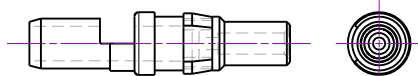


Notes

Rev.	Description	Date	Made By	Approval
A	Initial Release			

110963, CXP-1 Parts List :



A Body, Male



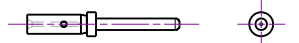
B Contact Insulator, PEEK



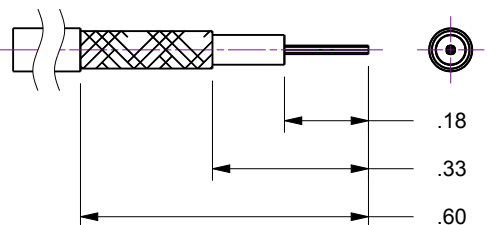
C Spacer Sleeve, PEEK



D Crimp Sleeve, Metal



E Contact, Male



F Cable Trim, 100720

## Tools List

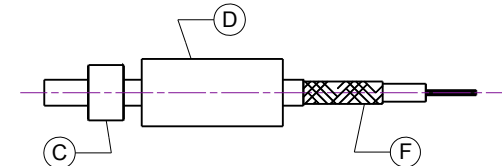
All listed wiring tools and supplies are available from our website at...

[www.accuglassproducts.com](http://www.accuglassproducts.com)

100190 Crimp Tool-1, Contact  
100908 Crimp Tool-2, Body  
100194 Wire Stripper-1  
100195 Wire Stripper-2

## Step-1

Slide metal sleeve (D), and PEEK spacer (C) onto pre-cut (desired) length of cable (F). These are moved into final position in Step-5. Note that PEEK contact insulator (B) is included, but preinstalled into Body (A) at the factory by AGP.



## Step-2

Trim / strip coaxial cable (F) to specifications indicated in diagram at left using wire stripper(s) No.1 (100194), and No.2 (100195).

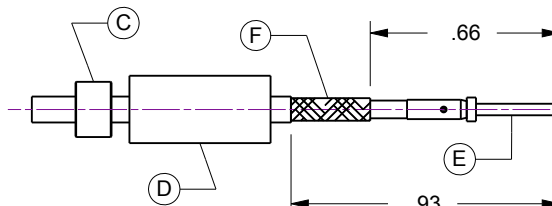
**2a) 0.60 Dimension** — Set wire Stripper-1 at #16 and mark/dent cable's Kapton jacket, then trim/strip with the same tool set to #14.

**2b) 0.33 Dimension** — Set wire Stripper-2 at #20 and mark/dent cable's metal braiding, then trim/strip with the same tool set to #18.

**2c) 0.18 Dimension** — Set wire Stripper-2 at #24 and trim/strip Kapton wire insulation.

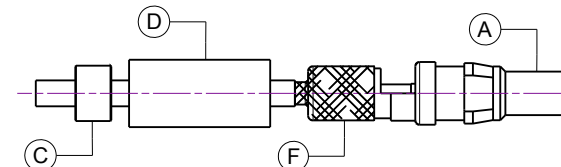
## Step-3

Slide male contact (E) onto stripped wire (F), then crimp contact (E) using Crimp-Tool-1 with dial set to position #5. **Note that back of contact 'MUST' rest lightly on Kapton insulation to help stabilize contact and prevent side-to-side movement.** After crimping, contact position will measure close to these specifications...



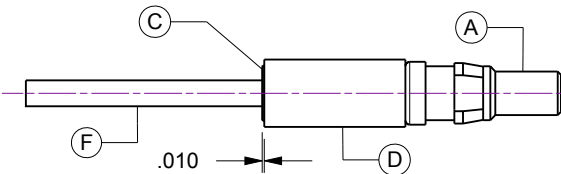
## Step-4

Unravel and evenly flare coaxial braided shielding (F), then slide back-end of body (A) under flared shielding, and over crimped male contact (E) until contact bottoms out inside of PEEK contact Insulator (B).



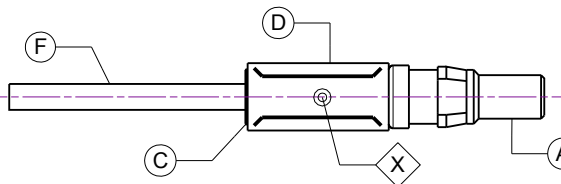
## Step-5

Slide metal sleeve (D) over flared braiding until stopped by shoulder on body (A)... then slide PEEK spacer (C) over flared braid, into, and almost flush with back-end of metal crimp sleeve (D)



## Step-6

Crimp Metal Sleeve (D) at location (X) using body crimp tool-2 100908



## Step-7

Test finished cable/contact assembly for end-to-end electrical continuity on both conductor and shielding paths.

## Step-8

Clean finished coaxial cable assembly by immersion in an ultrasonic bath of Isopropyl Alcohol for a minimum of 5 minutes.

## UNCONTROLLED WEB DRAWING

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Material  
See Individual Components

Tolerances,  
unless otherwise specified

.X ± .030	Angles ± 0.5° Finish 63Ra
.XX ± .010	
.XXX ± .005	

Title

Wiring Instructions for CXP-1

Drawn by	Ligeti	No.	Rev.
Date	6/5/2019	<b>A110963</b>	<b>A</b>
Approved		Sheet	



**Accu-Glass Products Inc.**  
25047 Anza Drive  
Valencia, CA 91355  
T 818-365-4215  
F 818-365-7074  
[www.accuglassproducts.com](http://www.accuglassproducts.com)