

## Crimping Manual for 211-POWER-F and 211-POWER-M

The power pins 211-POWER-F and 211-POWER-M are designed to use with the in-vacuum cable **311-KAPM-200**.

Other cables can be used. The crimp diameter of the connectors have an ID of 2.7mm max. Required settings or change in the procedure might be required with different cables and are not described in this manual.



- 1) Strip the cable 311-KAPM-200 of a length of 6 (+/-0.5)mm.  
Make sure, that the conductor is not damaged by the stripping process.
- 2) Insert the cable into the connector (211-POWER-F or 211-POWER-M).  
The stripped area has to go completely into the crimp ferule including about 1mm insulated wire.  
All conductor wires have to go into the crimp ferule
- 3) Use the hexagonal crimping tool 321-CTOOL-SMA-BNC at position 2.67mm.  
Crimp the complete length of the crimp ferule  
Other tools with the same hex size can be used as well, the crimp length must be 8.5mm minimum.
- 4) Crimp completely until the tool releases again.
- 5) Inspect the crimp. The thickness of the remaining hexagon must be 2.9mm or lower.  
If this is not the case, the crimp tool has to be re-adjusted.

With the above procedure, a tear-out force bigger than 10 N is reached.  
Samples tested by Allectra showed after applying 10x 11N no change.