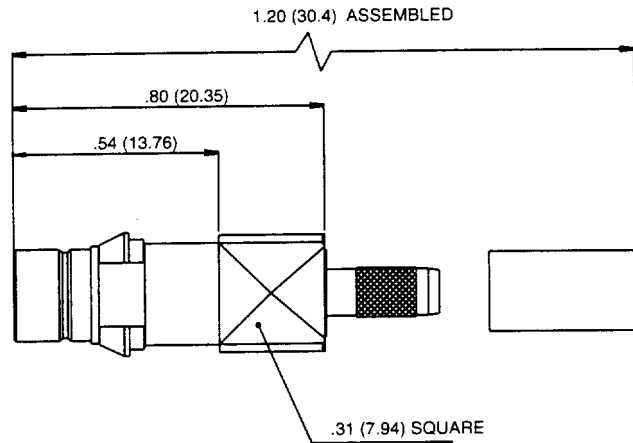


# HDC43

584 - 599 to 617

## Straight DDF Plug



Cable Type	Cable Attachment		Description	Part Number
	Inner	Outer		
BT2003	Crimp	Crimp	Plug HDC43/3GTIS	B67 H74 T062 XMP
RG179	Crimp	Crimp	Plug HDC43/4GTIS	B67 H74 T022 XMP
BT3002	Crimp	Crimp	Plug HDC43/5GTIS	B67 H74 T437 XMP

## U Links

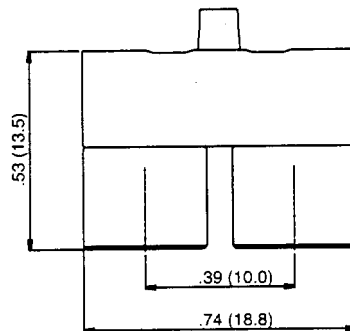


Figure 1

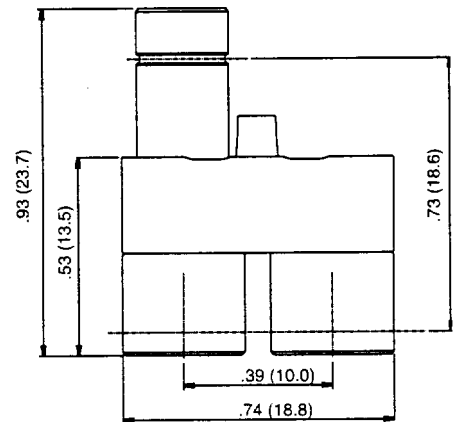


Figure 2

Figure	Description	Part Number
1	Link HDC43/10A	B67 Z03 T999 XMP
2	Link HDC/10B -30dB	B67 Z04 T999 XMP

ACCESSORIES:	Description	Part Number
	Mounting Block	127819-98
	Block Label	127818-98
	Label Cover (Clear)	127817-98
	Label Fixing Spigot	127763-98
	Block Fixing Screws	127764-98
	T Bar Tool BT3002	127846-50

Dimensions are in decimal inches, metric equivalents (to the nearest 0.1 mm) are given in parenthesis for general information only.

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# TYPE 43 ASSEMBLY INSTRUCTIONS SOCKET ES & FS; PLUG FS & GTIS

- 1) Slide crimp sleeve over cable.  
Strip cable to dimensions shown in figure 1.

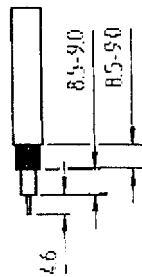


Figure 1

- 2) Push centre conductor until it bulks on dielectric figure 2. Check that the centre conductor is visible through the inspection hole, figure 3.

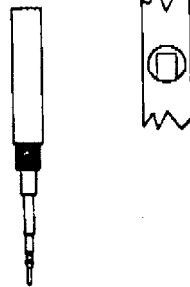


Figure 2



Figure 3

- 4) Check that the dielectric (ST 427664-981) is inserted into the crimp front (PLIERS CRIMPING 19A). Push the assembly fully in against the contact plunger as figure 4.

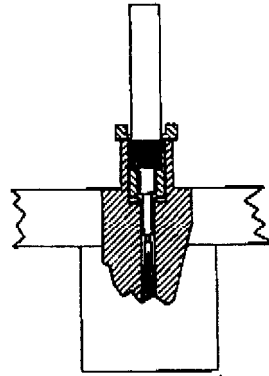


Figure 4

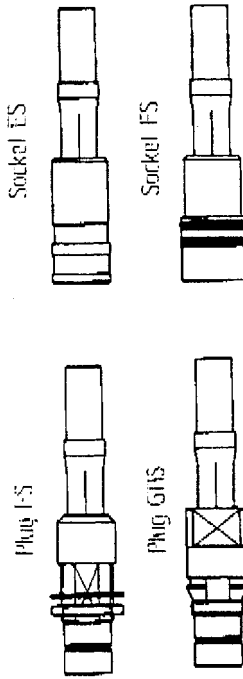
- 5) Crimp the contact and then withdraw the assembly from the tool. Check that the centre conductor is visible through the inspection hole, figure 5.

- 6) Insert the contact/cable into the connector, make sure the contact is straight. Gently twist the cable to spread the braid sufficiently to go over the knurled ferrule. Continue to push until the assembly is full to crimp into position. For the sockets only the contact will be flush with the face of the insulation.



Figure 5

- 7) Check the braid is covering the knurl. Slide the crimp sleeve forward until it bulks against the body of the connector. Crimp with PLIERS CRIMPING 6A using the die as shown in table. The dies should be used for crimping the body.



Socket ES

Plug FS

Socket FS

Plug GTIS

Figure 6

Plug	BT ref	Socket	Socket	Cable type	Cable group	Die set	BS ref
43/1GTIS	43/1FS	43/1ES	43/1ES	2001	280	XED	C
43/2GTIS	43/2FS	43/2ES	43/2ES	2002	117	XW	O
43/3GTIS	43/3FS	43/3ES	43/3ES	2003	062	X1A	R
43/4GTIS	43/4FS	43/4ES	43/4ES	RG1798/U	022	XCF	B
43/5GTIS	43/5FS	43/5ES	43/5ES	3002 & TZL75024 RG598/U	437 A25	XED XH	C E

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