

STEP 1. SLIDE CRIMP SLEEVE OVER JACKET. STRIP CABLE TO DIMENSIONS SHOWN IN FIGURE 1. BE CAREFUL NOT TO NICK INNER CONDUCTOR OR SHIELD.

NOTE: FOR ASSEMBLY TO CABLES WITH "MINI-NOISE" COATING. MINI-NOISE COATING MUST BE REMOVED FROM SURFACE OF CABLE DIELECTRIC AS FOLLOWS:

1. PAINTED COATINGS: WIPE OFF DIELECTRIC SURFACE WITH A DRY CLOTH. WIPE AGAIN USING PAINT THINNER OR TRICHLOROETHANE. DO NOT IMMERSE CABLE IN SOLVENT.
2. TAPE OR FUZED COATINGS: REMOVE WITH SANDPAPER, FILE OR SCRAPING ACTION OF RAZOR BLADE. DO NOT DAMAGE DIELECTRIC.

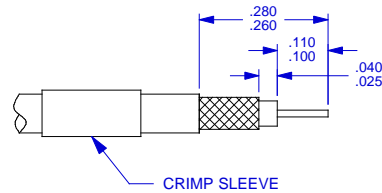


FIGURE 1

STEP 2. SLIDE BACK END OF CONTACT SUB-ASSEMBLY BETWEEN THE SHIELD AND DIELECTRIC. INNER CONDUCTOR MUST BE VISIBLE THROUGH INSPECTION HOLE. CRIMP CONTACT TO INNER CONDUCTOR WITH TOOL NUMBER 010-0150-000 OR DAVO TOOL NUMBER 826D. SLIDE CRIMP SLEEVE OVER SHIELD AND AGAINST CONTACT SUB-ASSEMBLY.

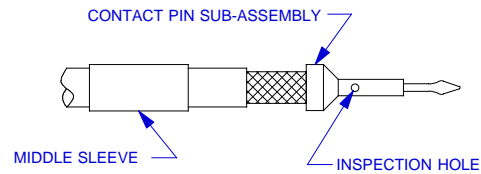


FIGURE 2

STEP 3. SLIDE ASSEMBLED PARTS INTO HOUSING SUB-ASSEMBLY. CRIMP REAR OF HOUSING AT LOCATION SHOWN IN FIGURE 3. USING TOOL NUMBER 010-0132-000 OR THOMAS & BETTS TOOL NUMBER WT-419.

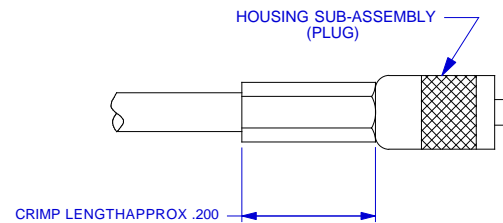
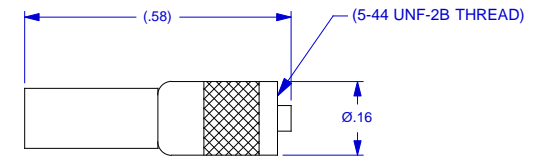


FIGURE 3



		CHATSWORTH, CA.	
DATE 11/18/02	PART NO.	127-6119	
DRAWN R.A.	CHECKED N.C.	MATL	
APPROVED	NEXT ASSEMBLY	USED ON	VARIOUS CABLES
TITLE OUTLINE DRAWING, 5-44 CONNECTOR, MODEL 6119			DWG NO. 127-6119
			SHEET 1 OF 1