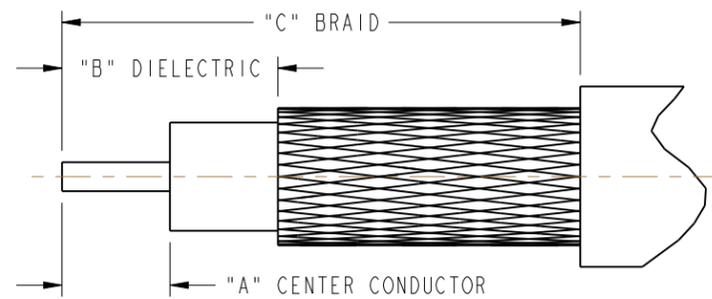


REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
B	A) MODIFY C71 STRIPPING DIMENSION, B) ADDED NOTE 7, C) C04 AND C62 WERE "***"	5/6/09	47539	BCG
H	A) REVISED NOTE 3 TO INCLUDE THE USE OF A MECHANICAL STOP.	10/10/13	49742	BCG

CABLE ASSEMBLY INSTRUCTIONS FOR 2FAH, 2FDH, 3FAH & 3FDH SERIES PLUGS & JACKS



RECOMMENDED CABLE STRIPPING DIMENSIONS

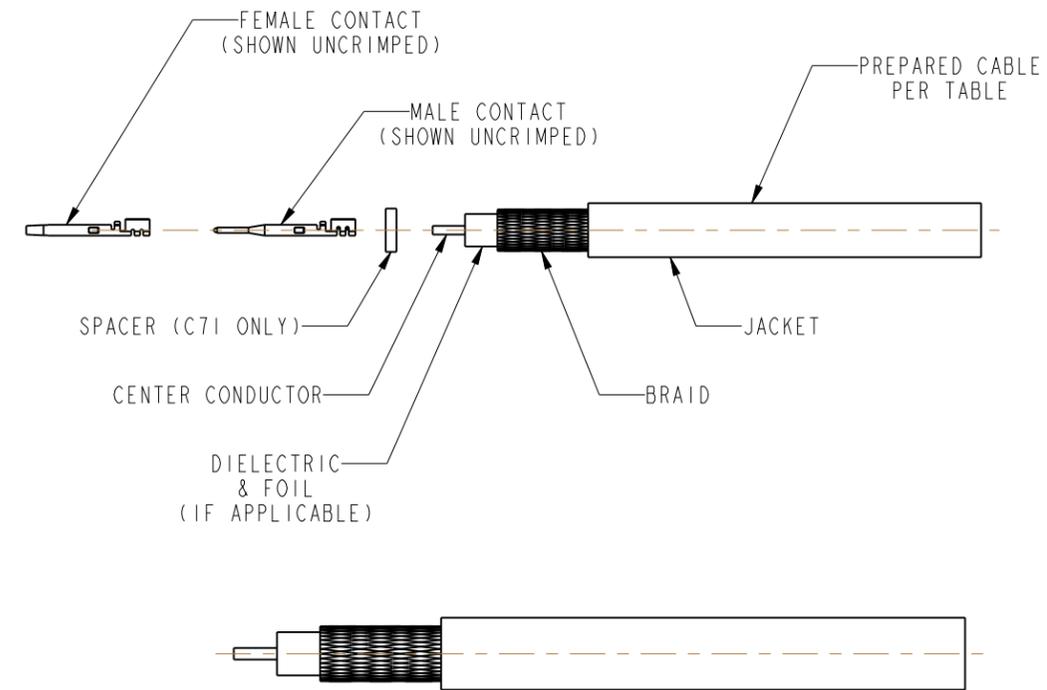
CABLE GROUP	STRIPPING LENGTH (mm)			FERRULE HEX CRIMP SIZE	NOTES (SEE BELOW)	CENTER CONTACT CRIMPING SPECIFICATION / DIE
	"A"	"B"	"C"			
C01	.098 (2.50)	.187 (4.75)	.394 (10.00)	.128 (3.25)	A	349-50747 & 349-50750
C04	.098 (2.50)	.187 (4.75)	.394 (10.00)	.213 (5.41)	A	349-50747 & 349-50748
C05	.098 (2.50)	.187 (4.75)	.394 (10.00)	.128 (3.25)	A	349-50747 & 349-50750
C06	.118 (3.00)	.201 (5.10)	.409 (10.40)	.130 (3.30)	A	349-50747 & 349-50750
C40	.106 (2.70)	.169 (4.30)	.413 (10.5)	.187 (4.75)	A	349-50747 & 349-50750
C65	.098 (2.50)	.226 (5.75)	.433 (11.00)	.255 (6.48)	B,C	349-50747 & 349-50750
C71	.146 (3.70)	.232 (5.90)	.448 (11.37)	.255 (6.48)	B,C	349-50747 & 349-50750
M59	.106 (2.70)	.169 (4.30)	.390 (9.90)	.178 (4.52)	A	349-50747 & 349-50750

- A) THE C01,C05,C06,C40,M59 CABLE GROUPS REQUIRES A SHORTENED HEX CRIMP DIE FOR THE FERRULE (.300" MAX. LONG). THE C04 CABLE GROUP REQUIRE A SPECIAL HEX DIE SET (SEE DWG. 227-Y1987P FOR DETAILS)
- B) THE C65 & C71 CABLE GROUPS REQUIRE A STANDARD HEX CRIMP DIE FOR THE FERRULE (.375" MIN. LONG) TO ASSURE THE ENTIRE FERRULE IS CRIMPED.
- C) AFTER CRIMPING, THE FERRULES DIMENSION OF C65 & C71 IS 6.55±0.13 mm IN THREE PLACES.

	NAME	DATE		NAME	DATE
PROJ. ENG.	B.C. GLEISSNER	26-Nov-06	APPD. BY	M. HOYACK	4/25/08
CHK. BY			DATE ISSUED		

AMPHENOL CORPORATION DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°	CODE IDENT.	349-50767	REV
	74868		H
SCALE: NONE	SHEET 1 OF 4		



1. PREPARE CABLE PER TABLE AS SHOWN.

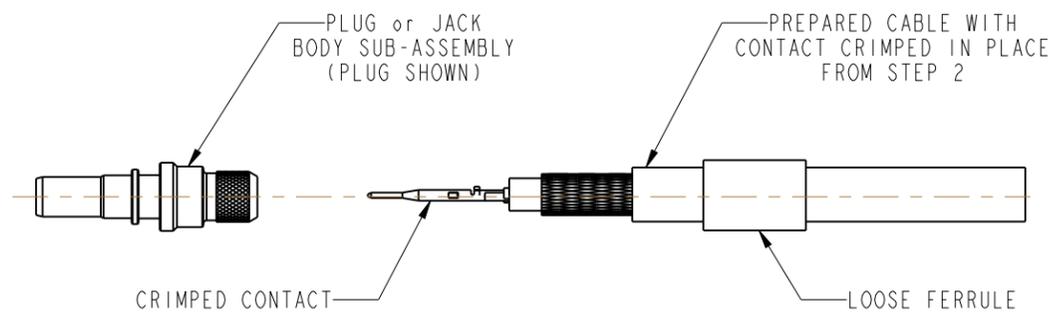


2. SLIDE SPACER (IF APPLICABLE) OVER THE CENTER CONDUCTOR AND CRIMP CONTACT (MALE SHOWN) USING THE APPROPRIATE CRIMPING SPECIFICATION AS SHOWN IN TABLE BASED ON CABLE GROUP.

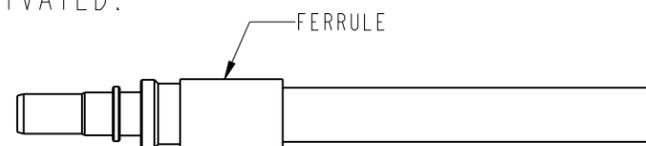
AMPHENOL CORPORATION DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°	CODE IDENT.	349-50767	REV
	74868		H
SCALE: NONE	BODYF1_FAK	SHEET 2 OF 4	

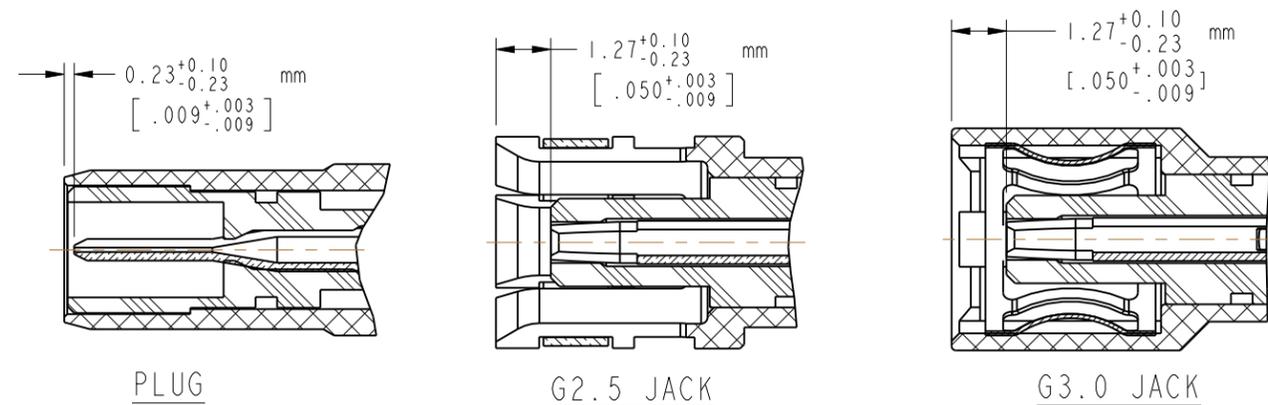
CABLE ASSEMBLY INSTRUCTIONS FOR 2FAH, 2FDH, 3FAH & 3FDH SERIES PLUGS & JACKS



3. SLIDE FERRULE OVER THE PREPARED CABLE AS SHOWN. COMB OR FLARE OUT THE BRAID AND INSERT THE CONTACT, DIELECTRIC, AND FOIL (IF APPLIES) INTO THE REAR OF THE BODY SUB-ASSEMBLY, KEEPING THE BRAID OUTSIDE THE BODY UNTIL THE CONTACT MEETS THE DIMENSIONS SHOWN BELOW. DUE TO CABLE CONSTRUCTION, PROCESS VARIATION, OR PULL BACK (AFTER CRIMPING), IT MAY BE NECESSARY TO USE A MECHANICAL STOP ON THE INTERFACE SIDE OF THE CONNECTOR TO ASSURE THE CONTACT'S POSITION IS WITHIN TOLERANCE. GIVE A LIGHT PULL (2 LBS. MAX.) ON THE CABLE TO ASSURE THE CONTACT IS CAPTIVATED.



4. SLIDE FERRULE OVER THE BRAID UNTIL IT RESTS ON THE REAR SURFACE OF THE BODY. CRIMP THE FERRULE IN PLACE USING THE APPLICABLE HEX DIE AS SHOWN IN THE TABLE ON SHEET 1 BASED ON THE CABLE GROUP. THE FERRULE SHOULD BE CRIMPED AS CLOSE TO THE BODY AS POSSIBLE. CONFIRM THE CONTACT POSITION PER THE DIMENSIONS SHOWN BELOW.

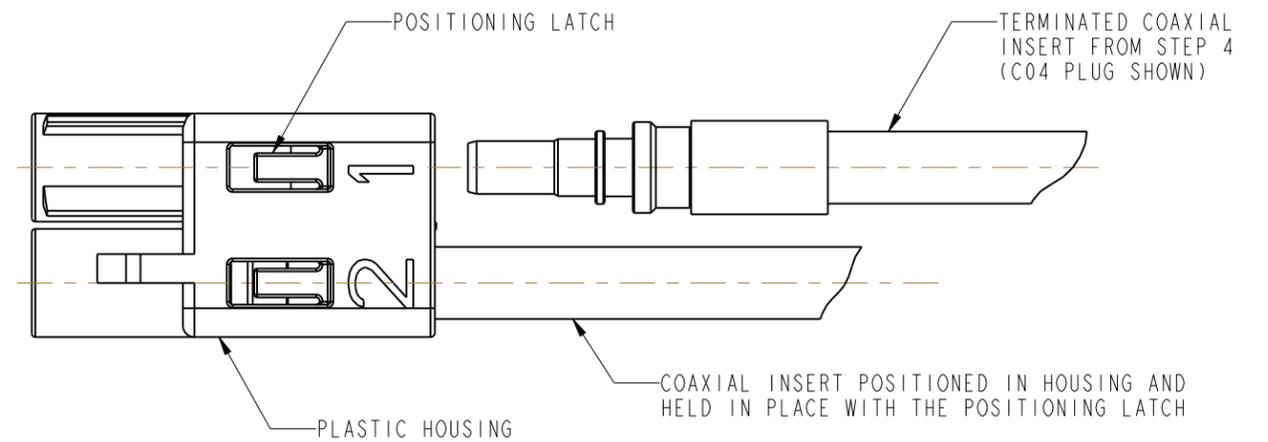


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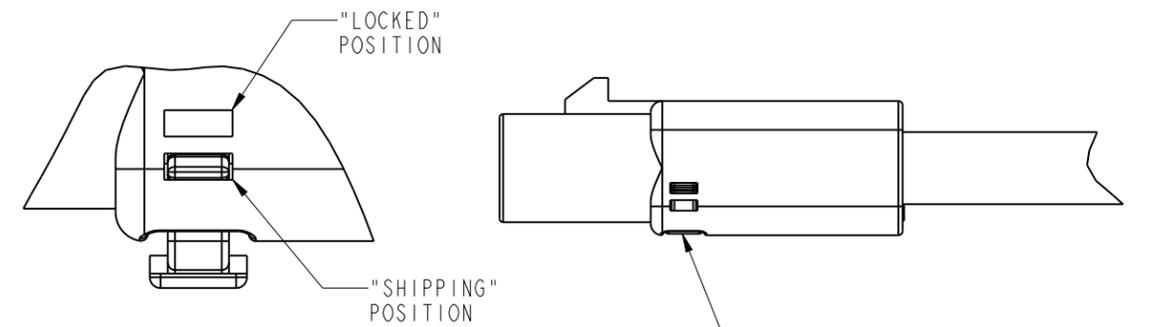
DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:			CODE IDENT.	349-50767	REV
FRACTIONS	DECIMALS	ANGLES	74868		H
± 1/64	± .005	± 1°	SCALE: NONE	SHEET 3 OF 4	

CABLE ASSEMBLY INSTRUCTIONS FOR 2FAH, 2FDH, 3FAH & 3FDH SERIES PLUGS & JACKS



5. INSERT BOTH TERMINATED COAXIAL INSERTS (SEE NOTE 7) INTO THEIR RESPECTIVE PORT OPENINGS IN THE REAR OF THE PLASTIC HOUSING. THE BODY OF THE COAXIAL INSERT WILL STOP AGAINST A SURFACE INSIDE POSITIONING LATCH TEMPORARILY RETAIN THE COAXIAL INSERTS IN THE THE HOUSING. THE HOUSING UNTIL THE TPA CLIP (TERMINAL POSITION ASSURANCE) IS DEPRESSED INTO THE "LOCKED" POSITION.



DETAIL SHOWING THE TPA IN THE "SHIPPING" POSITION (PLUG CONNECTOR SHOWN) SCALE 5.000

TPA DEPRESS TO THE "LOCKED" POSITION TO RETAIN BOTH COAXIAL INSERTS

6. WITH BOTH THE TERMINATED COAXIAL INSERTS (SEE NOTE 7 FOR 2FDH & 3FDH HYBRID SERIES) INSTALLED INTO THE HOUSING, PLACE THE TOP OF THE CONNECTOR (OPPOSITE SIDE TO THE TPA) ON A RIGID SURFACE AND DEPRESS THE TPA TO THE "LOCKED" POSITION AS SHOWN ABOVE. ONCE "LOCKED", THE TPA WILL RETAIN BOTH COAXIAL INSERTS WITH MINIMUM RETENTION OF 110 NEWTONS.

7. SEE 349-50807 FOR DETAILED INSTRUCTIONS FOR TERMINATING AND INSTALLING THE DC CONTACTS & HOLDER OF THE 2FDH & 3FDH (HYBRID) SERIES.

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:			CODE IDENT.	349-50767	REV
FRACTIONS	DECIMALS	ANGLES	74868		H
± 1/64	± .005	± 1°	SCALE: NONE	SHEET 4 OF 4	