----
	1.5			5		
ABMPT16SA	0.93			4		
	1.5			5		
ABMPTR16PA	0.93		ABB-FT8	4	ABB-TH608	Blue
	1.5			5		
ABMPTR16SA	0.93			4		
	1.5			5		
ABMPQ16PA	0.93			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-TH608	Blue
ABMPT20SA						
ABMPTR20PA						
ABMPTR20SA						
ABMPQ20PA			ABB-FT8	3	ABB-TH608	Blue
ABMPQ20SA						
ABMPT22PA		22	ABB-FT8	2	ABB-UH2-5 (Adjustable)	----
	0.34			3		
ABMPT22SA	0.2 - 22			2		
	0.34			3		
ABMPTR22PA	0.2 - 22		ABB-FT8	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)	----
ABMP1620KLKP3						
ABMP####PA	Ø8.1	----	ABBPL0550A1130	----	ABT.00004	----
ABMP####SA	Max Cable Dia.	----	ABB-D51	----		

Tolerance Details (Unless Otherwise Stated):	Created By: Rory Watkins	Created Date: 28/05/2010	Revision: F	ECN: N/A	Third Angle Projection: 	<div>Information: • Unless otherwise stated, all dimensions are in mm. • ∇ denotes a critical characteristic. • ∅ denotes a significant characteristic. • Drawing conforms to AS-W07-03-01. • Finishing codes conform to PED-021. • In the event of conflict between information contained within this drawing, and AS-W07-03-01, the information contained within this drawing takes precedence.</div> <div> © AB Connectors Ltd a subsidiary of ©TT Electronics plc. This document and the information contained herein may not be copied, used or disclosed, in whole or in part, except with the prior written permission of AB Connectors LTD, or if this document has been produced under a contract with another party as expressly authorised under that contract. It is supplied without liability for errors or omissions.</div>	<div>Description: MULTICORE CONTACT & MULTI CONTACT CONNECTOR ASSEMBLY AID</div> <div>Material: N/A</div> <div>Drawing Number: SPEC-595</div>	Sheet: 5 of 7
	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						

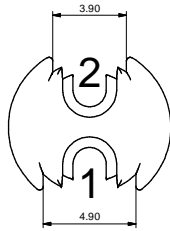
TWINAX



REAR VIEW
SOCKET INSERT CARRIER

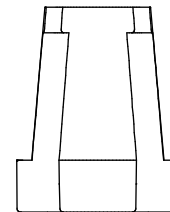


REAR VIEW
PIN INSERT CARRIER

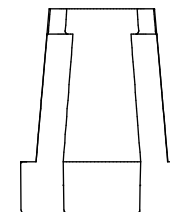
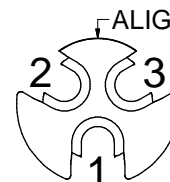


NOTE:
REAR VIEW OF ABIC_013#_IR
THIS COMPONENT IS COMMON
TO BOTH THE PIN & SOCKET
CONTACT ASSEMBLIES.

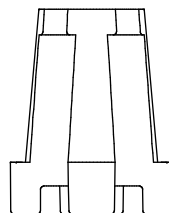
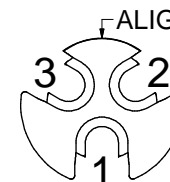
TRIAx



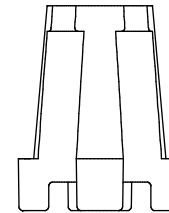
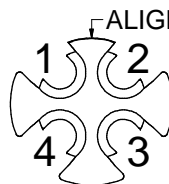
REAR VIEW
SOCKET INSERT CARRIER



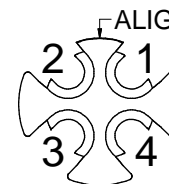
REAR VIEW
PIN INSERT CARRIER



REAR VIEW
SOCKET INSERT CARRIER

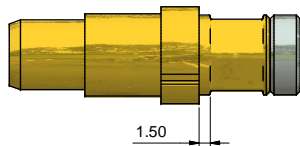


REAR VIEW
PIN INSERT CARRIER

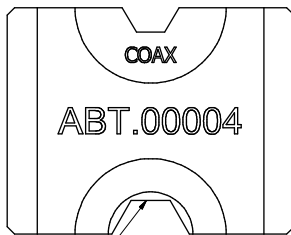
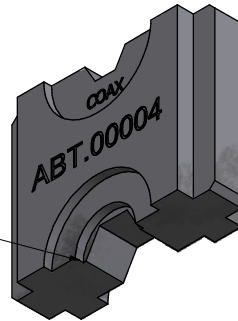


QUADRAx

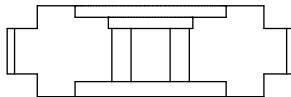
FINISHED CRIMP DETAIL



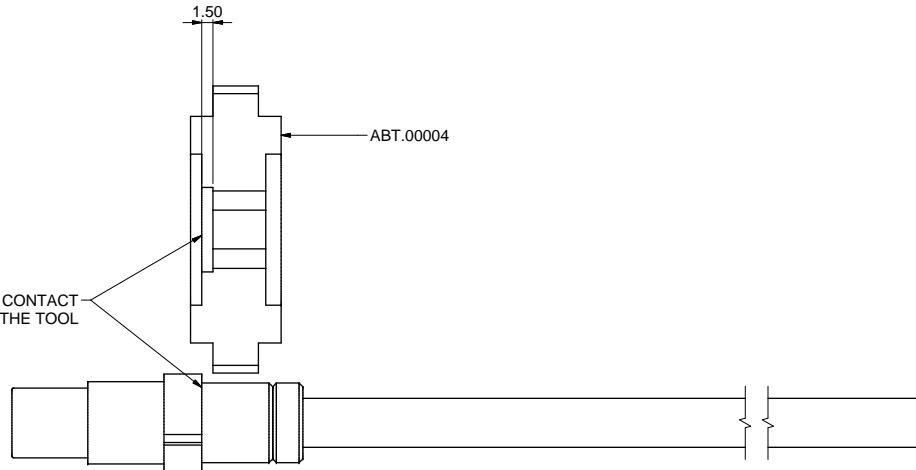
UNDERCUT FOR 1.5mm
GAP TO SHOULDER ON CONTACT



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:
Rory Watkins
Issued By:
Darren Tucker
Checked By:
Rory Watkins
Approved By:
Rory Watkins

Created Date:
28/05/2010
Issued Date:
08/02/2017
Checked Date:
08/02/2017
Approval Date:
08/02/2017

Revision: ECH:
F N/A
Description of last change:
1. STEADI-SHIELD ASSEMBLY INSTRUCTIONS
ADDED
2. CRIMPING CHART UPDATED
3. ILLUSTRATIONS UPDATED TO ILLUSTRATE
MOULDED INSERTS

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.
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CONNECTOR ASSEMBLY AID
Material:
N/A
Drawing Number:
SPEC-595

Sheet:
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