EUROFIGHTER	ELECTRICAL ASSEMBLY INSTRUCTION MANUAL	A101
GmbH	59010	

CONNECTORS DK-621 RAYCHEM

SCOPE

1. This assembly method covers the assembly of Raychem data bus connectors with PAN6421 data bus cable.

PROCEDURE

- 1. Cut cable to length and ident.
- 2. Slide strain relief sleeve and braid terminator over cable and strip outer sheath to the dimension given in Fig 1.
- 3. Comb out braids and fold back over outer sheath. Cut fillers off flush with braid, strip the cores to 13mm. See Fig 2.
- 4. Tin the conductors and trim back to the dimensions given in Fig 3.
- 5. Insert the conductors into the contact, the red conductor into the inner insulating sleeve and the blue core between the two insulating sleeves. Heat contact until both solder pre-forms have melted and flowed (holding tool AD1480 or AD1319 with AT1319-14 may be used to hold the contact). Fig 4.
- 6. Inspection stage.
- 7. Insert contact into the rear of the tri-axial connector body until the contact locks into place in the insulator. Fold the braid forward and trim if required to the dimensions given in Fig 5.
- 8. Slide the braid terminator forward up to shoulder of connector. Heat terminator assembly until solder melts and flows (holding tool AD1504 may be used).
- 9. Inspection stage.
- 10. Slide strain relief tubing over terminator assembly and recover commencing at body end.

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