

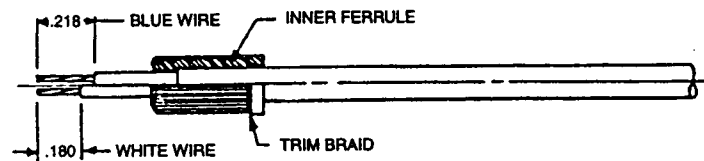
## ASSEMBLY INSTRUCTIONS FOR T3-46T08-LD PIN & T3-47T08-LD SOCKET TWINAX CONTACTS

FIG.1



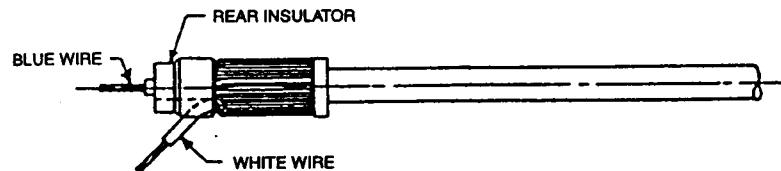
1. SLIDE HEAT SHRINK BOOT (SUPPLIED WITH CONTACT) OR REMOVABLE BOOT (SUPPLIED WITH CONNECTOR) ONTO CABLE AS SHOWN. DISCARD HEAT SHRINK BOOT WHEN USING REMOVABLE BOOT.
2. STRIP OUTER JACKET TO DIMENSION SHOWN (.500). MAKE CUT SQUARE AND SHARP, BEING CAREFUL NOT TO NICK BRAID.

FIG.2



1. SLIDE INNER FERRULE OVER BRAID UNTIL OUTER JACKET TOUCHES INNER SHOULDER OF FERRULE.
2. COMB OUT BRAID AND FOLD BRAID BACK OVER INNER FERRULE. TRIM EXCESS BRAID EVEN WITH SHOULDER.
3. STRIP INNER WIRES AS SHOWN (.218 BLUE WIRE & .180 WHITE WIRE). MAKE CUTS SQUARE AND SHARP, BEING CAREFUL NOT TO NICK CONDUCTORS.

FIG.3



1. BEND WHITE WIRE OUTWARD AND INSTALL BLUE WIRE THRU CENTER HOLE OF REAR INSULATOR.

TABLE I

|                   | CENTER CONTACT TOOLING |                    | INTERMEDIATE CONTACT TOOLING |                 | OUTER CRIMP SLEEVE TOOLING |                 |
|-------------------|------------------------|--------------------|------------------------------|-----------------|----------------------------|-----------------|
|                   | Basic Crimping Tool    | Contact Positioner | Basic Crimping Tool          | Die Part Number | Basic Crimping Tool        | Die Part Number |
| Military Part No. | M22520/2-01            | None               | M22520/5-01                  | None            | M22520/5-01                | None            |
| Daniels Part No.  |                        | K709               |                              | Y631            |                            | Y631            |



(Pyle-National) Form No. PN-430 3/94

**AMPHENOL CORPORATION**  
**Amphenol Aerospace**  
 607-563-5011  
 40-60 Delaware Avenue  
 Sidney, New York 13838-1395

FIG 4A



1. SLIDE CENTER PIN CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER PIN CONTACT TO BLUE WIRE USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG 5A



1. SLIDE INTERMEDIATE SOCKET CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER PIN CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

FIG 6A



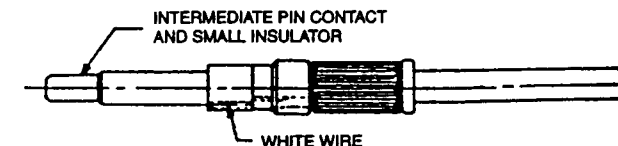
1. SLIDE OUTER PIN BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE SOCKET CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, CENTER PIN CONTACT MUST BE LOCATED WITHIN DIMENSIONS SHOWN.
- 3A. SLIDE HEAT SHRINK BOOT OVER CRIMPED PORTION OF CONTACT AND APPLY HEAT TO SHRINK BOOT ONTO CONTACT AND CABLE.
- 3B. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONTACT CAVITY UNTIL FIRMLY SEATED.

FIG 4B



1. SLIDE CENTER SOCKET CONTACT OVER CONDUCTOR OF BLUE WIRE. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. CONTACT MUST BUTT REAR INSULATOR AND REAR INSULATOR MUST BUTT INNER FERRULE.
2. CRIMP CENTER SOCKET CONTACT TO BLUE WIRE USING CRIMP TOOL AND CONTACT POSITIONER AS SHOWN IN TABLE I.

FIG 5B



1. SLIDE INTERMEDIATE PIN CONTACT AND SMALL INSULATOR SUB-ASSEMBLY OVER CENTER SOCKET CONTACT.
2. INSERT WHITE WIRE INTO HOLE ON REAR SURFACE OF INTERMEDIATE CONTACT. CONDUCTOR MUST BE VISIBLE THROUGH THE WIRE INSPECTION HOLE. INTERMEDIATE CONTACT MUST BUTT THE REAR INSULATOR.
3. CRIMP THE INTERMEDIATE CONTACT TO THE WHITE WIRE USING CRIMP TOOL AND CRIMP DIE AS SHOWN IN TABLE I.

FIG 6B



1. SLIDE OUTER SOCKET BODY AND LARGE INSULATOR SUB-ASSEMBLY OVER INTERMEDIATE PIN CONTACT UNTIL FULLY BOTTOMED.
2. WITH ASSEMBLY FULLY BOTTOMED, HEX CRIMP REAR PORTION OF OUTER BODY WITH CRIMPING TOOL AND CRIMP DIE AS SHOWN IN TABLE I. AFTER CRIMPING, INTERMEDIATE PIN CONTACT MUST BE LOCATED WITHIN DIMENSIONS SHOWN.
- 3A. SLIDE HEAT SHRINK BOOT OVER CRIMPED PORTION OF CONTACT AND APPLY HEAT TO SHRINK BOOT ONTO CONTACT AND CABLE.
- 3B. AFTER INSERTION OF TWINAX CONTACT INTO CONNECTOR, SLIDE THE REMOVABLE BOOT OVER THE CONTACT AND INTO THE CONTACT CAVITY UNTIL FIRMLY SEATED.

Компания «Life Electronics» занимается поставками электронных компонентов импортного и отечественного производства от производителей и со складов крупных дистрибьюторов Европы, Америки и Азии.

С конца 2013 года компания активно расширяет линейку поставок компонентов по направлению коаксиальный кабель, кварцевые генераторы и конденсаторы (керамические, пленочные, электролитические), за счёт заключения дистрибьюторских договоров

Мы предлагаем:

- Конкурентоспособные цены и скидки постоянным клиентам.
- Специальные условия для постоянных клиентов.
- Подбор аналогов.
- Поставку компонентов в любых объемах, удовлетворяющих вашим потребностям.
- Приемлемые сроки поставки, возможна ускоренная поставка.
- Доставку товара в любую точку России и стран СНГ.
- Комплексную поставку.
- Работу по проектам и поставку образцов.
- Формирование склада под заказчика.
- Сертификаты соответствия на поставляемую продукцию (по желанию клиента).
- Тестирование поставляемой продукции.
- Поставку компонентов, требующих военную и космическую приемку.
- Входной контроль качества.
- Наличие сертификата ISO.

В составе нашей компании организован Конструкторский отдел, призванный помогать разработчикам, и инженерам.

Конструкторский отдел помогает осуществить:

- Регистрацию проекта у производителя компонентов.
- Техническую поддержку проекта.
- Защиту от снятия компонента с производства.
- Оценку стоимости проекта по компонентам.
- Изготовление тестовой платы монтаж и пусконаладочные работы.



Тел: +7 (812) 336 43 04 (многоканальный)

Email: [org@lifeelectronics.ru](mailto:org@lifeelectronics.ru)

[www.lifeelectronics.ru](http://www.lifeelectronics.ru)