AI85187-P-1

For 963-069-26 cable

Revision History

Rev	Description	Date	Initiated By	Approved
A	RELEASED	08/10/22	AHN	WLL
B	REVISED PER DCN102276	9/23/24	NAD	BNS
C	REVISED PER DCN104060	1/21/25	AH4	BNS

Tools needed:

- **Glenair tool 809-464 (Daniels Manufacturing Corporation tool UDT3) OR equiv.**
- **Glenair tool 859-205 (Crimp Dies)**
- **Glenair tool 809-465 (Daniels Manufacturing Corporation tool UDT5) OR equiv.**
- **Glenair tool 859-206-01 and 859-206-2 (Strain Relief crimp tools)**
- **Glenair tool 859-206-P (Shield insulator aligner)**

Kit contents & description:

Grommet follower Molded insulator Shield

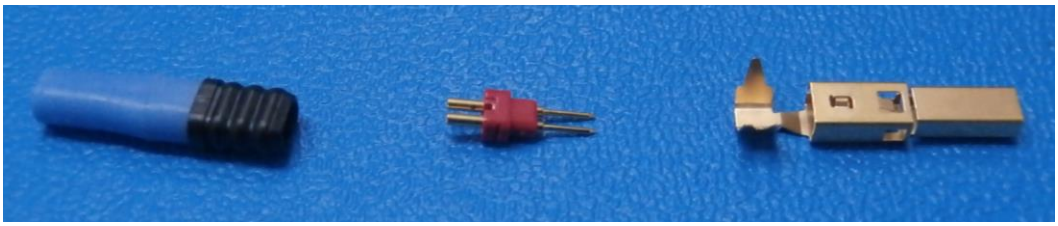

Figure 1: 853-045-01F kit components

This Assembly Instruction (AI) applies to all 853-045 base part numbers.

Procedure:

Step 1: Cable preparation

Slide grommet follower onto cable. Ensure black plastic end is closest to tip of cable. Use Isopropyl alcohol if grommet follower does not slide onto cable easily. Cable ends must be cut cleanly and perpendicular to cable axis. Cable conductors are expected to "piston" during handling. To ensure conductors stay the same length, do not trim exposed conductors.

Figure 2: Clean cut cable

Step 2: Contact preparation

It is recommended to use a wire stripping laser to strip cable. Strip cable jacket 0.130". Trim braided shield and foil flush to cable jacket.

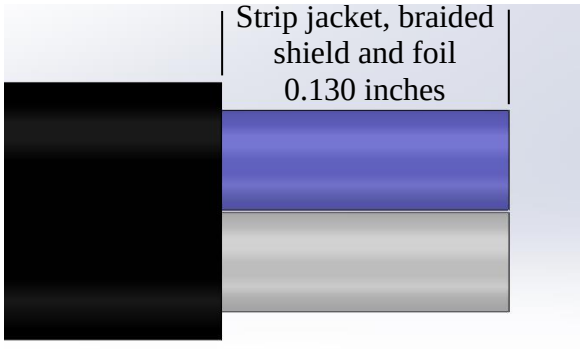

Figure 3: Stripped jacket, braided shield and foil

Strip inner conductors 0.090" and cable jacket 0.400". Remove cable jacket and insulation. Do not disturb inner conductors' twisted strands. Make sure braided shield does not ground to inner conductors. Trim braided shield as necessary.

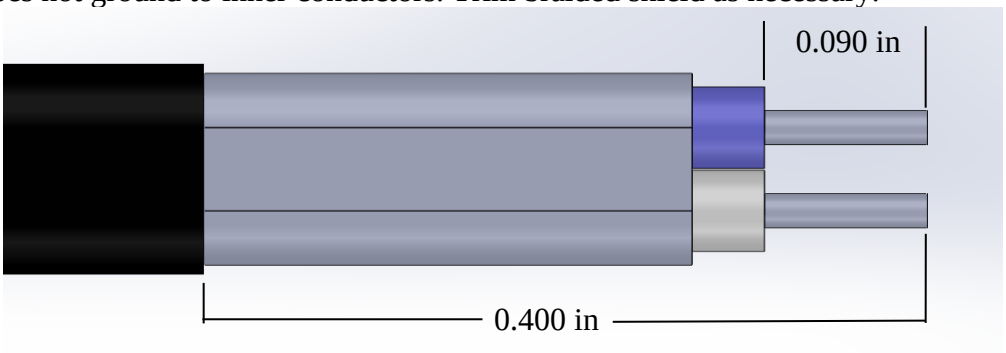

Figure 4: Ensure braided shield does not short to inner conductors

Step 3: Crimp contact

Molded insulator is symmetrical. Slide molded insulator onto inner conductors and crimp with crimp tool 809-464 and crimp die 859-205.

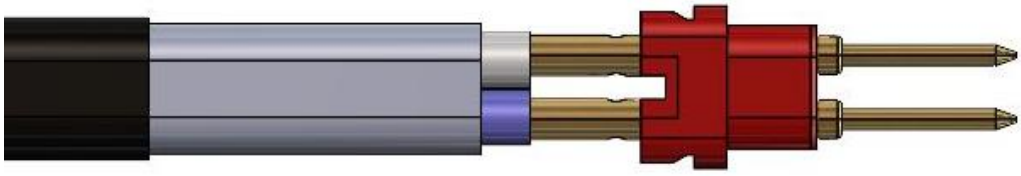

Figure 5: Positioning of contact onto cable

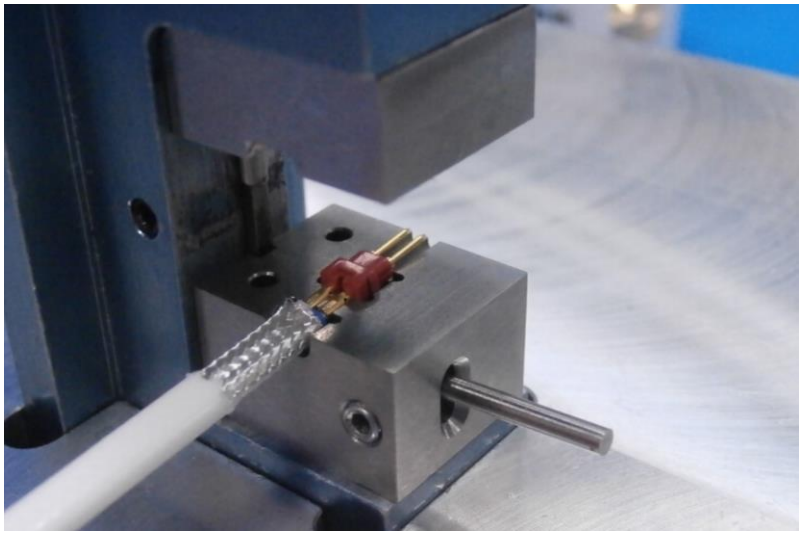

Figure 6: Crimping contact onto inner conductors using 859-205 die

Step 4: Insert insulator into shield

Verify desired pinout. Push terminated insulator into rear of shield. Once fully inserted, insulator cannot be removed. Verify clip is fully engaged, see ***Figure 8***.

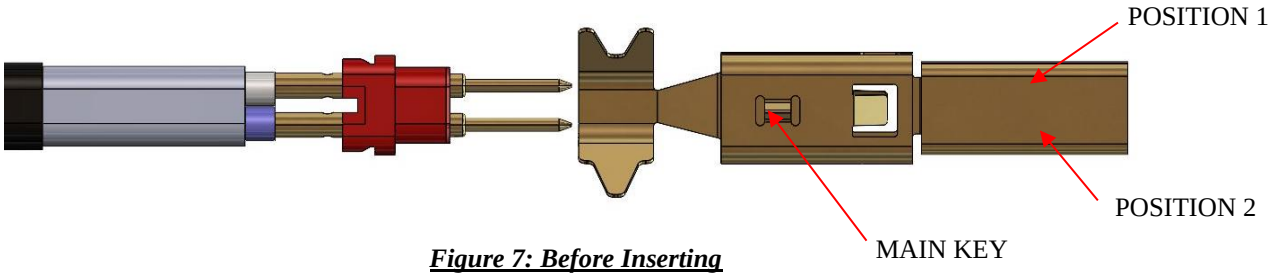

Figure 7: Before Inserting

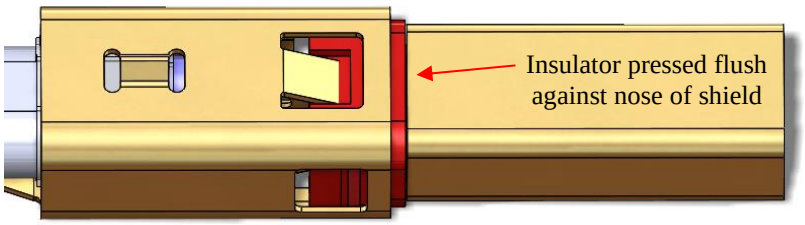

Figure 8: Fully Inserted, Insulator pressed against nose of shield

Step 5: Strain relief prep

Slide shield assembly into 859-206-P. Make sure contact assembly is fully seated inside 859-206-3.

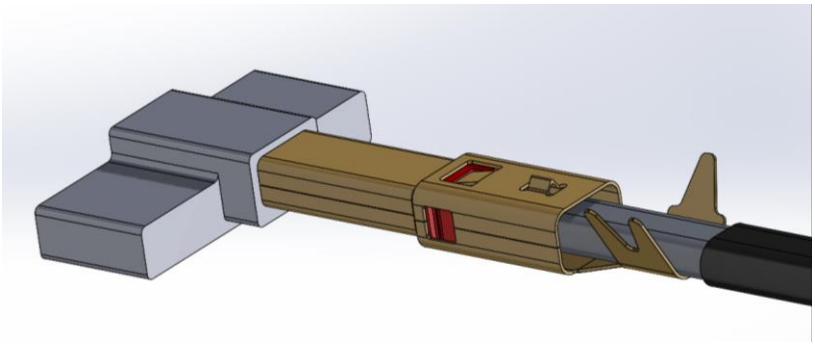

Figure 9: Inserting assembly into 859-206-PIN

Pre crimp shield strain relief using 859-206 Crimp A. Position assembly per figure before crimping.

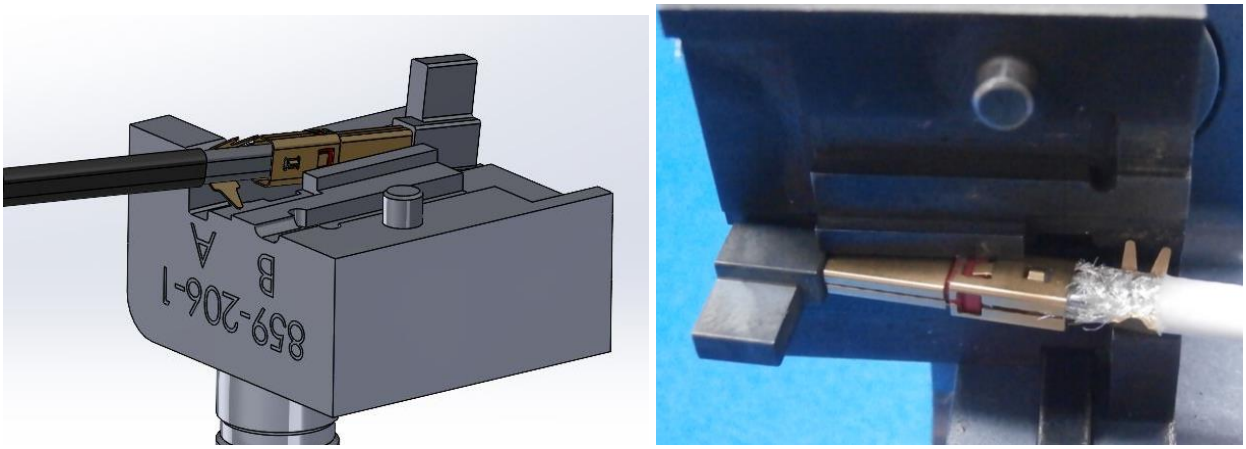

Figure 10: Pre crimp shield strain relief with 859-206

Step 6: Strain relief crimp

Move 859-206-P and cable assembly into 859-206 Crimp B per figure.

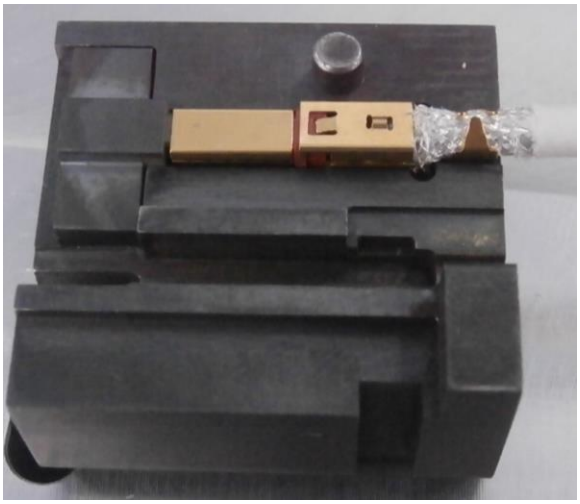

Figure 11: 859-206-P and shield inside of 859-206

Crimp strain relief onto cable shield.

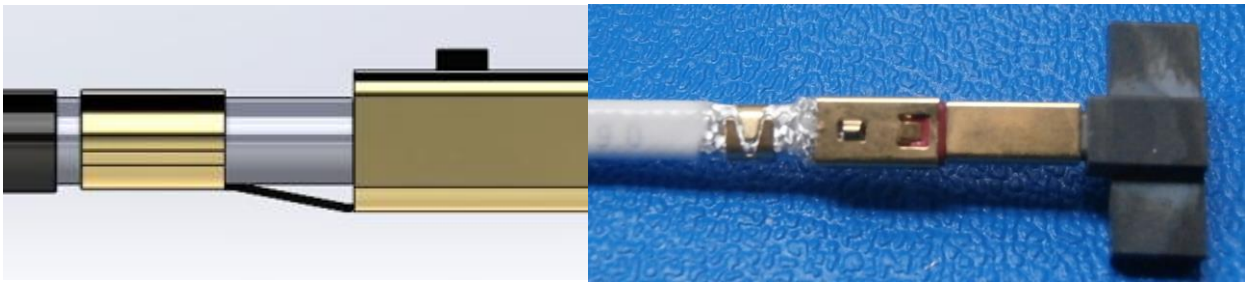

Figure 12: Crimped strain relief

Slide grommet to behind shield crimp buckle.

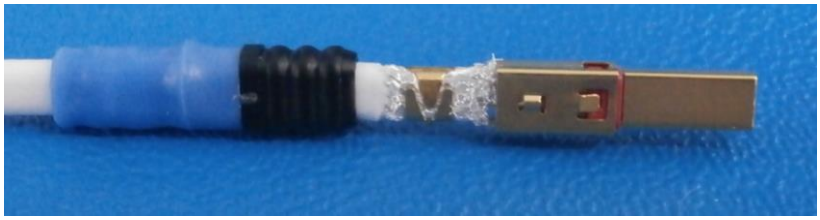

Figure 13: Crimped strain relief