

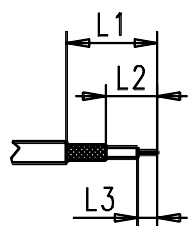
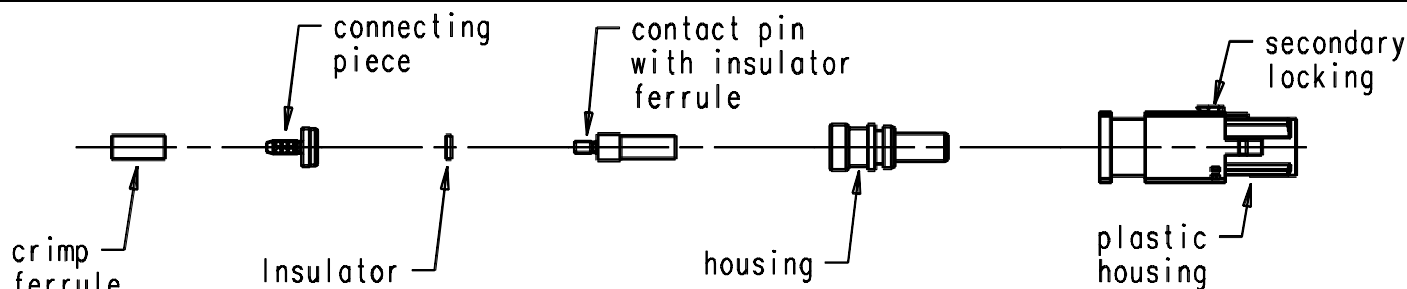
M-156

# Assembly Instruction

**IMS** CONNECTOR SYSTEMS

Date: 14.12.04

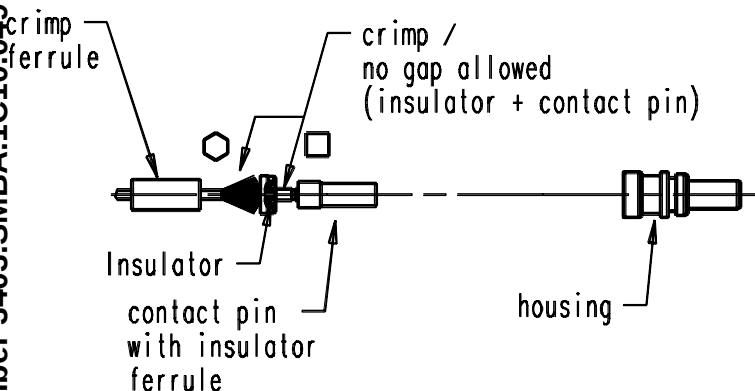
Rev.: b



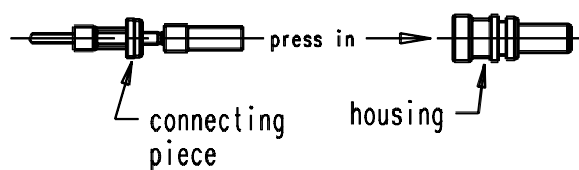
| Y= Variable | Cable type         | L1   | L2  | L3  |
|-------------|--------------------|------|-----|-----|
| 1           | Nexans ET 124899   | 10,3 | 4,6 | 2,5 |
| 4           | Hirose U.FL-LP-066 | 10,3 | 4,6 | 2,5 |
|             |                    |      |     |     |

Cable stripping as shown in the picture. Dimensions according to the table.

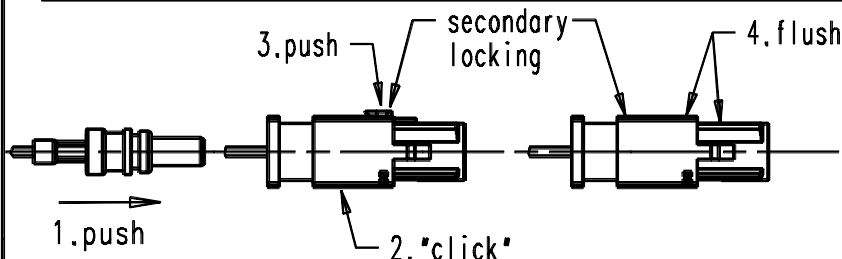
Please be careful when handling the cable and do not damage the braid, dielectric or center conductor.



Put the braid over the crimpneck and fit the center conductor of the cable into the contact pin. No gap allowed between insulator and contact pin. Crimp the contact pin by using the square size or crimp die listed in the table below. Push the crimp ferrule over the braid. Crimp the ferrule with the hex size or tool listed in the table below.



Carefully press the pre-assembled connecting piece into the housing.



Push the preassembled connector into the plastic housing until you feel and hear a "click". Push the secondary-locking into the plastic housing until it is flush with it.

| Y= Variable | Cable type         | outer contact  hex-Crimp |        | center contact  square-Crimp |        | Crimp die IMS-number |
|-------------|--------------------|-------------------------------------------------------------------------------------------------------------|--------|------------------------------------------------------------------------------------------------------------------|--------|----------------------|
|             |                    | size                                                                                                        | length | size                                                                                                             | length |                      |
| 1           | Nexans ET 124899   | 2,67                                                                                                        | 4      | 1,23                                                                                                             | 1,5    | AGK-3573-10          |
| 4           | Hirose U.FL-LP-066 | 2,67                                                                                                        | 4      | 1,23                                                                                                             | 1,5    | AGK-3573-10          |
|             |                    |                                                                                                             |        |                                                                                                                  |        |                      |