CONNECTOR ASSEMBLY WITH TRIAX CABLE

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CONNECTOR ASSEMBLY WITH TRIAX CABLE

1. PART NUMBERS AND DESCRIPTION

A. Connector Part Numbers

Table 1
CONNECTOR PART NUMBERS

Part Number	Connector Type	Supplier
1965-12-9	Triax Cable	Kings
30382-1	Triax Cable	Dage
30391-1	Triax Cable	Dage
83-59	Right Angle UHF	Amphenol

B. Cable Adapter Part Numbers

Table 2
TRIAX CABLE ADAPTER PART NUMBERS

Part Number	Supplier
83-185	Amphenol

C. Cable Part Numbers

Table 3
TRIAX CABLE PART NUMBERS

Part Number	Cable Type	Supplier
10363	Triax	Raychem
7524D5011	Triax	Raychem
BA6416A	Triax	Surprenant

D. Necessary Materials

Table 4
NECESSARY MATERIALS

Material	Specification or Part Number	Supplier	Notes
Adhesive	S-1006	Raychem	-
	S-1009	Raychem	-
Catalyst, RTV	F	Dow Corning	Only For RTV-3110 Potting Compound
	S	Dow Corning	Only For RTV-3110 Potting Compound
Emery Cloth	No. 240	Any Source	-
	No. 320	Any Source	-
Masking Tape	1/2 Inch Width	Any Source	-

Table 4 NECESSARY MATERIALS (Continued)

Material	Specification or Part Number	Supplier	Notes
Naptha, aliphatic	TT-N-95	Any Source	-
Solvent	BMS 11-7	Boeing	-

Table 5
APPROVED SUPPLIERS OF BOEING STANDARD SOLVENTS

Boeing Specification	Approved Supplier
BMS 11-7	AZKO/Dexter Aerospace Finishes
	Barton Solvents
	Elf Atochem Turco Products
	Pratt and Lambert Industrial Coating

Table 6
POTTING COMPOUNDS

Temperature Grade	Description	Part Number or Specification	Cure Time (hours)	Notes	Supplier
A	Polysulfide	MIL-S-8516	48	-	QPL
		WS 516		-	J and R Industries
C	Silicone	RTV-3110	2	10 Percent Catalyst F	Dow Corning
			6.5	10 Percent Catalyst S	Dow Corning

2. ASSEMBLY OF MIL-C-26482 AND MIL-C-26500 CONNECTORS WITH TRIAX CABLE

This paragraph gives the procedures to assemble connectors with these triax cables:

- Raychem 10363
- Raychem 7524D5011
- Surprenant BA6416A.

A. Connector Assembly with a Straight Heat Shrinkable Boot

This paragraph gives the procedure to assemble the connector with the Raychem 202A132-3-00 heat shrinkable boot.

(1) Prepare the cable. Refer to Paragraph 2.C.

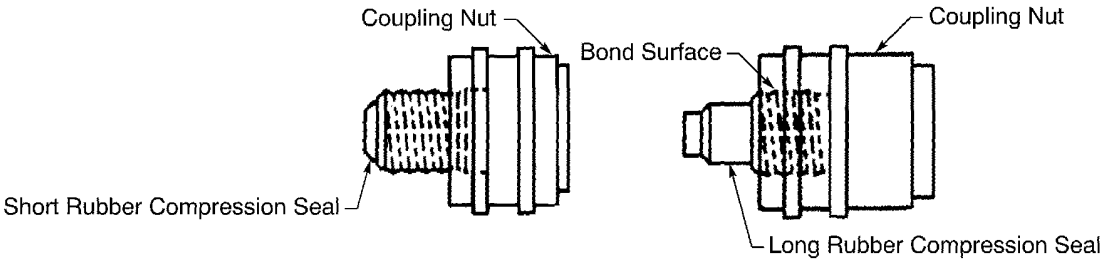
(2) Discard the ferrule and the grommet nut if they are supplied with the connector.

NOTE: The ferrule and the grommet nut are not used for assembly of a connector with a heat shrinkable boot.

(3) Make a selection of a 500 degree F hot air gun. Refer to Subject 20-30-12.

NOTE: A reflector is recommended.

(4) For a connector that has a long rubber compression seal, prepare the surfaces of the boot, the connector and the cable that make a bond with an adhesive. Refer to Figure 1 and Paragraph 2.F.



BOND SURFACE OF A CONNECTOR WITH A LONG RUBBER COMPRESSION SEAL
Figure 1

(5) Put the boot on the cable.

(6) Assemble the connector.

Refer to:

- Subject 20-61-16 for the procedures to assemble a MIL-C-26482 type connector
- Subject 20-61-11 for the procedures to assemble a MIL-C-26500 type connector.

(7) For a connector that has a long rubber compression seal:

(a) Make a selection of an adhesive from Table 4.

(b) Make a selection of a solvent from Table 4.

(c) Apply the adhesive on the bond surface of these components:

- The boot
- The connector
- The cable.

Make sure that the adhesive extends 0.13 inch farther than the bond surface.

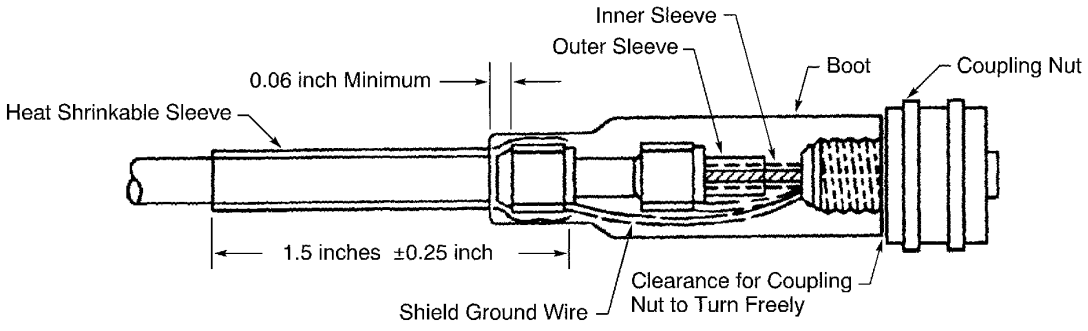
(8) Move the boot into its position on the threads of the connector.

Make sure that the coupling nut can be turned freely.

Refer to:

- Figure 2 for the installation of a boot on a connector that has a short rubber compression seal
- Figure 3 for the installation of a boot on a connector that has a long rubber compression seal.

CONNECTOR ASSEMBLY WITH TRIAX CABLE



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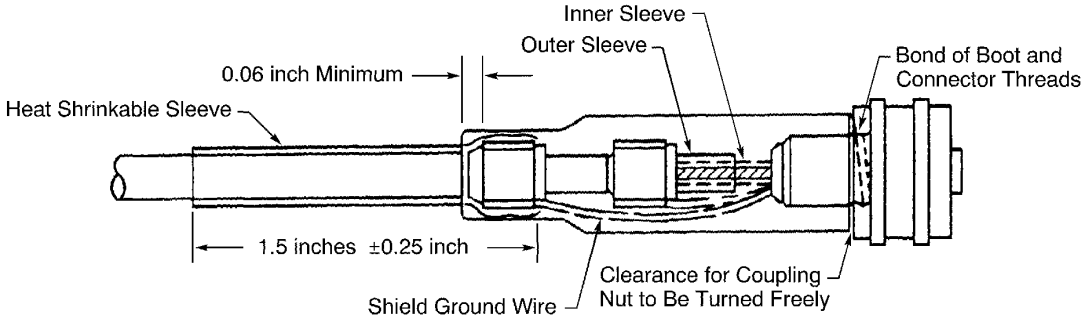
INSTALLATION OF A BOOT ON A CONNECTOR THAT HAS A SHORT RUBBER COMPRESSION SEAL
Figure 2



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INSTALLATION OF A BOOT ON A CONNECTOR THAT HAS A LONG RUBBER COMPRESSION SEAL
Figure 3

(9) Shrink the boot.

Make sure that:

- The intake air vent on the hot air gun is open
- The hot air gun is at the full operation temperature
- A heat shield is used to give the cable protection from damage
- Heat is applied for no longer than 40 seconds at one time.

(10) If unwanted adhesive is on the boot or the connector, remove the unwanted adhesive immediately with a clean wiper and solvent.

(11) If it is necessary to apply heat again, let the boot cool for 5 minutes before the heat is applied again.

(12) Seal the boot with potting compound. Refer to Paragraph 2.G.

B. Connector Assembly with a 90 Degree Heat Shrinkable Boot

This paragraph gives the procedure to assemble the connector with the Raychem 222A132-3-00 heat shrinkable boot.

(1) Prepare the cable. Refer to Paragraph 2.D.

(2) Discard the ferrule and the grommet nut if they are supplied with the connector.

NOTE: The ferrule and the grommet nut are not used for assembly of a connector with a heat shrinkable boot.

(3) Make a selection of an adhesive from Table 4.

(4) Make a selection of a 500 degree F hot air gun. Refer to Subject 20-30-12.

NOTE: A reflector is recommended.

(5) Prepare the boot. Refer to Paragraph 2.E.

(6) Prepare the surfaces of the boot, the connector, and the cable that make a bond with an adhesive. Refer to Paragraph 2.F.

(7) Put the boot on the cable.

(8) Assemble the connector.

Refer to:

- Subject 20-61-16 for the procedures to assemble a MIL-C-26482 type connector
- Subject 20-61-11 for the procedures to assemble a MIL-C-26500 type connector.

(9) Put the cable or wire harness in an approximate 90 degree position. Refer to Figure 17.

(10) Apply the adhesive on the bond surface of these components:

- The boot
- The connector
- The cable.

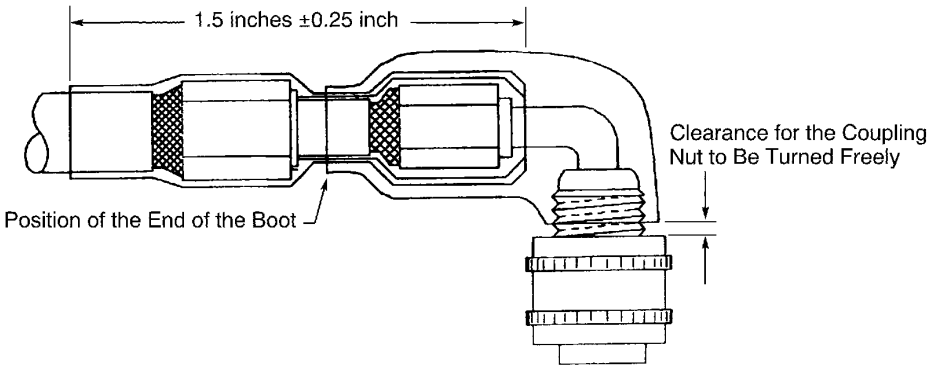
Make sure that the adhesive extends 0.13 inch farther than the bond surface.

(11) Move the boot into its position on the threads of the connector. Refer to Figure 4.

Make sure that:

- The coupling nut can be turned freely

• The boot assembly is in the correct clock position on the connector.



2445515 S00061546227_V1

INSTALLATION OF A 90 DEGREE BOOT
Figure 4

(12) Shrink the boot.

Make sure that:

- The intake air vent on the hot air gun is open
- The hot air gun is at the full operation temperature
- A heat shield is used to give the cable protection from damage
- Heat is applied for no longer than 40 seconds at one time.

(13) Remove the unwanted adhesive immediately with a clean wiper and solvent.

(14) If it is necessary to apply heat again, let the boot cool for 5 minutes before the heat is applied again.

(15) Seal the boot with potting compound. Refer to Paragraph 2.G.

C. Cable Preparation for Assembly with a Straight Heat Shrinkable Boot

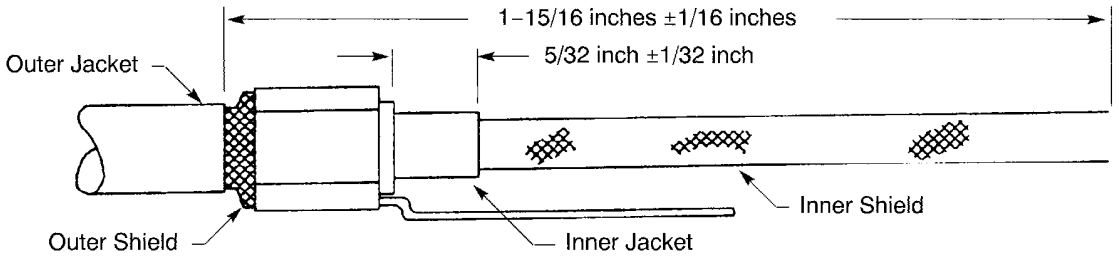
(1) Remove 1-15/16 inches ±1/16 inch of the outer jacket of the cable.

(2) Install a shield ground wire to the outer shield at the end of the outer jacket.

Use mechanical ferrules. Refer to Figure 5 and Subject 20-10-15.

(3) Remove the necessary length of the inner jacket so that the edge of the jacket is 5/32 inch ±1/32 inch from the ferrule on the outer shield.

Refer to Figure 5.



2446345 S00061546228_V1

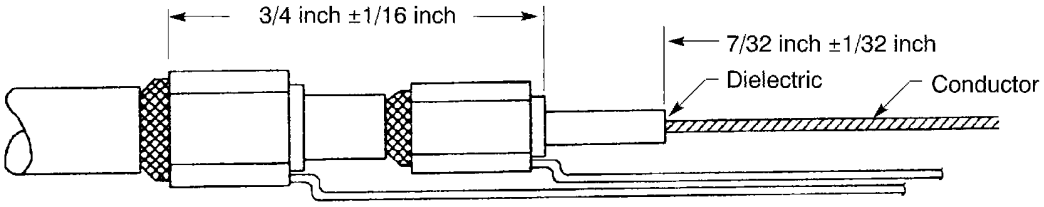
TERMINATION OF THE OUTER SHIELD
Figure 5

(4) Install a shield ground wire to the inner shield.

Use mechanical ferrules. Refer to Figure 6 and Subject 20-10-15.

(5) Remove the necessary length of the dielectric so that the edge of the dielectric is 7/32 inch ±1/32 inch from the ferrule on the inner shield.

Refer to Figure 6.

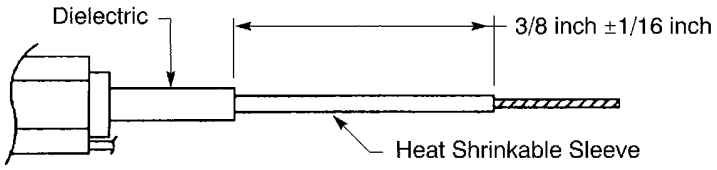


2446346 S00061546229_V1

TERMINATION OF THE INNER SHIELD
Figure 6

(6) Put a 3/8 inch ±1/16 inch length of 3/32 inch diameter heat shrinkable sleeve over the center conductor. Refer to Figure 7.

Make sure that the sleeve touches the end of the dielectric.



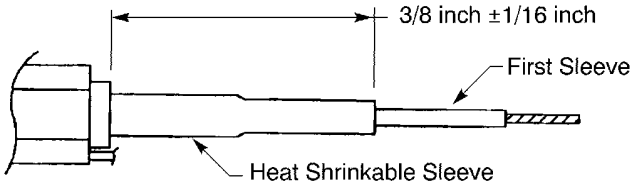
2446347 S00061546230_V1

POSITION OF THE FIRST SLEEVE
Figure 7

(7) Shrink the sleeve in position.

(8) Put a 7/16 inch ±1/16 inch length of 3/32 inch diameter of heat shrinkable sleeve on the dielectric and the first sleeve. Refer to Figure 8.

Make sure that the sleeve touches the ferrule of the inner shield.

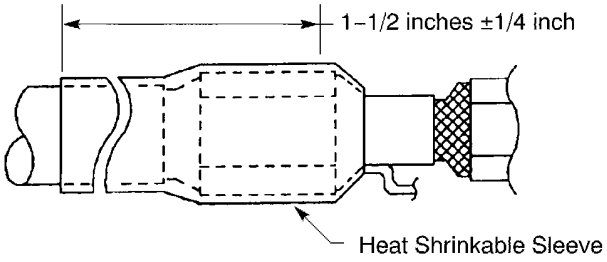


2446348 S00061546231_V1

POSITION OF THE SECOND SLEEVE
Figure 8

(9) Shrink the sleeve in position.

(10) Put a 1-1/2 inch ±1/4 inch length of 1/4 inch heat shrinkable sleeve on the outer shield termination. Refer to Figure 9.



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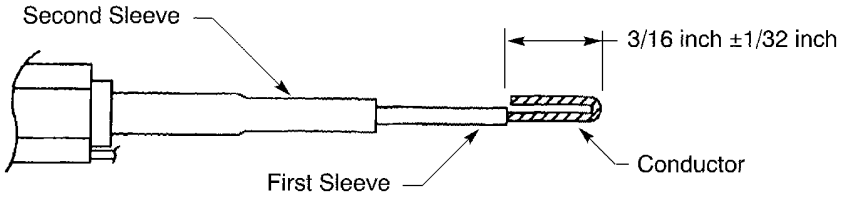
POSITION OF THE SLEEVE ON THE OUTER SHIELD TERMINATION
Figure 9

(11) Shrink the sleeve in position.

(12) Fold the center conductor back on itself so that the end of the conductor is 3/16 inch ±1/32 inch from the end of the sleeve. Refer to Figure 10.



2446350 S00061546233_V1

CONDUCTOR FOLDED BACK
Figure 10

D. Cable Preparation for Assembly with a 90 Degree Heat Shrinkable Boot

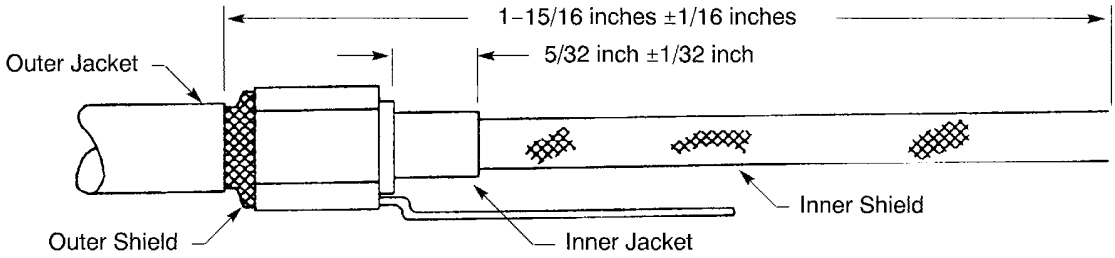
(1) Remove 1-15/16 inches ±1/16 inch of the outer jacket of the cable.

(2) Install a shield ground wire to the outer shield at the end of the outer jacket.

Use mechanical ferrules. Refer to Figure 11 and Subject 20-10-15.

(3) Remove the necessary length of the inner jacket so that the edge of the jacket is 5/32 inch ±1/32 inch from the ferrule on the outer shield.

Refer to Figure 11.



2446345 S00061546228_V1

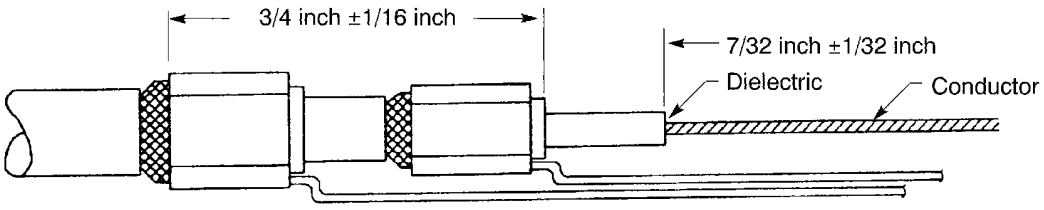
TERMINATION OF THE OUTER SHIELD
Figure 11

(4) Install a shield ground wire to the inner shield.

Use mechanical ferrules. Refer to Figure 12 and Subject 20-10-15.

(5) Remove the necessary length of the dielectric so that the edge of the dielectric is 7/32 inch ±1/32 inch from the ferrule on the inner shield.

Refer to Figure 12.

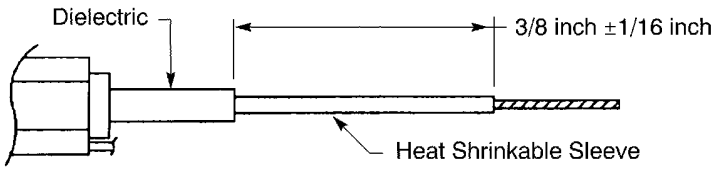


2446346 S00061546229_V1

TERMINATION OF THE INNER SHIELD
Figure 12

(6) Put a 3/8 inch ±1/16 inch length of 3/32 inch diameter heat shrinkable sleeve over the center conductor. Refer to Figure 13.

Make sure that the sleeve touches the end of the dielectric.



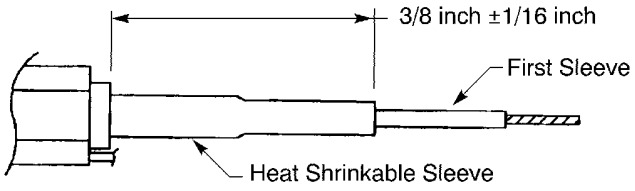
2446347 S00061546230_V1

POSITION OF THE FIRST SLEEVE
Figure 13

(7) Shrink the sleeve in position.

(8) Put a 7/16 inch ±1/16 inch length of 3/32 inch diameter of heat shrinkable sleeve on the dielectric and the first sleeve. Refer to Figure 14.

Make sure that the sleeve touches the ferrule of the inner shield.



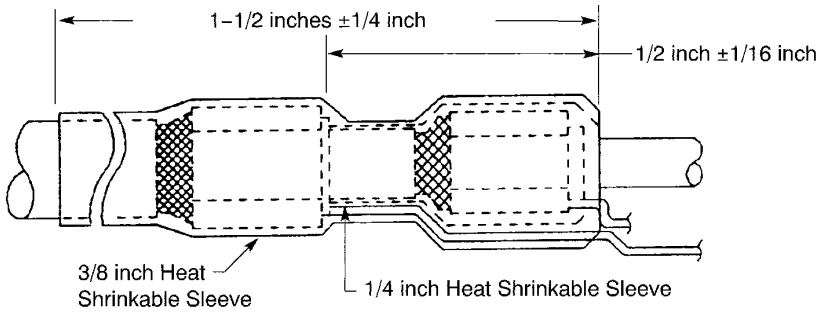
2446348 S00061546231_V1

POSITION OF THE SECOND SLEEVE
Figure 14

(9) Shrink the sleeve in position.

(10) Put a 1/2 inch ±1/16 inch length of 1/4 inch heat shrinkable sleeve on the second shield ferrule and the inner jacket. Refer to Figure 15.

Make sure that the sleeve is against the outer shield ferrule.



2445514 S00061546234_V1

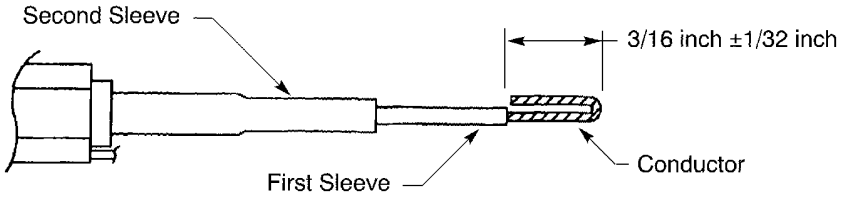
INSTALLATION OF INSULATION ON THE SHIELD TERMINATION
Figure 15

(11) Shrink the sleeve into its position. Refer to Subject 20-10-14.

(12) Put a 1-1/2 inch ±1/4 inch length of 3/8 inch heat shrinkable sleeve on the inner shield termination. Refer to Figure 15.

(13) Shrink the sleeve into its position. Refer to Subject 20-10-14.

(14) Fold the center conductor back on itself so that the end of the conductor is 3/16 inch ±1/32 inch from the end of the sleeve. Refer to Figure 16.

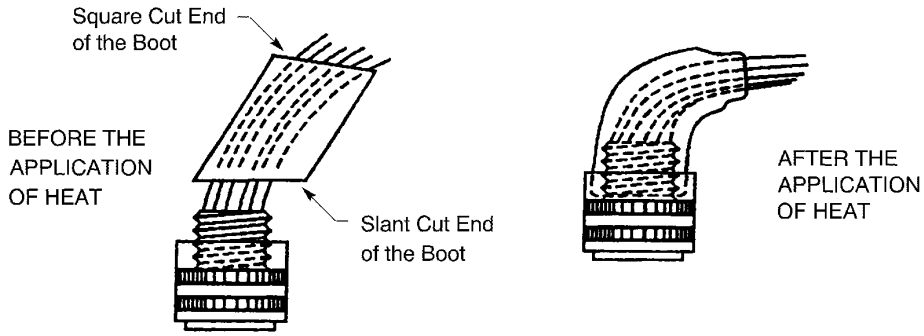


2446350 S00061546233_V1

CONDUCTOR FOLDED BACK
Figure 16

E. Boot Preparation for a 90 Degree Heat Shrinkable Boot

For the conditions that are applicable to this procedure, refer to Paragraph 2.B.



2445513 S00061543704_V1

PREPARATION OF A 90 DEGREE BOOT
Figure 17

Refer to Figure 17.

(1) Put a 1/4 to 5/16 inch diameter rod approximately 0.5 inch into the square cut end of the boot. Refer to Figure 17.

(2) Shrink the boot on the rod.

(3) Let the boot cool.

(4) Remove the rod from the boot.

(5) For a connector that has a short rubber compression seal, do Step 2.E.(1) through Step 2.E.(4) again for the slant cut end of the boot. Refer to

F. Bond Surface Preparation

For the conditions that are applicable for this procedure, refer to Paragraph 2.B.

(1) Make a selection of an aliphatic naptha from Table 4.

(2) Prepare the surfaces of the boot that must make a bond with the adhesive.

(a) Wind a piece of emery cloth around an applicable rod or tool.

(b) Make the bond surfaces rough.

(c) Shake the loose particles out of the boot.

(d) Clean the bond surfaces with a clean wiper and naptha.

(e) Dry the boot with a wiper immediately.

CAUTION: DO NOT LET THE NAPTHA DRY ON THE BOOT. WHEN NAPTHA DRIES, AN UNWANTED FILM STAYS ON THE CLEAN SURFACES.

(3) Clean the other surfaces that must make a bond with the adhesive.

(a) Clean the bond surfaces of the connector threads with a clean wiper and naptha.

(b) Dry the connector with a wiper immediately.

CAUTION: DO NOT LET THE NAPTHA DRY ON THE CONNECTOR. WHEN NAPTHA DRIES, AN UNWANTED FILM STAYS ON THE CLEAN SURFACES.

(c) Clean the bond surface on the cable with a clean wiper and naptha.

Make sure to clean the insulation the cable approximately 1 inch farther than the bond surface.

(d) Dry the insulation with a wiper immediately.

CAUTION: DO NOT LET THE NAPTHA DRY ON THE INSULATION. WHEN NAPTHA DRIES, AN UNWANTED FILM STAYS ON THE CLEAN SURFACES.

G. Seal of the Boot with Potting Compound

For the conditions that are applicable for this procedure, refer to Paragraph 2.B.

(1) Make a selection of a potting compound from Table 6.

(2) If the potting compound is a silicone compound, make a selection of a catalyst from Table 4.

Refer to the manufacturer's instructions to mix the compound with the catalyst.

(3) Fill the boot assembly with potting compound.

Make sure that air is not caught in the boot.

NOTE: To make a continuous flow of the potting compound, a constant pressure is recommended.

(4) Lightly tap the boot on a solid surface or shake the boot to release air that is caught in the boot.

(5) Let the potting compound cure for the specified time. Refer to Table 6.

3. ASSEMBLY OF AMPHENOL 83-59 RIGHT ANGLE UHF CONNECTORS WITH TRIAX CABLE

This paragraph gives the procedures assemble an Amphenol 83-185 cable adapter with these triax cables:

- Raychem 7524D5011
- Surprenant BA6416A.

A. Cable Preparation

(1) Put the 83-185 cable adapter on the cable.

Make sure that the small end is toward the end of the cable.

(2) Cut the cable so that the end of the cable is perpendicular with its longitudinal axis.

(3) Remove 7/8 inch to 5/16 inch of the outer jacket from the end of the cable.

(4) Align the edge of the adapter with the edge of the outer jacket.

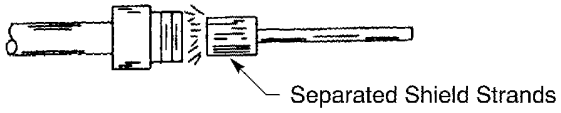
(5) Open the outer shield braid and move the strands of the shield apart.

(6) Fold the shield strands back over the end of the adapter.
Make sure that the strands are applied evenly around the adapter.

(7) Remove 27/32 inch to 29/32 inch of the inner jacket.

(8) Open the inner shield braid and move the strands of the shield apart.

(9) Fold the shield strands back over the end of the adapter. Refer to Figure 18.
Make sure the strands are applied evenly around the adapter.

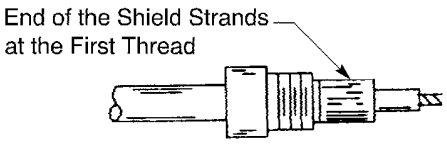


2446352 S00061546235_V1

POSITION OF THE INNER SHIELD
Figure 18

(10) Solder the shield strands to the adapter.

(11) Remove the ends of the strands at the first thread of the adapter. Refer to Figure 19.



2446353 S00061546236_V1

TERMINATION OF THE INNER SHIELD
Figure 19

(12) Remove 5/8 inch to 11/16 inch of dielectric from the end of the cable.

(13) Cut the conductor so that the end of the conductor is 1/8 inch to 3/16 inch for the end of the dielectric.

B. Connector Assembly

(1) Remove the connector cap screw.

(2) Align the slot of the contact with the cable axis.

(3) Hold the shoulder of the adapter with pair of padded pliers.

(4) Turn the connector body on the adapter.
Make sure to guide the center conductor into the slot of the pin.

(5) Tighten the adapter on the body of the connector.

(6) Solder the shield strands to the body of the connector through the four solder holes.
Make sure to:

- Use only the necessary quantity of solder
- Apply only the necessary amount of heat.

(7) Solder the conductor in the slot of the connector pin.

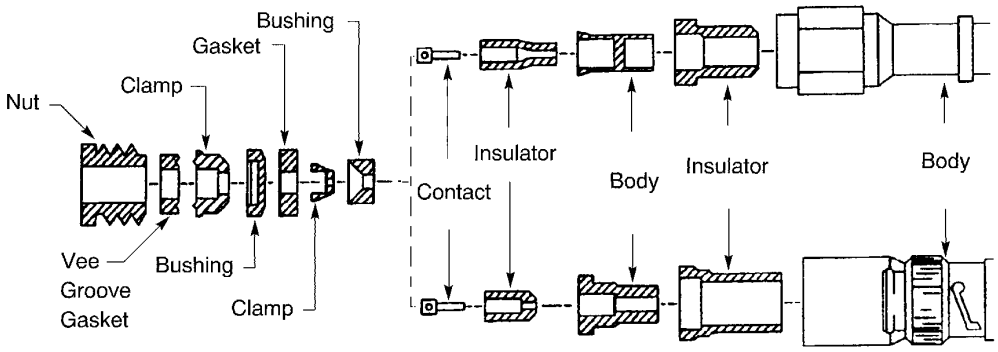
(8) Tighten the connector cap screws.

4. ASSEMBLY OF DAGE 30382-1 AND 30391-1 CONNECTORS WITH TRIAX CABLE

This paragraph gives the procedures to assemble the connectors with these triax cables:

- Raychem 10363
- Raychem 7524D5011
- Surprenant BA6416A.

A. Connector Description



2446354 S00061546237_V1

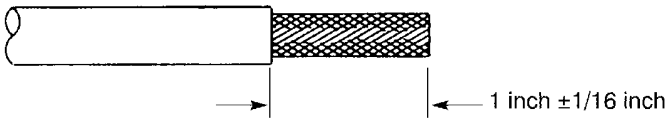
DAGE 30382-1 AND 30391-1 CONNECTORS
Figure 20

B. Cable Preparation

Refer to Figure 20.

(1) Cut the cable so that the end is perpendicular to its longitudinal axis.

(2) Remove 1 inch ±1/16 inch of the outer jacket of the cable. Refer to Figure 21.



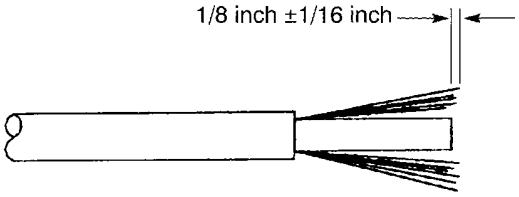
2446355 S00061546238_V1

OUTER JACKET REMOVAL LENGTH
Figure 21

(3) Open the shield braid and move the strands of the shield apart.

CAUTION: DO NOT REMOVE THE PLATING ON THE SHIELD STRANDS.

(4) Remove an additional 1/8 inch ±1/16 inch of the cable so that shield strands extend past the end of the cable. Refer to Figure 22.



2446356 S00061546240_V1

OUTER SHIELD STRANDS EXTENDED PAST THE END OF THE CABLE
Figure 22

(5) Put tape on the braid so the connector components can be moved over the shield strands.

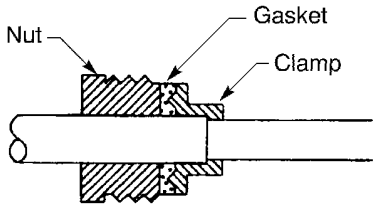
(6) In order, put these components over the tapes strands of the shield:

- The nut
- The vee groove gasket
- The clamp.

Make sure that:

- The vee of the gasket is turned toward the clamp
- The inner shoulder of the clamp is tight against the end of the jacket.

Refer to Figure 23.

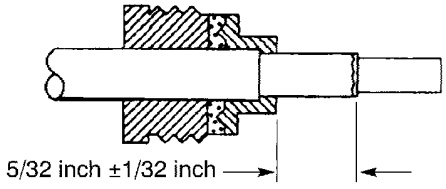


2450244 S00061546241_V1

POSITION OF THE NUT, THE GASKET, AND THE CLAMP
Figure 23

(7) Remove the necessary length of the taped strands of the shield so that the distance from the end of the strands to the clamp is 5/32 inch ±1/32 inch.

Refer to Figure 24.

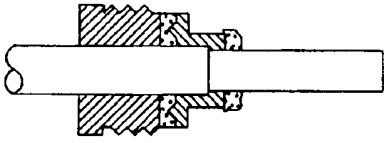


2446357 S00061546242_V1

LENGTH OF THE TAPED STRANDS OF THE SHIELD
Figure 24

(8) Remove the tape from the shield strands.

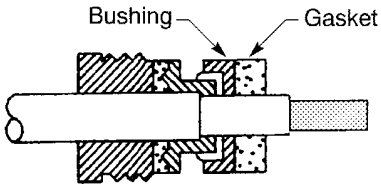
(9) Fold the shield strands back over the clamp. Refer to Figure 25.



2446358 S00061546243_V1

SHIELD STRANDS FOLDED BACK OVER THE CLAMP
Figure 25

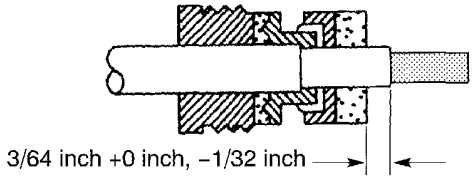
(10) Put the bushing and the gasket on the cable and push them until the bushing is against the shield strands. Refer to Figure 26.



2446359 S00061546244_V1

POSITION OF THE BUSHING AND THE GASKET
Figure 26

(11) Remove the necessary length of the inner jacket so that the end of the jacket is 3/64 inch +0 inch, -1/32 inch from the gasket. Refer to Figure 27.



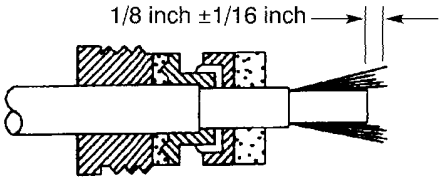
2446360 S00061546245_V1

LENGTH OF THE BARE INNER JACKET
Figure 27

(12) Open the inner shield and move the strands of the shield apart.

(13) Remove 1/8 inch ±1/16 inch from the end of the conductor so that the strands of the shield extend past the end of the cable. Refer to Figure 28.

CAUTION: DO NOT REMOVE THE PLATING ON THE SHIELD STRANDS.

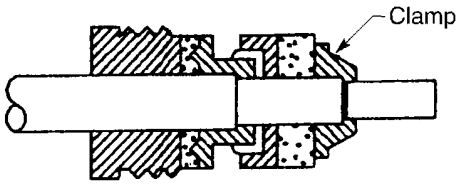


2446361 S00061546246_V1

INNER SHIELD STRANDS EXTENDED PAST THE END OF THE CABLE
Figure 28

(14) Put tape on the braid so the connector components can be moved over the shield strands.

(15) Put the clamp on the cable and over the inner shield so that the shoulder of the clamp is tight against the end of the inner jacket. Refer to Figure 29.

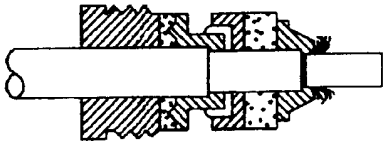


2446362 S00061546247_V1

CLAMP POSITION OVER THE INNER SHIELD
Figure 29

(16) Remove the tape from the shield strands.

(17) Fold the shield strands back over the clamp. Refer to Figure 30.

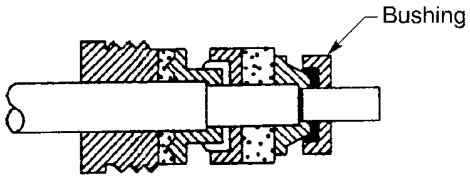


2446363 S00061546248_V1

STRANDS OF THE INNER SHIELD FOLDED OVER THE CLAMP
Figure 30

(18) Remove the unwanted length of the shield strands. Refer to Figure 30.

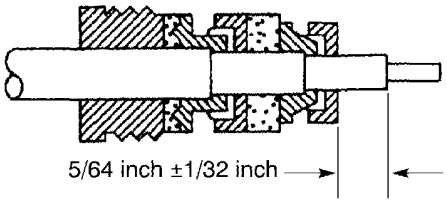
(19) Put the small bushing on the cable so that the bushing is tight against the shield strands. Refer to Figure 31.



2446364 S00061546249_V1

POSITION OF THE BUSHING
Figure 31

(20) Remove the necessary length of the dielectric so that the end of the dielectric is 5/64 inch ±1/32 inch from the bushing. Refer to Figure 32.

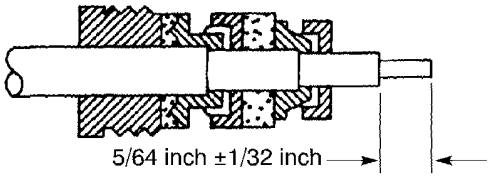


2446365 S00061546250_V1

LENGTH OF THE BARE DIELECTRIC
Figure 32

(21) Remove the necessary length of the conductor so that the end of the conductor is 5/64 inch ±1/32 inch from the end of the dielectric.

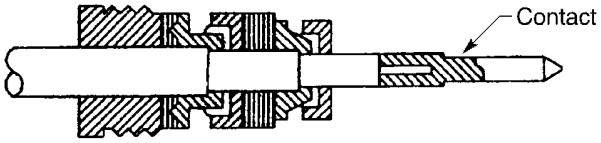
Refer to Figure 33.



2446366 S00061546251_V1

LENGTH OF THE BARE CONDUCTOR
Figure 33

C. Contact Assembly



2446367 S00061546252_V1

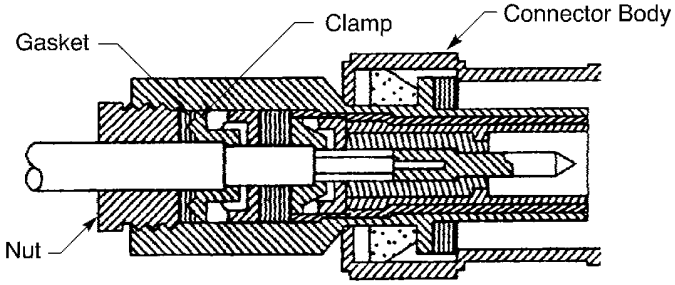
ASSEMBLED CONTACT
Figure 34

(1) Solder the contact to the conductor. Refer to Figure 34.

CAUTION: DO NOT APPLY TOO MUCH HEAT. THE DIELECTRIC WILL NOT ENTER THE INSULATOR PROPERLY.

(2) Remove any unwanted solder.

D. Connector Assembly



2446368 S00061546254_V1

CONNECTOR ASSEMBLY
Figure 35

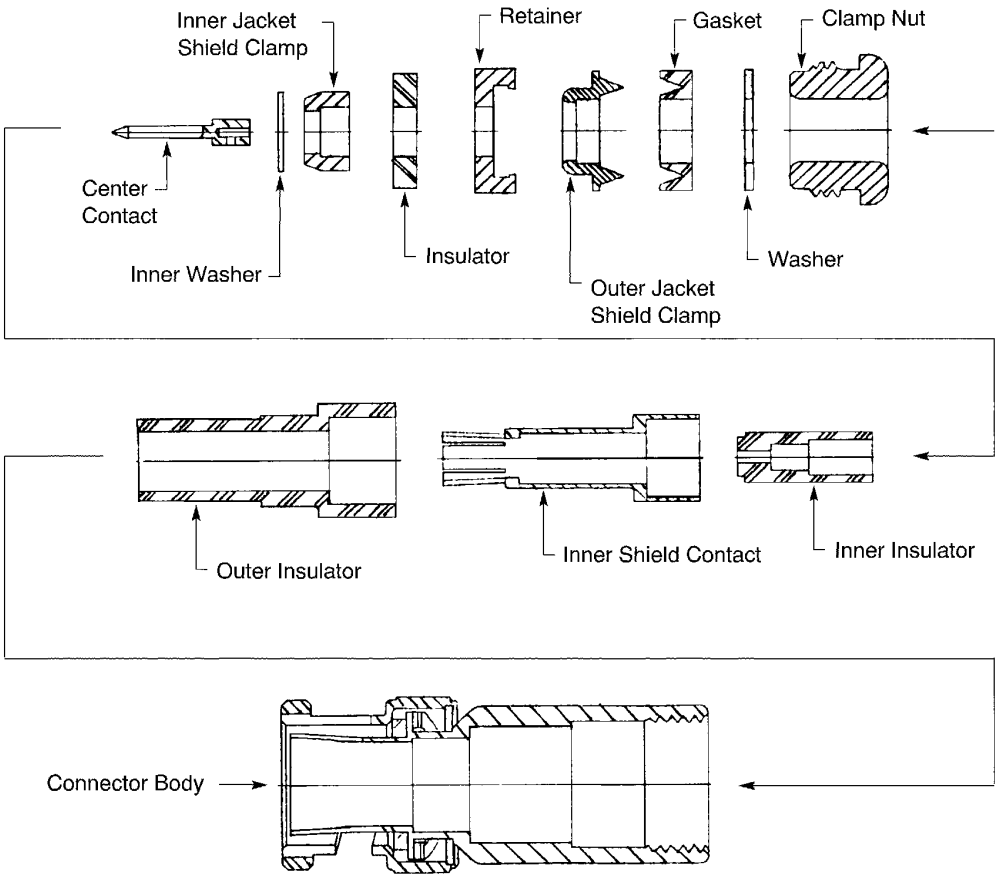
(1) Put the assembled contact into the connector body. Refer to Figure 35.
Make sure the gasket is against the sharp edge of the clamp.

(2) Torque the nut 45 inch-pounds ±5 inch-pounds.

5. ASSEMBLY OF KINGS 1965-12-9 CONNECTORS WITH TRIAX CABLE

This paragraph gives the procedure to assemble the Kings 1965-12-9 connector with a Raychem 7524D5011 triax cable.

A. Connector Description



2446369 S00061546255_V1

KINGS 1965-12-9 TRIAX CONNECTOR
Figure 36

B. Cable Preparation

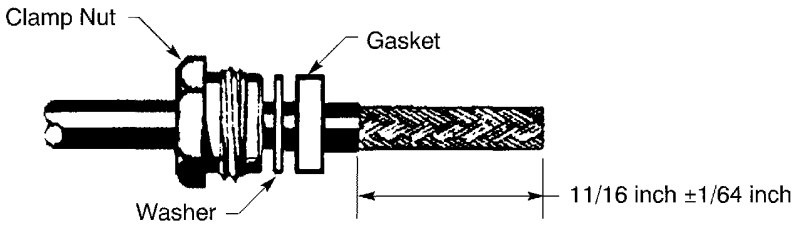
Refer to Figure 36.

(1) Cut the cable so that the end is perpendicular to its longitudinal axis.

(2) In order, put these components on the cable:

- The clamp nut
- The washer
- The gasket.

(3) Remove 11/16 inch ±1/64 inch of the outer jacket of the cable. Refer to Figure 37.



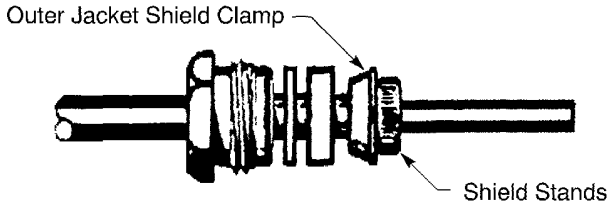
2446370 S00061546256_V1

OUTER JACKET REMOVAL LENGTH
Figure 37

(4) Put the outer jacket shield clamp over the outer shield and against the edge of the outer jacket.

(5) Use a non-metallic pick to open the outer shield braid and move the strands of the shield apart.

(6) Fold the shield strands back over the clamp. Refer to Figure 38.



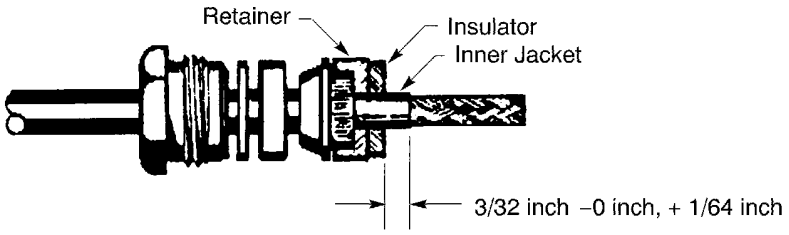
2446371 S00061546257_V1

STRANDS OF THE OUTER SHIELD FOLDED OVER THE CLAMP
Figure 38

(7) Remove the unwanted length of the shield strands. Refer to Figure 38.

(8) Put the retainer and the insulator on the cable against the shield strands.

(9) Remove the necessary length of the inner jacket so that the end of the jacket is 3/32 inch, - 0 inch, +1/64 inch from the insulator. Refer to Figure 39.



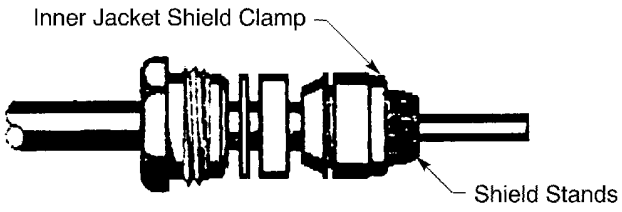
2446372 S00061546258_V1

LENGTH OF THE BARE INNER JACKET
Figure 39

(10) Put the inner jacket shield clamp over the inner shield and against the endge of the inner jacket.

(11) Use a non-metallic pick to open the inner shield braid and move the strands of the shield apart.

(12) Fold the shield strands back over the clamp. Refer to Figure 40.



2446373 S00061546259_V1

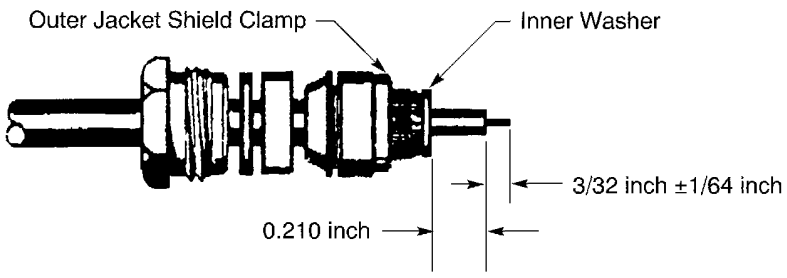
STRANDS OF THE INNER SHIELD FOLDED OVER THE CLAMP
Figure 40

(13) Remove the unwanted length of the shield strands. Refer to Figure 40.

(14) Put the inner washer on the cable against the shield strands.

(15) Remove the necessary length of the dielectric so that the end of the dielectric is 0.210 inch from the washer. Refer to Figure 41.

Make sure that the length of the bare conductor is 3/32 inch ±1/64 inch.

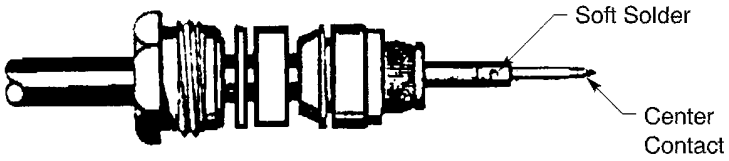


2446374 S00061546260_V1

LENGTH OF THE BARE DIELECTRIC AND THE BARE CONDUCTOR
Figure 41

C. Contact Assembly

(1) Solder the contact to the center conductor. Refer to Figure 42.



2446375 S00061546261_V1

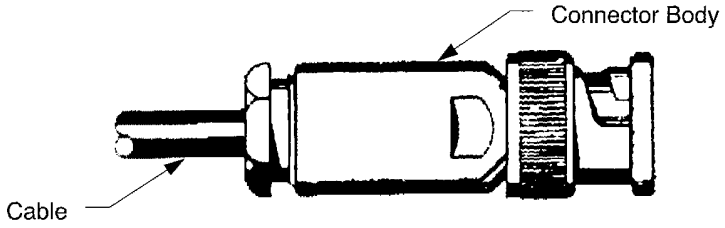
CONTACT SOLDERED TO THE CENTER CONDUCTOR
Figure 42

D. Connector Assembly

(1) In order, put these components over the center contact:

- The inner insulator
- The inner shield contact
- The outer insulator.

(2) Put the assembled contact in the connector body. Refer to Figure 43.



2446376 S00061546262_V1

CONNECTOR ASSEMBLY
Figure 43

(3) Turn the clamp nut to tighten the assembled contact in the connector body.

(4) Torque the clamp nut 45 inch-pounds ± 5 inch-pounds.