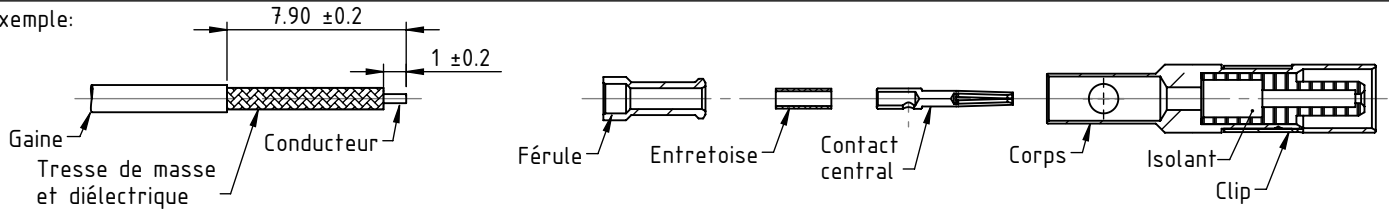


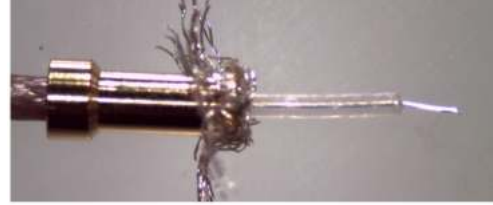
Exemple:



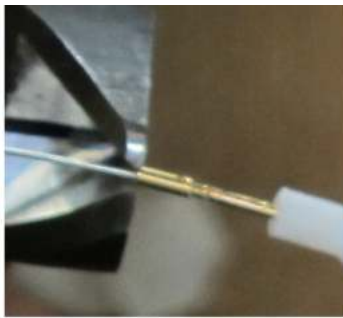
1/ 1.1 - Enfiler la férule en butée sur le câble



1.2 - Rebrousser la tresse de masse sur la férule.

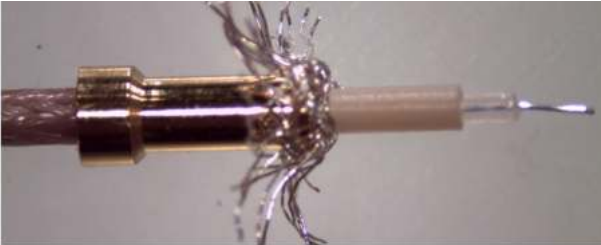


2/ 2.1 - Monter le contact central dans l'outillage C17750.  
2.2 - Insérer un fil d'étain dans la chambre du contact.  
2.3 - Couper le fil d'étain à ras du contact.



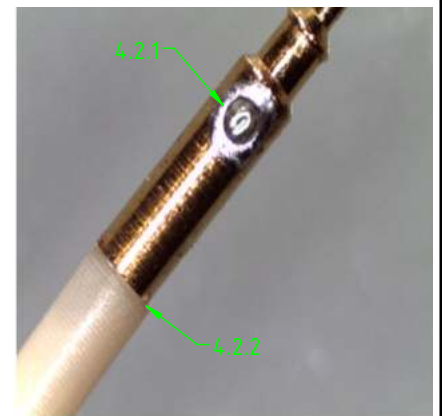
NICOMATIC recommande d'utiliser un fil d'étain Ø0.4mm

3/ 3.1 - Monter l'entretoise isolante sur le câble,



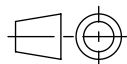
4/ 4.1 - Braser le contact central  
4.2 - Vérifier la brasure du contact central et la position de l'isolant :  
4.2.1 - la brasure peut sortir de la fenêtre d'inspection mais ne doit pas empêcher le montage  
4.2.2 - la bague isolante doit être à ras du contact.

NICOMATIC recommande d'utiliser une pince à effet joule



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Echelle/Scale  
3:1

|      |          |               |       |         |          |
|------|----------|---------------|-------|---------|----------|
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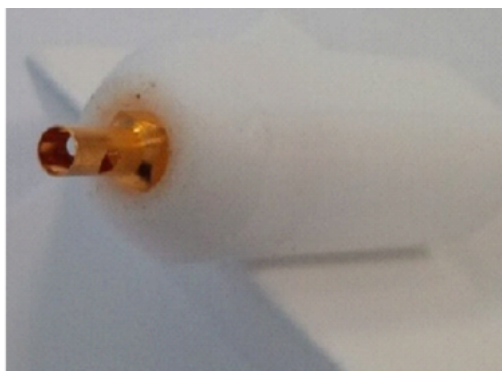
Designation : Instruction de câblage contact femelle  
HF à braser série 30

Ref : IC30HF05

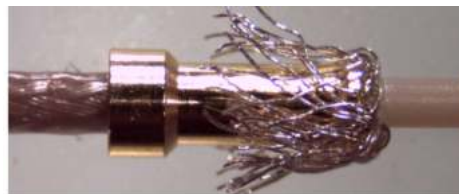
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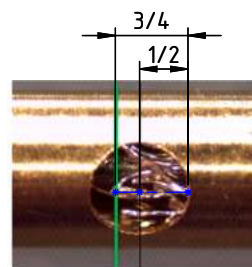
- 5/ 5.1 - Monter le contact central et le câble dans le corps :  
 5.1.1 - Monter le corps en buté dans l'outillage 17489.  
 5.1.2 - Rabattre la tresse sur la fêrulle,  
 5.1.3 - Insérer l'ensemble contact central soudé sur le câble.



5.1.1



5.1.2



5.2.1

- 5.2 - Vérification :  
 5.2.1 - Les brins de la tresse doivent couvrir au minimum les 3/4 du trou du corps

Côté : câble

Côté : Face avant du corps.

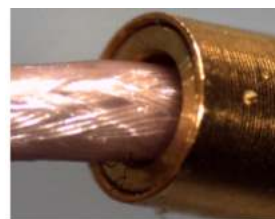
- 6/ 6.1 - Braser la tresse dans le corps :  
 6.1.1 - Chauffer la tresse par le trou du corps.  
 6.1.2 - Apporter de l'étain dans le trou,  
 6.1.3 - Reproduire l'opération dans le second trou

NICOMATIC recommande d'utiliser une panne de type LTK avec un fer à souder chauffé à 360°C et un fil d'étain Ø0.7 (99C) (longueur du fil 8 mm par trou).



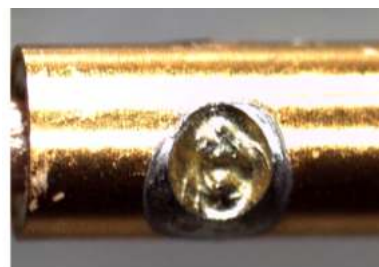
6.1

- 6.2 - Vérifier la position de la fêrulle :  
 6.2.1 - La fêrulle ne doit pas dépasser du corps



6.2

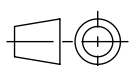
- 6.3 - Vérifier la brasure :  
 6.3.1 - Les brins de la tresse de masse sont recouverts d'étain.  
 6.3.2 - La brasure est en creux ou affleurante au corps.



6.3



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Echelle/Scale

4:1

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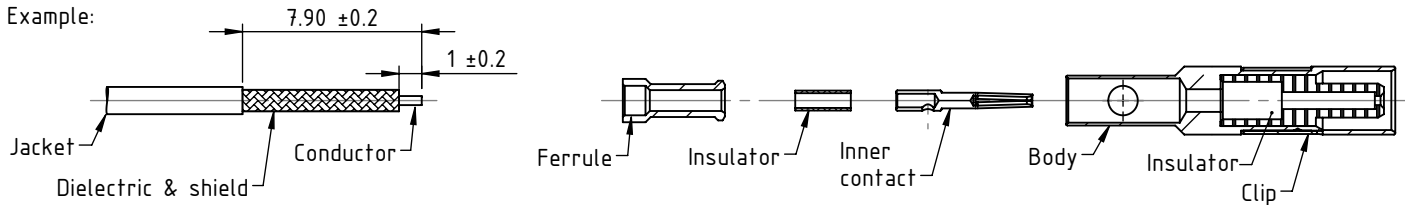
Designation : Instruction de câblage contact femelle  
 HF à braser série 30

Ref : IC30HF05

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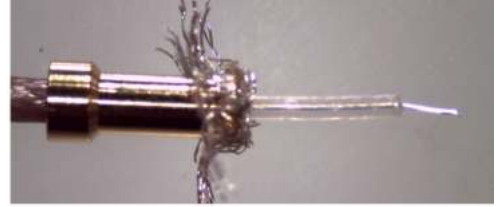
Example:



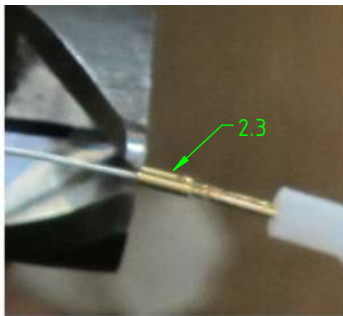
1/ 1.1 - Thread the ferrule to the stop on the cable.



1.2 - Brush back the shield onto the ferrule.

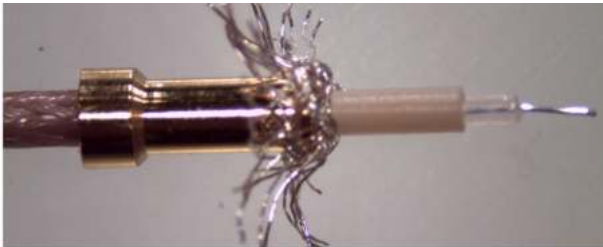


- 2/ 2.1 - Place the inner contact inside the tool C17750.
- 2.2 - Place the tin soldering wire inside the inner contact.
- 2.3 - Cut the tin soldering wire flush with the contact.



NICOMATIC recommends the use of a tin soldering wire with  $\varnothing 0.4\text{mm}$

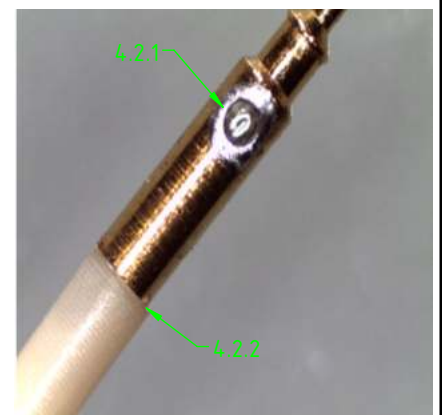
3/ 3.1 - Place the insulator over the dielectric.



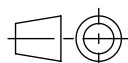
4/ 4.1 - Braise the inner contact

- 4.2 - Check the brazing of the inner contact and the location of the insulator :
  - 4.2.1 - The brazing can be outside the inspection window but it must not prevent the assembly.
  - 4.2.2 - the insulator must touch the inner contact.

NICOMATIC recommends the use of a Joule Effect Soldering Device



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Echelle/Scale  
 4:1

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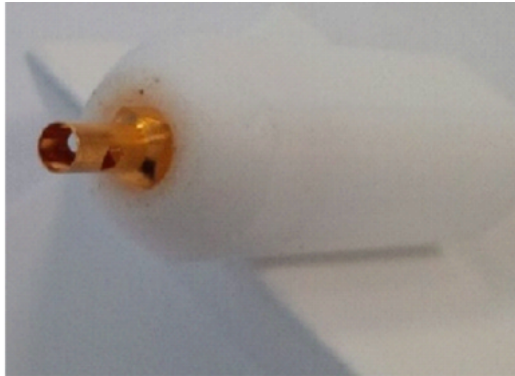
Designation : Cable instruction for HF female contact series 30 to braise

Ref : IC30HF05

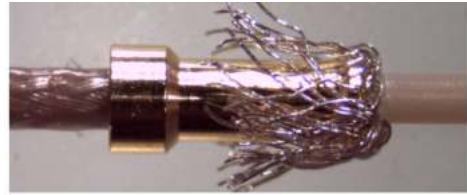
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5/ 5.1 - Assemble the subassembly of the inner contact and the cable inside the body :

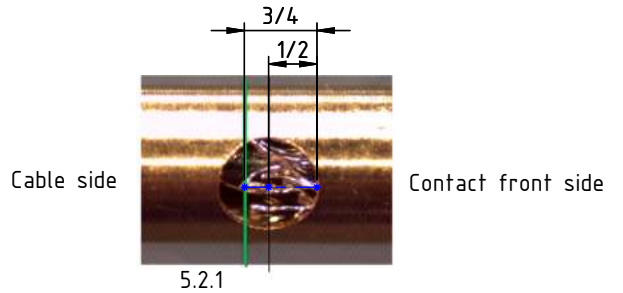
- 5.1.1 - Place the body inside the tool 17489 (the body is in stop position).
- 5.1.2 - Fold the shield onto the ferrule.
- 5.1.3 - Insert the inner contact and cable subassembly into the body.



5.1.1



5.1.2



5.2.1

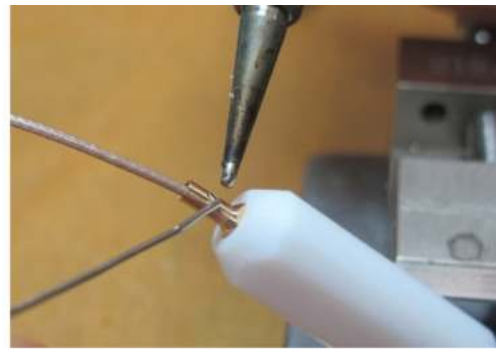
5.2 - Checking :

- 5.2.1 - The shield must cover a minimum of 3/4 of the inspection window

6/ 6.1 - Braze the shield with the body :

- 6.1.1 - Heat up the shield by the inspection window.
- 6.1.2 - Add the tin
- 6.1.3 - Repeat steps 6.1.1 and 6.1.2 for the second inspection window.

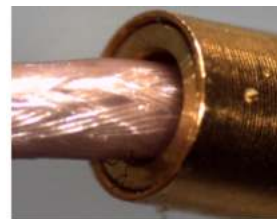
NICOMATIC recommends the use of a LTK soldering pencil with a soldering iron heat up at 360°C (680°F) and a tin soldering wire Ø0.7 (99C) (Length of the tin soldering wire per inspection windows 8 mm).



6.1

6.2 - Check the position of the ferrule :

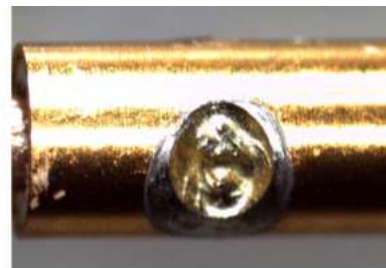
- 6.2.1 - The ferrule must not go outside the body



6.2

6.3 - Check the brazing :

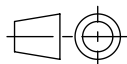
- 6.3.1 - The shield is cover by the tin.
- 6.3.2 - the brazing shape is in counter-relief or level with the body.



6.3



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Designation : Cable instruction for HF female contact series 30 to braze

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