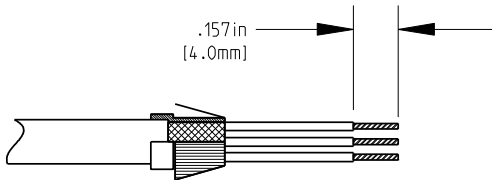
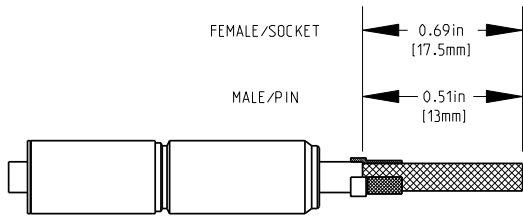


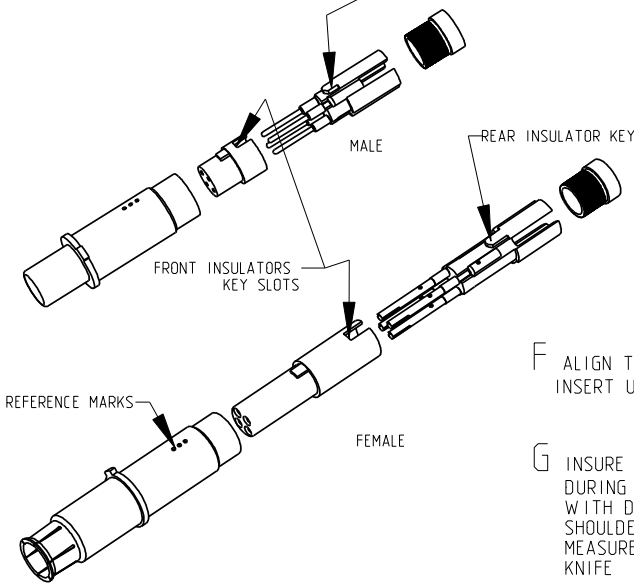
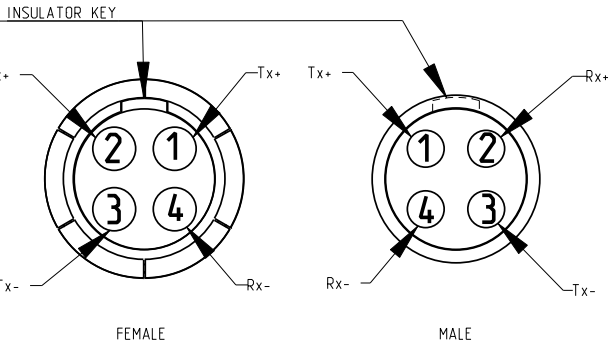
DWG. NO.
ETH1-38999-NOTICE

WIRING INSTRUCTION QUADRAX ETHERNET #8

P/N = ETH1-1115A/ETH1-1116A
ETH1-1235A/ETH1-1236A

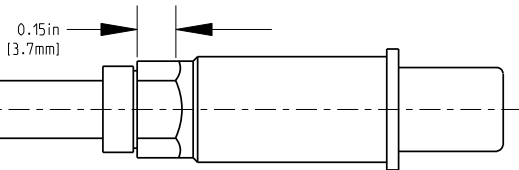


- A FIT THE SEALING BOOT ON THE CABLE AND STRIP OFF THE OUTER JACKET .512 IN. FOR PIN AND 0.689 IN. FOR SOCKET CONTACT EXPOSING THE BRAID.
- B INSTALL THE CRIMP FERRULE AS SHOWN OVER THE OUTER BRAID AND FOLD THE OUTER & INNER BRAID OVER THE CRIMP FERRULE
- C STRIP .157 IN. OF THE INSULATOR OFF THE INNER CONDUCTOR WIRES, AND CRIMP THE CONTACTS USING CRIMP TOOL M2252/2-01 AT CRIMP HEIGHT SETTING 5, AND POSITIONED WITH K709 OR M22520/2-37 LOCATOR
- D INSTALL THE WIRED CONTACTS IN THE REAR INSULATOR. (FRONT FACE VIEW FOR POSITIONING).
- E INSTALL THE FRONT INSULATOR OVER THE CONTACTS AND ONTO THE REAR INSULATOR ALIGNING THE TWO INSULATOR KEYS.



- F ALIGN THE INSULATOR KEYS WITH THE REFERENCE MARKS ON THE OUTER CONTACT BARREL INSERT UNTIL THE KNURLING PART OF THE FERRULE IS FULLY SEATED IN THE OUTER CONTACT

- G INSURE THAT ALL THE PIECES ARE FULLY SEATED IN THE OUTER CONTACT BEFORE AND DURING THE CRIMPING PROCESS. CRIMP THE OUTER CONTACT WITH CRIMP TOOL M22520/5-01 WITH DANIELS Y211, or M22520/5-45 DIE SET CAVITY B. LOCATE THE CRIMP WITH THE SHOULDER ON THE OUTER CONTACT THE CRIMPING LENGTH ON THE BODY SHOULD BE 0.150 IN. MEASURED AS SHOWN. AFTER TERMINATION TRIM OFF THE REMAINING BRAID WITH AN X-ACTO KNIFE



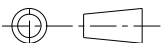
| | | | |
|-----|---------------------|--------------|--------------|
| C | REVISED PER ECN9935 | SDH 09-10-06 | SDH 09-14-06 |
| B | REVISED PER ECN9892 | FLR 08-07-06 | SDH 08-07-06 |
| A | RELEASE PER ECN9807 | FLR 03-27-06 | SDH 03-27-06 |
| REV | ECN NUMBER | BY DATE | CHKD DATE |

DRAWING TITLE

QUADRAX TERMINATION INSTRUCTIONS

LINEAR MEASURE: $\frac{\text{INCH}}{\text{mm}}$ INCH [mm]

THIRD ANGLE PROJECTION



TOLERANCES UNLESS OTHERWISE SPECIFIED

| | |
|----------------------|-----------------------|
| No. OF PLACES | INCH [mm] |
| ONE PLACE | $\pm .1 [\pm 3]$ |
| TWO PLACES | $\pm 0.01 [\pm .3]$ |
| THREE PLACES | $\pm 0.005 [\pm .13]$ |
| ANGLES $\pm 1^\circ$ | |



| | | | | |
|---|---------|--------------------|------------|----------|
| CAGE NO.: 09922 | SIZE: A | APPROVAL | DRAWN: TLP | 02-06-06 |
| SYMBOLS \odot \ominus INDICATE CLASSIFICATION PER SPECIFICATION D313 | | | CHKD : SDH | 02-06-06 |
| | | | DSGN : SDH | 02-06-06 |
| THE SYMBOL \square DENOTES INDICATORS FOR STATISTICAL PROCESS CONTROL REQUIREMENTS PER SPECIFICATION D735 | | | MFG : JRE | 02-06-06 |
| | | QC : DK | 02-06-06 | |
| INTERPRET THIS DRAWING IN ACCORDANCE WITH ASME Y14.5M - 1994. | | DRAWING SCALE: 2:1 | | |
| | | DRAWING NO. | | REV |
| | | ETH1-38999-NOTICE | | C |
| | | 1 OF 1 | | |

CONTACT THE DOCUMENT CENTER FOR THE LATEST REVISION.

PROL