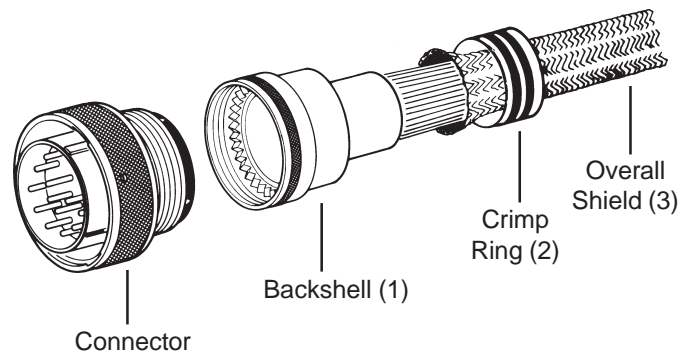


Crimp Ring Backshells Assembly Instructions 44-1



The following suggested procedure serves as a guide for proper assembly and installation of Glenair EMI/RFI Crimp Ring Backshells. It is recommended that trial samples of appropriate cables or harnesses be used to determine proper trim dimensions of the outer shield, individual conductors, and cable jacket where applicable.

- Temporarily assemble backshell (1) to connector.
- Place crimp ring (2) on cable or harness, and keep it at a convenient distance from the end of the cable so it will not interfere with subsequent assembly steps.
- Insert cable or harness into backshell (1) and bottom against connector. Hold cable in position and mark outer shield (or jacket) at rear end of backshell.
- Remove backshell from connector and place on cable with crimp ring (2).
- Trim outer shield (and jacket if necessary) at mark made in step (c) above.
- Prepare and terminate individual conductors in accordance with established practices.

- Assemble backshell (1) to connector and tighten securely.
- Flare shield over rear crimping area of backshell (1) and slide crimp ring (2) into place over shield.
- Hold crimp ring and shield in position as in step (h) and crimp with proper tool, making sure accepted crimping practices are observed. Trim any exposed shield strands at forward end of crimp ring.
- Depending on the particular application, subsequent molding, potting or shrink boot installation may be accomplished at this point, using the knurled surface or molding grooves provided on the backshell body.

NOTE: As with any electrical connector assembly procedure, be sure to use the proper tools. Be sure the proper crimp tool and die head is used. For convenient reliable assembly of the backshell to the connector it is suggested that Glenair's connector holding tools, strap wrenches and connector pliers be used.