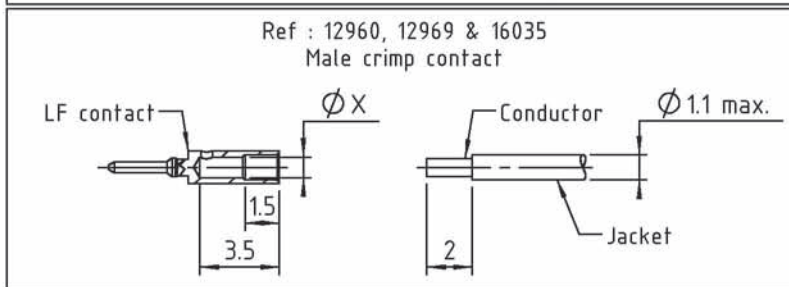
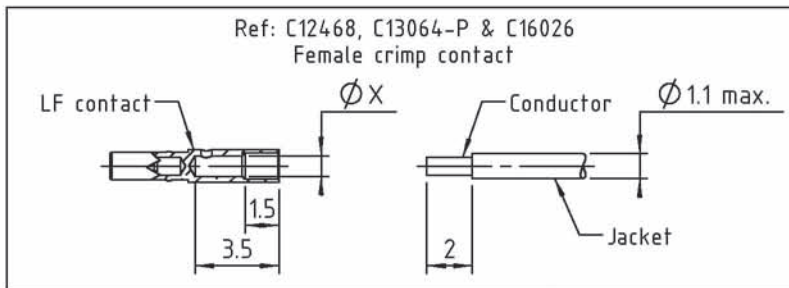


Cable instructions (ICLF01)

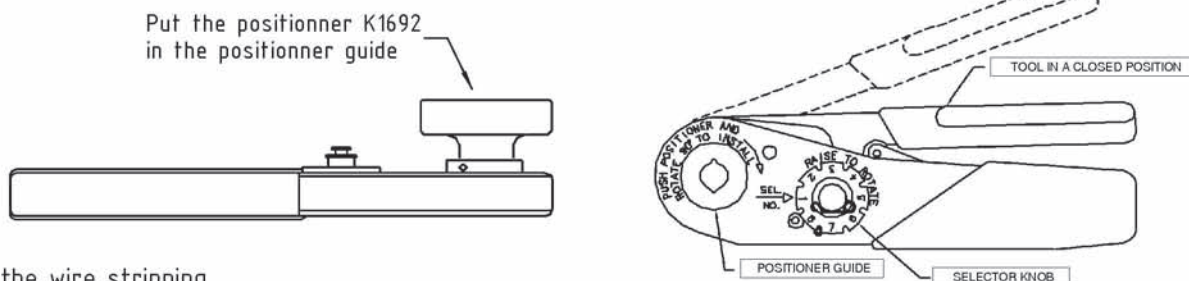
Diameter X	
Reference	X
12969	0.7
16035	
C12468	
C16026	
12960	0.9
C13064-P	



Crimp barrel accommodation					
Reference	Contact Type	Wire size (AWG)	Tool		
			Hand crimp tool reference	Positionner	Crimp tool setting
12960	Male C	22	DANIELS MH800	K1692	6
12969	Male S	24			7
16035	Male S	26 & 28			6
12969	Male S	26 & 28			6
16035	Male S	26 & 28			6
C13064-P	Female C	22			6
C12468	Female S	24			7
C16026	Female S	26 & 28			6

1 - Set the Hand crimp tool according to Crimp barrel accommodation table above

- 1.1 - Select the crimp tool setting with the selector knob.
- 1.2 - Put the Positionner K1692 in the positionner guide.



2 - Check the wire stripping

- 2.1 - Insert the Wire in the contact
- 2.2 - The conductor must be visible through the inspection window of the contact



3 - Insert the contact and Wire assembly in the crimp guide of the hand crimp tool

- 3.1 - In the crimp guide, the contact and Wire assembly must be in the end stop position
- 3.2 - During the crimping, keep the wire in position
- 3.3 - Just one crimping operation is allowed per contact and wire assembly

4 - Visually check the crimping

- 4.1 - The crimping must not deform the inspection window
- 4.2 - The contact must not have visible fractures or cracks
- 4.3 - The contact barrel must not be deformed or bent

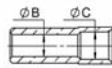
5 - Check the contact is firmly crimped, by pulling gently

- 5.1 - For that purpose two (2) fingers are enough : pinch the wire and pull smoothly along the axis of the crimped contact.

Cable instructions

HF CONTACTS						CONNECTION MODE		
Supplier	P/N	Ø Cable	Series	Gender	Ref. contact	Central contact	Shield	Impedance
Nexans (Axon *)	50VMTX (SM 50 *)	1,2 mm	HF30	Male	30-1312-ZS-01 (30-1312-ZS-02 *)	Solder	Crimped Hex. 1,9 mm	50 Ohm
					30-1412-ZS			
				Female	30-2312-ZS-01 (30-2312-ZS-02 *)			
				30-2412-ZS				
			HF22	Male	22-1312-ZS-01 (22-1312-ZS-02 *)			
				Female	22-2312-ZS-01 (22-2312-ZS-02 *)			
	75VMTX (SM 75 *)	1,2 mm	HF30	Male	30-1312-ZS-75-01 (30-1312-ZS-75-02 *)	Solder	Crimped Hex. 1,9 mm	75 Ohm
					30-1412-ZS-75			
				Female	30-2312-ZS-75-01 (30-2312-ZS-75-02 *)			
				30-2412-ZS-75				
			HF22	Male	22-1312-ZS-75-01 (22-1312-ZS-75-02 *)			
				Female	22-2312-ZS-75-01 (22-2312-ZS-75-02 *)			
Axon RG 178 DT	P500955	2,3 mm	HF30	Male	30-1320-DS 30-1420-DS	On choice Solder	Crimped Hex. 2,8 mm	50 Ohm
		Female		30-2320-DS 30-2420-DS	On choice Solder			
Axon PTFE Cellular	P 812817	2,3 mm	HF30	Male	30-1324-DS 30-1424-DS	On choice Solder	Crimped Hex. 2,8 mm	50 Ohm
				Female	30-2324-DS 30-2424-DS	On choice Solder		
	P 804298 B	2,4 mm	HF30	Male	30-1324-DS-75 30-1424-DS-75	On choice Solder	Crimped Hex. 2,8 mm	75 Ohm
				Female	30-2324-DS-75 30-2424-DS-75	On choice Solder		
Axon RG 316 DT	P0530912	2,7 mm	HF30	Male	30-1326-DS 30-1426-DS	On choice Solder	Crimped Hex. 3,25 mm	50 Ohm
				Female	30-2326-DS	On choice		
					30-2426-DS	Solder		
Axon RG 179 DT	P530268	3 mm	HF30	Male	30-1326-DS-75 30-1426-DS-75	On choice Solder	Crimped Hex. 3,25 mm	75 Ohm
				Female	30-2326-DS-75	On choice		
					30-2426-DS-75	Solder		

DT = DS (Double Shield)

	ØB	ØC	Sleeve
P/N terminal -01 for 50VMTX cable type	1 mm	1,25 mm	
P/N terminal -02 for SM 50 cable type	0,85 mm	1,15 mm	

Cable instructions

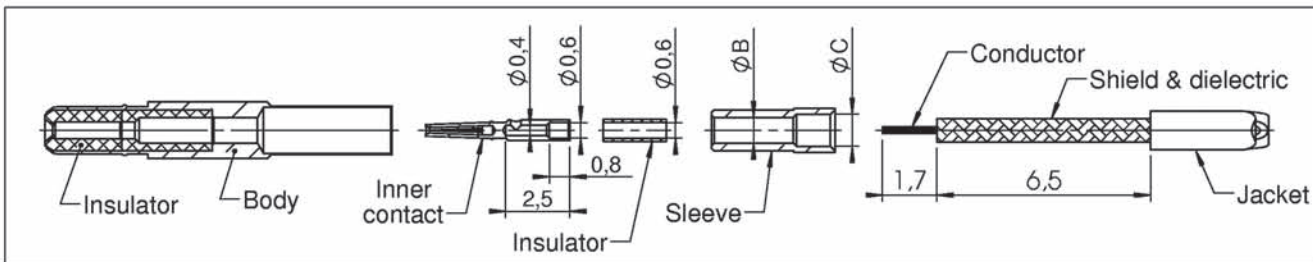
NORMES			HF CONTACTS			CONNECTION MODE			
MIL-C-17	NF C93-550	Ø Cable	Series	Gender	Ref. contact	Central contact	Shield	Impedance	
RG 178	KX 21 A	2 mm	HF30	Male	30-1320-SS	Crimped	Crimped Hex. 2,4 mm	50 Ohm	
					30-1320-ZS	Solder			
				30-1420-ZS	Solder				
				30-2320-SS	Crimped				
			HF22	Male	30-2320-ZS	Crimped	Solder		Solder
					30-2420-ZS	Solder			
				Female	22-1320-ZZ	Crimped			
					22-2320-ZZ	Solder			
RG 316	KX 22 A	2,7 mm	HF30	Male	30-1326-SS	Crimped	Crimped Hex. 2,8 mm	50 Ohm	
					30-1326-ZS	Solder			
				30-1426-ZS	Solder				
			Female	30-2326-SS	Crimped				
				30-2326-ZS	Solder				
				30-2426-ZS	Solder				
RG 174	KX 3 B	2,7 mm	HF30	Male	30-1326-SS	Crimped	Crimped Hex. 2,8 mm	50 Ohm	
					30-1326-ZS	Solder			
				30-1426-ZS	Solder				
			Female	30-2326-SS	Crimped				
				30-2326-ZS	Solder				
				30-2426-ZS	Solder				
RG 179		2,7 mm	HF30	Male	30-1326-SS-75	Crimped	Crimped Hex. 2,8 mm	75 Ohm	
					30-1326-ZS-75	Solder			
				30-1426-ZS-75	Solder				
			Female	30-2326-SS-75	Crimped				
				30-2326-ZS-75	Solder				
				30-2426-ZS-75	Solder				

COAX CABLE

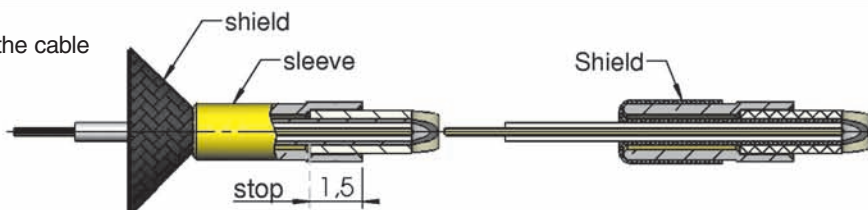
			HF CONTACTS			CONNECTION MODE		
Supplier	P/N	Ø Cable	Series	Gender	Ref. contact HF	Central contact	Shield	Impedance
	UT47	1,2 mm	HF30	Male	30-1347-ZZ	Solder	Solder	50 Ohm
					30-1447-ZZ			
				Female	30-2347-ZZ			
					30-2447-ZZ			
(Axon *)	UT85 (QFX 86 SPCW *)	2,2 mm	HF30	Male	30-1385-ZZ	Solder	Solder	50 Ohm
					30-1485-ZZ			
				Female	30-2385-ZZ			
					30-2485-ZZ			

SEMI-RIGID

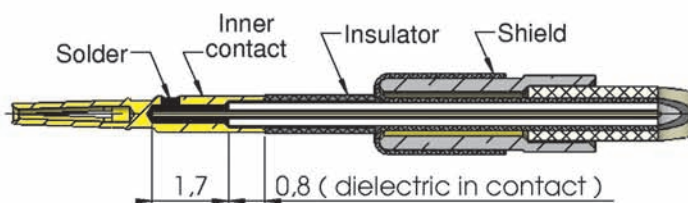
Cable instructions (IC22HF01)



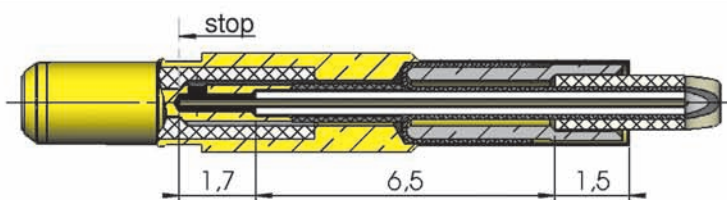
- 1 - Thread the sleeve until stop onto the cable
- Place the shield on the sleeve



- 2 - Thread the insulator
- Solder the inner contact on the conductor

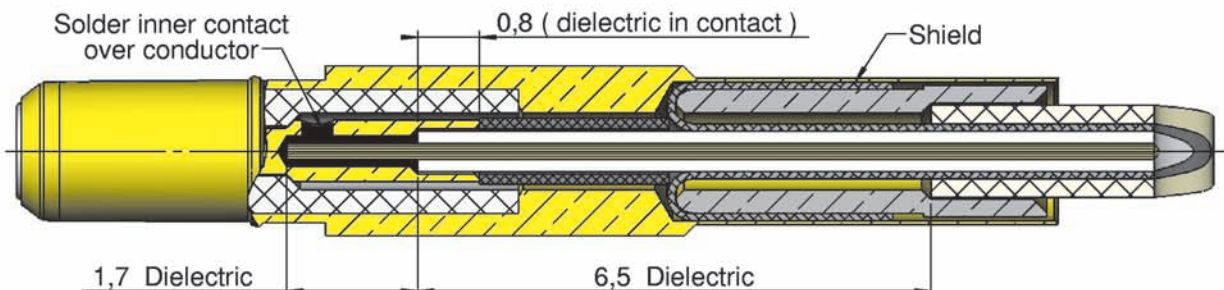
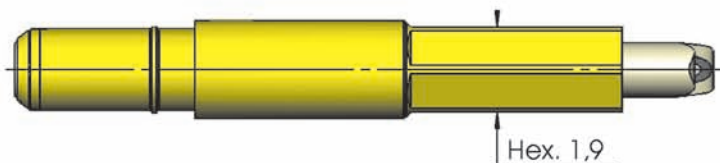


- 3 - Thread to the body.

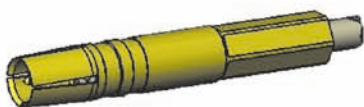


- 4 - CRIMP

- Tool : DANIELS HX3
- Die : C13847
- Hexagone : 1,9 mm / flat
- Position : 8,95 mm



Female HF contact

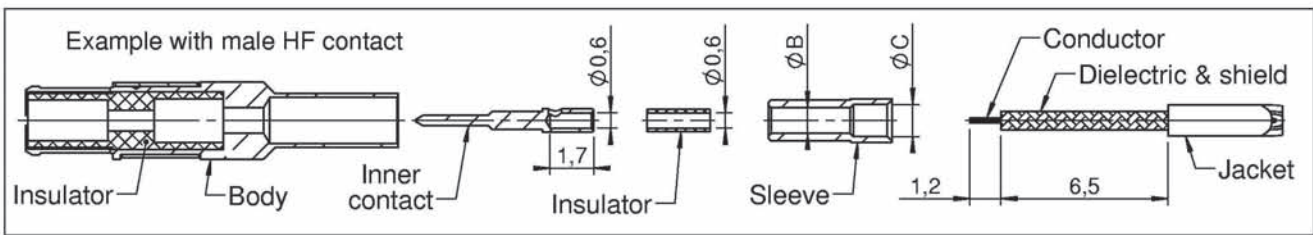


	ØB	ØC	Sleeve	
			ØB	ØC
P/N terminal -01	1	1,25		
P/N terminal -02	0,85	1,15		

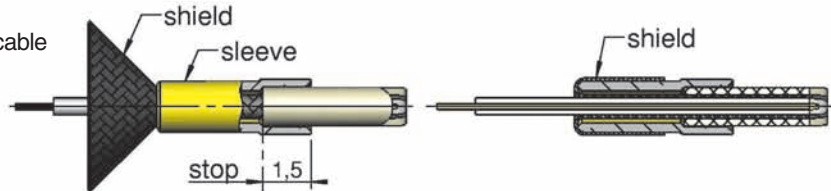
Male HF contact



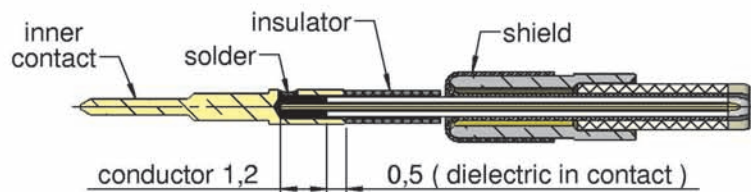
Cable instructions (IC30HF01)



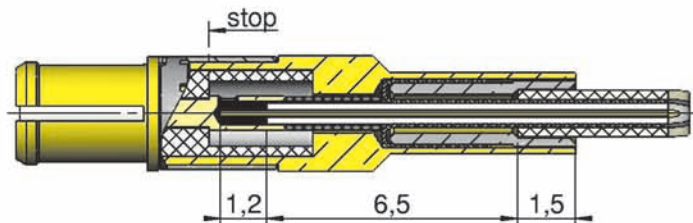
- 1 - Thread the sleeve until stop onto the cable
- Place the shield on the sleeve



- 2 - Thread the insulator
- Solder the inner contact on the conductor

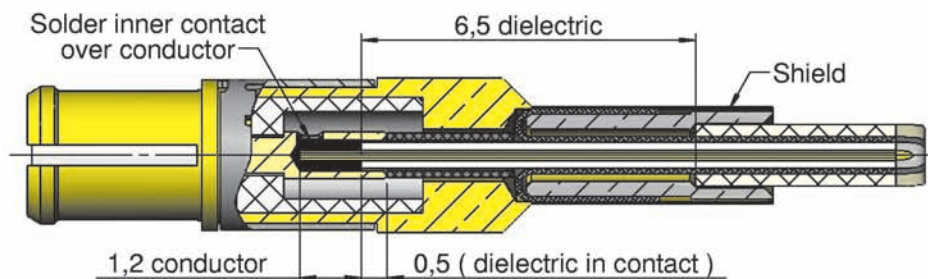
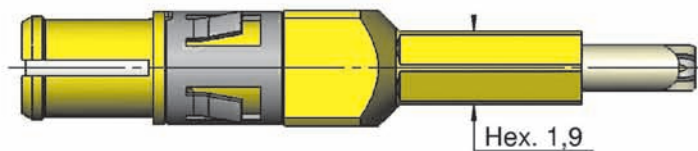


- 3 - Thread to the body.

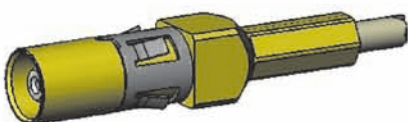


- 4 - CRIMP

- Tool : DANIELS HX3
- Die : C13847
- Hexagone : 1,9 mm / flat
- Position : 9,95 mm

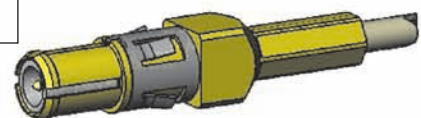


Female HF contact

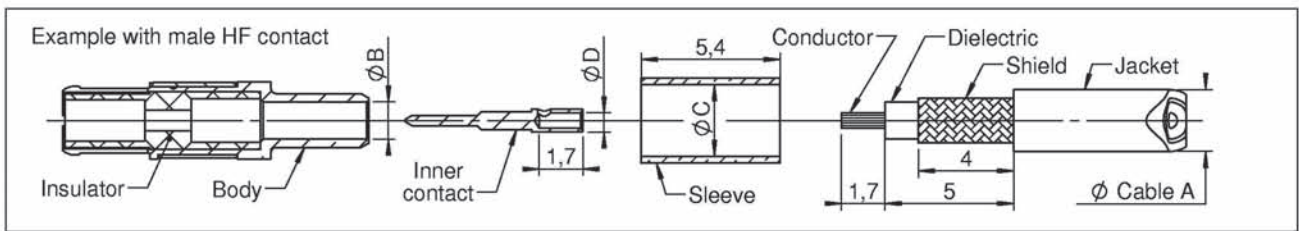


	Sleeve	
	$\varnothing B$	$\varnothing C$
P/N terminal -01	1	1,25
P/N terminal -02	0,85	1,15

Male HF contact

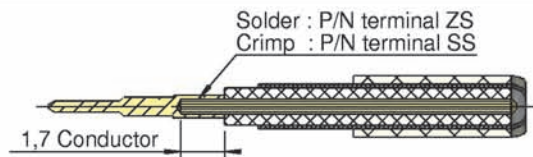


Cable instructions (IC30HF02)

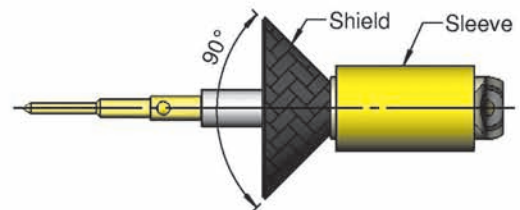


	Cable ØA	Body ØB	Sleeve ØC	Contact ØD	Central crimp DANIELS MH800		Hexagonal imprint E sleeve crimp DANIELS HX3 tool				
					Positioner K1131		Die C13847		Die C14680		
					Conductor Ø 0,3	Conductor Ø 0,5	Hex.1,9	Hex.2,4	Hex.2,8	Hex.3,25	Hex.4
30-x320-SS	2 mm	1 mm	2,2 mm	0,5 mm	Position 2 / 3	Position 3 / 4		x			
30-x320-DS	2,3 mm	1 mm	2,8 mm	0,5 mm					x		
30-x324-SS	2,4 mm	1,5 mm	2,8 mm	0,6 mm						x	
30-x326-SS	2,7 mm	1,7 mm	2,8 mm	0,6 mm							x
30-x326-DS	3 mm	1,7 mm	3,25 mm	0,6 mm							x

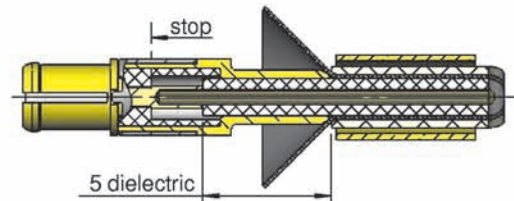
1 - Mount the inner contact on the conductor and solder or crimp.
(crimping with DANIELS MH800 positioner K1131)



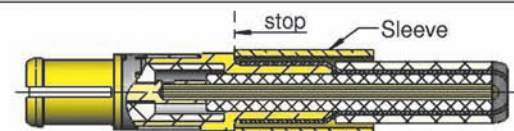
2 - Thread the sleeve onto the cable and bent the shield at 90°.



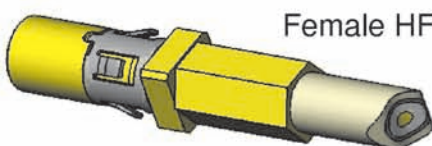
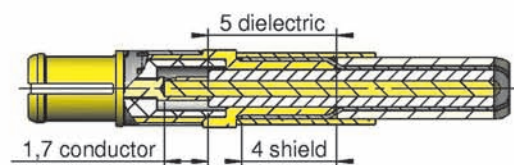
3 - Push until stop inside the body.



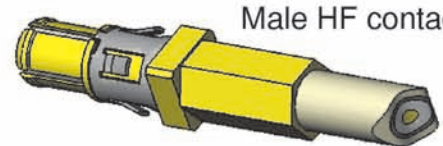
4 - Thread the sleeve until stop on the body so as to bent the shield.



5 - Crimp the sleeve



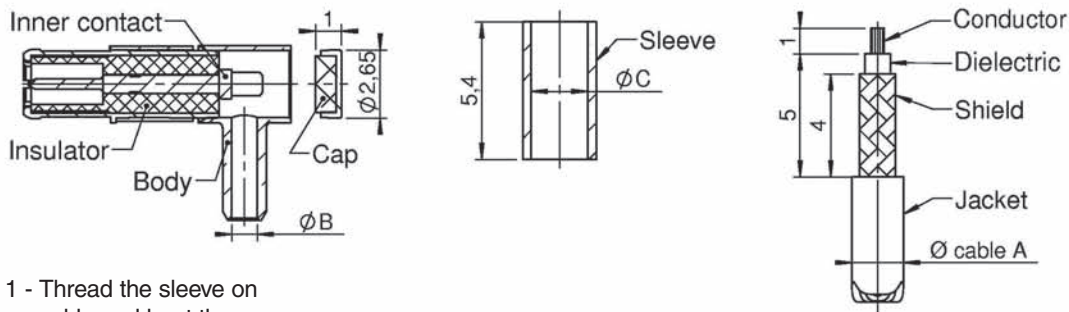
Female HF contact



Male HF contact

Cable instructions (IC30HF03)

Example with male HF contact



1 - Thread the sleeve on cable and bend the shield at 90°

2 - Place the inner contact until stop in the body. Insert the cable and solder the conductor onto the inner contact

3 - Thread the sleeve until stop on the body so as to bend the shield

4 - Crimp the sleeve with DANIELS HX3 tool and mount the back cap with tool P/N C14772

Hexagonal imprint E sleeve crimp DANIELS HX3 tool

	Cable ØA	Body ØB	Sleeve ØC	Contact	Die C13847			Die C14680	
					Hex.1,9	Hex.2,4	Hex.2,8	Hex.3,25	Hex.4
30-x412-ZS	1,2 mm	0,7 mm	1,3 mm	solder	x				
30-x420-ZS	2 mm	1 mm	2,2 mm	solder		x			
30-x420-DS	2,3 mm	1 mm	2,8 mm	solder			x		
30-x424-ZS	2,4 mm	1,5 mm	2,8 mm	solder			x		
30-x426-ZS	2,7 mm	1,7 mm	2,8 mm	solder			x		
30-x426-DS	3 mm	1,7 mm	3,25 mm	solder				x	

