

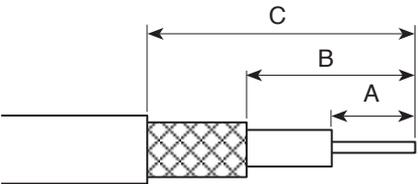


Termination of Type 43 Connectors

Table 1. Tooling

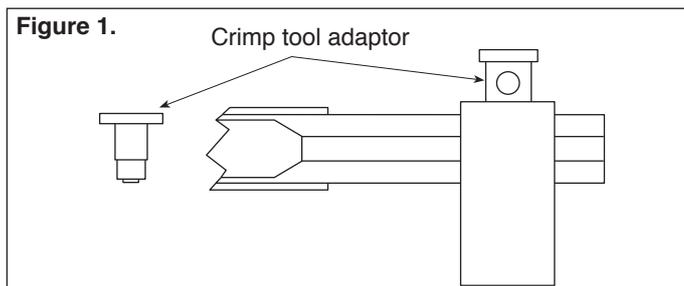
Description	BS ref.	BT ref	RS stock no.
Nippers		3A	185-9471
Centre contract crimp tool		19A	185-6157
Extraction tool		65A	185-6450
HDC 3 in 1 tool			185-6466
Outer ferrile crimp tool	5310	19A	185-7734
2001 and 3002 die set	VC		185-7740
2002 die set	VQ		185-7756
2003 die set	VR		185-7762
RG179B/U die set	B		185-7778
Coax stripper		8A	185-6472

Table 2. Cable stripping lengths BT43 and HDC



	C	B	A
Straight plug and socket	21	13	4.5
Right angle plug	15	7	3

1. Coaxial cables should be stripped back according to the dimensions in table 2. For 2001, 2002, 2003 and 3002 cables, use stripper **RS** stock no. 185-6472, following the instructions supplied with the tool.
2. The centre conductor should now be trimmed to the desired length using Nippers **RS** stock no. 185-9471.
3. Insert the grey plastic straight plug/socket crimp tool adaptor into the crimp tool **RS** stock no. 185-6157 as shown in figure 1. (This is supplied with the connectors).

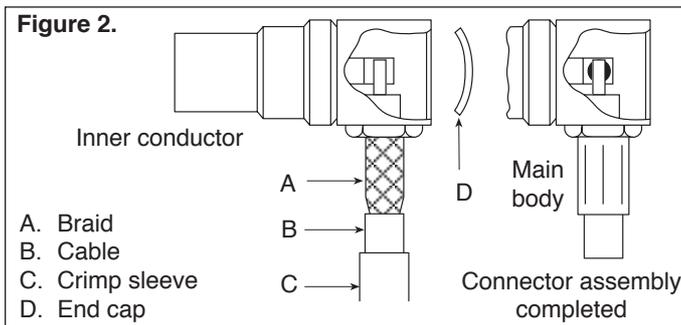


4. Insert the cable centre conductor into the contact until the contact butts to the cable dielectric. Ensure the cable centre conductor is visible through the inspection hole of the contact.
5. Insert the cable complete with contact into the crimp tool adaptor, ensuring the cable is fully home, push the assembly against the tool, you should feel spring tension as you push the locator against its stop. Operate the tool.
6. Remove the assembly from the crimp tool. Slide the outer crimp sleeve over the prepared cable end.
Note: Crimp sleeve may be pushed over cable prior to stripping or crimping centre contact.

7. Insert the crimped contact into the rear of the connector. Push the cable until the contact is 'felt' to click into place. Ensure the braid flares over the knurled back end.
8. Slide the outer crimp sleeve over the braid until it butts against the connector body. Crimp the sleeve using crimp tool **RS** stock no. 185-7734 with the appropriate die set, butting the crimp tool against the connector body.
Note: It is the industry practice for the crimp sleeve to be fitted with the manufactures date code furthest away from the back end of the connector.

Right angle plug

9. The coaxial cable should be stripped back according to the dimensions in table 2. Slide the crimp sleeve over the stripped cable onto the cable insulation.
10. Insert the cable dielectric into the bore of the crimp body back end whilst guiding the braid over it. Push the cable until the inner conductor is positioned within the contact slot, orientation of the contact slot may be altered with a small screwdriver. Slide the crimp sleeve over the braid until it butts against the connector body. Crimp the sleeve using crimp tool **RS** stock no. 185-7734 with the appropriate die set (see figure 2).
11. The centre contact may now be soldered in position and the end cap pressed into position.



Chassis sockets

12. Chassis mounted sockets are a push fit mounting. The plastic collet fixes the socket in place with a degree of free float.
13. Sockets can be released from the chassis using the appropriate extraction tool. For standard Type 43 using **RS** stock no. 185-6450 for HDC 43 use **RS** stock no. 185-6466. The sockets are a front release, with the extraction tool compressing the plastic collet, enabling the connector body to be pulled clear.
14. Reloading HDC chassis sockets into a DDF can be assisted using **RS** stock no 185-6466 to hold sockets when inserting them from the rear.
15. **'U' links**
HDC 'U' links may prove to be difficult to remove. The 3 in 1 tool **RS** stock no. 185-6466 contains an attachment enabling the tool to hook under a bridge on the top of the 10A/10B 'U' links.

For standard series 13A/13B 'U' links the die cast body is designed with easy grip knurl profile on the sides of the 'U' link. This enables easy removal of the 'U' link from the DDF by hand, without the use of tools.