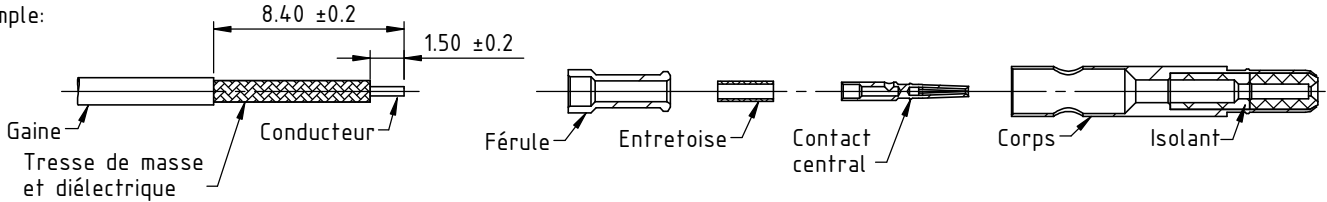
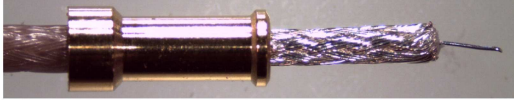


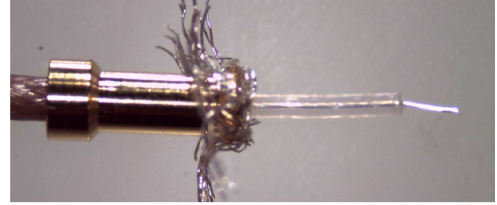
Exemple:



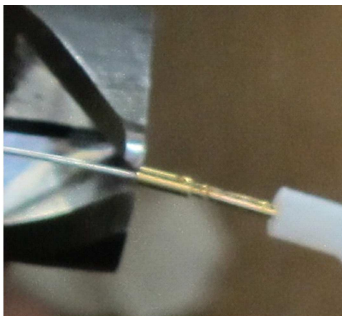
1/ 1.1 - Enfiler la férule en butée sur le câble



1.2 - Rebrousser la tresse de masse sur la férule.

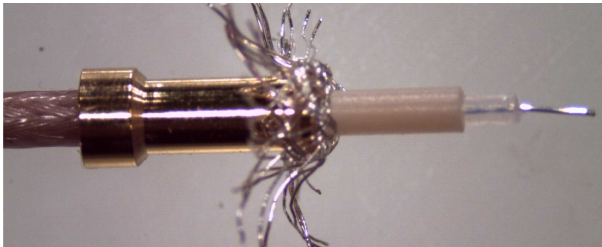


2/ 2.1 - Monter le contact central dans l'outillage C17712.
2.2 - Insérer un fil d'étain dans la chambre du contact.
2.3 - Couper le fil d'étain à ras du contact.



NICOMATIC recommande d'utiliser un fil d'étain Ø0.3mm

3/ 3.1 - Monter l'entretoise isolante sur le câble,



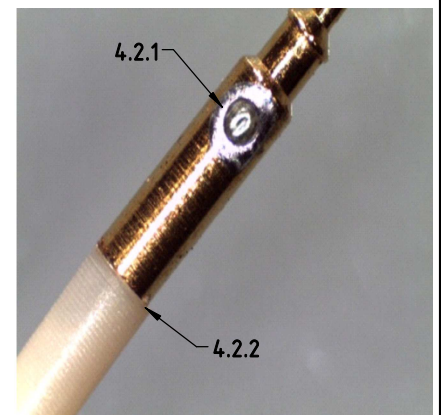
4/ 4.1 - Braser le contact central

4.2 - Vérifier la brasure du contact central et la position de l'isolant :

4.2.1 - la brasure peut sortir de la fenêtre d'inspection mais ne doit pas empêcher le montage

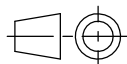
4.2.2 - la bague isolante doit être à ras du contact.

NICOMATIC recommande d'utiliser une pince à effet joule



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Echelle/Scale

4:1

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Designation : Instruction de câblage contact mâle
HF à braser série 22

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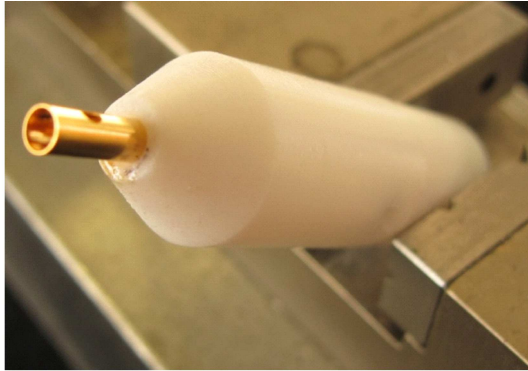
5/ 5.1 - Monter le contact central et le câble dans le corps :

5.1.1 - Monter le corps en buté dans l'outillage C17713.

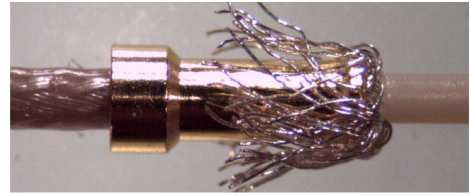
5.1.2 - Rabattre la tresse sur la fêrule,

5.1.3 - Insérer l'ensemble contact central soudé sur le câble.

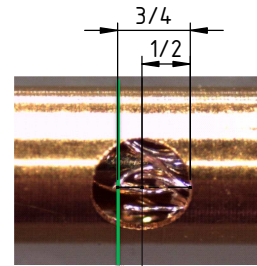
Un clic doit se faire sentir lors de l'insertion du contact central dans l'isolant.



5.1.1



5.1.2



5.2.1

5.2 - Vérification :

5.2.1 - Les brins de la tresse doivent couvrir au minimum les 3/4 du trou du corps

Côté : câble

Côté : Face avant du corps.

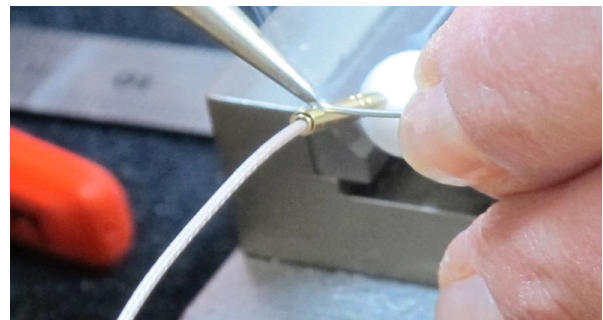
6/ 6.1 - Braser la tresse dans le corps :

6.1.1 - Chauffer la tresse par le trou du corps.

6.1.2 - Apporter de l'étain dans le trou,

6.1.3 - Reproduire l'opération dans le second trou

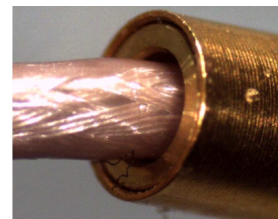
NICOMATIC recommande d'utiliser une panne de type LTK avec un fer à souder chauffé à 360°C et un fil d'étain Ø0.7 (99C) (longueur du fil 8 mm par trou).



6.1

6.2 - Vérifier la position de la fêrule :

6.2.1 - La fêrule ne doit pas dépasser du corps



6.2

6.3 - Vérifier la brasure :

6.3.1 - Les brins de la tresse de masse sont recouverts d'étain.

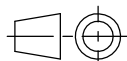
6.3.2 - La brasure est en creux ou affleurante au corps.



6.3



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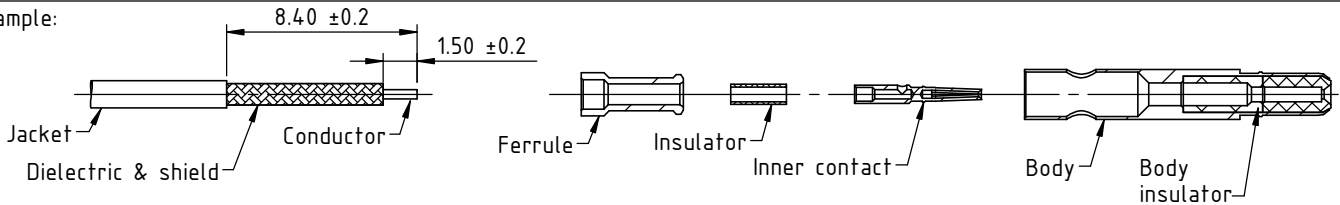
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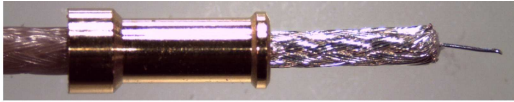
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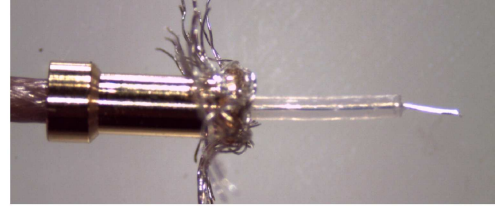
Example:



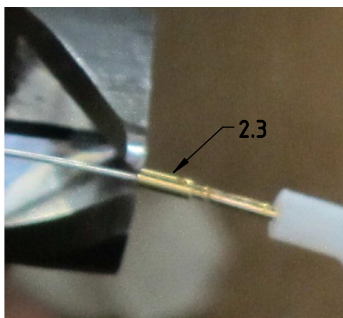
1/ 1.1 - Thread the ferrule to the stop on the cable.



1.2 - Brush back the shield onto the ferrule.

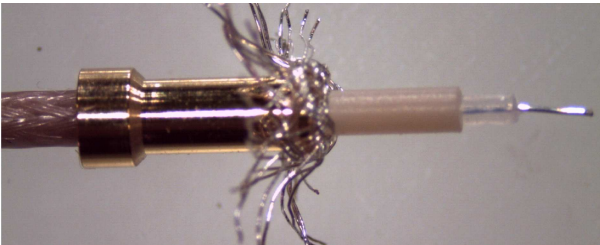


2/ 2.1 - Place the inner contact inside the tool C17712.
2.2 - Place the tin soldering wire inside the inner contact.
2.3 - Cut the tin soldering wire flush with the contact.



NICOMATIC recommends the use of a tin soldering wire with Ø0.3mm

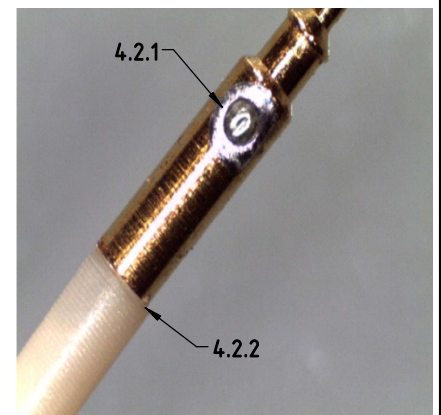
3/ 3.1 - Place the insulator over the dielectric.



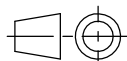
4/ 4.1 - Braid the inner contact

4.2 - Check the brazing of the inner contact and the location of the insulator :
4.2.1 - The brazing can be outside the inspection window but it must not prevent the assembly.
4.2.2 - the insulator must touch the inner contact.

NICOMATIC recommends the use of a Joule Effect Soldering Device



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Ref : IC22HF03

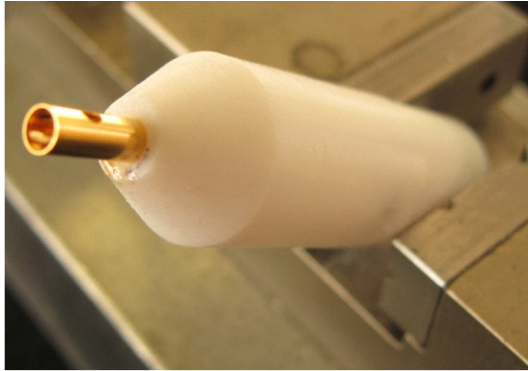
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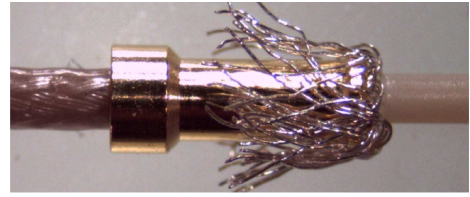
5/ **5.1 - Assemble the subassembly of the inner contact and the cable inside the body :**

- 5.1.1 - Place the body inside the tool C17713 (the body is in stop position).
- 5.1.2 - Fold the shield onto the ferrule.
- 5.1.3 - Insert the inner contact and cable subassembling into the body.

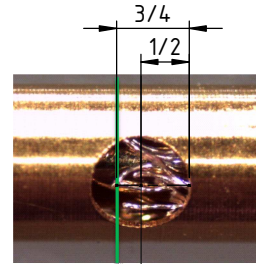
A sharp sound must be heard during the insertion of the inner contact with the body insulator.



5.1.1



5.1.2



Cable side

Contact front side

5.2.1

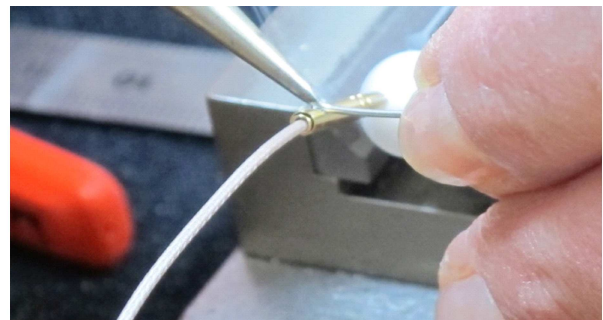
5.2 - Checking :

- 5.2.1 - The shield must cover a minimum of 3/4 of the inspection window

6/ **6.1 - Braze the shield with the body :**

- 6.1.1 - Heat up the shield by the inspection window.
- 6.1.2 - Add the tin
- 6.1.3 - Repeat steps 6.1.1 and 6.1.2 for the second inspection window.

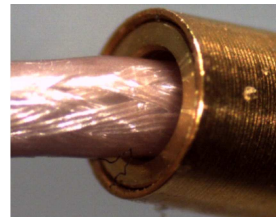
NICOMATIC recommends the use of a LTK soldering pencil with a soldering iron heat up at 360°C (680°F) and a tin soldering wire Ø0.7 (99C) (Length of the tin soldering wire per inspection windows 8 mm).



6.1

6.2 - Check the position of the ferrule :

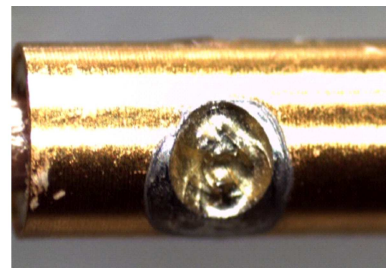
- 6.2.1 - The ferrule must not go outside the body



6.2

6.3 - Check the brazing :

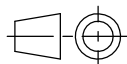
- 6.3.1 - The shield is cover by the tin.
- 6.3.2 - the brazing shape is in counter-relief or level with the body.



6.3



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