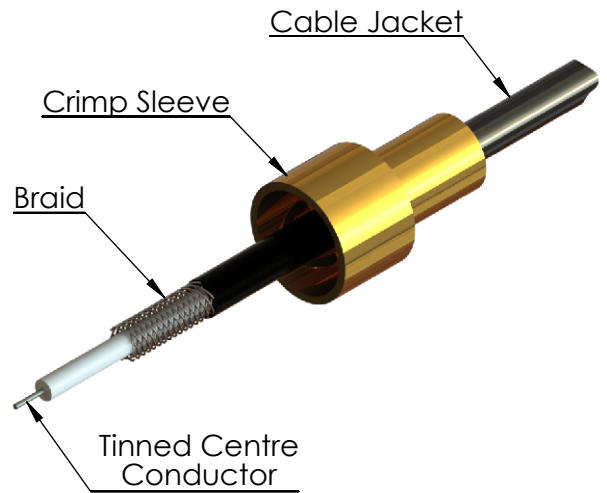
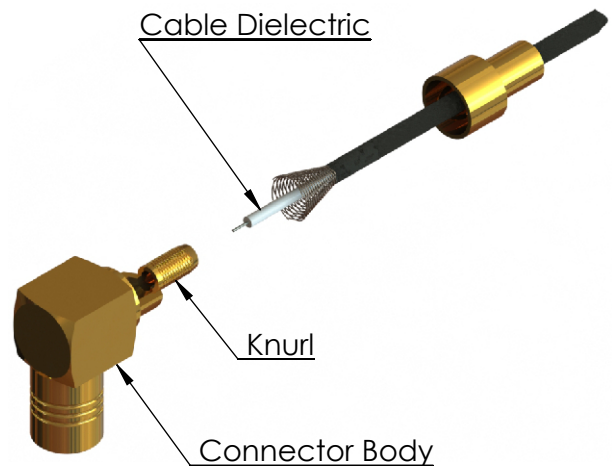


# ASSEMBLY PROCEDURE : AP040

1. Slide the Crimp Sleeve onto the cable, smaller diameter, first as shown.
2. Strip the cable to the dimensions given on the connectors datasheet.
3. Check to ensure the cables Centre Conductor is undamaged. Then using an appropriate solder, carefully Tin the Centre Conductor & the solder bucket at the rear end of the Centre Contact.

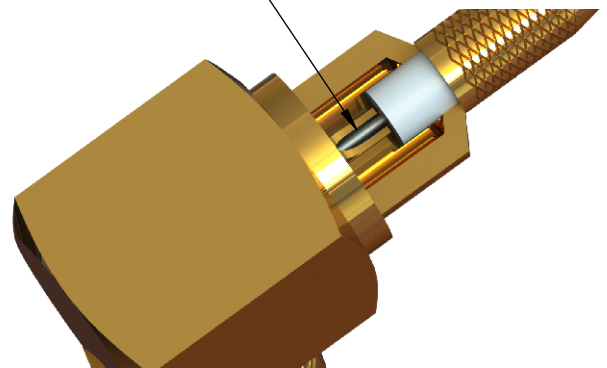


4. Flare the cable Braid as shown.



5. Slide the Knurled area of the Connector body onto the Cable Dielectric, but under the braid. Ensure centre conductor fully emerges undamaged, and is centred in the solder bucket of the Centre Contact.
6. Carefully heat the Centre Contact and Conductor using the appropriate tool, so that the solder melts, adding additional as required. Care should be taken not to overheat the contact to avoid damaging the Insulator or cable dielectric. Allow to cool and inspect joint.

Add more solder here as required

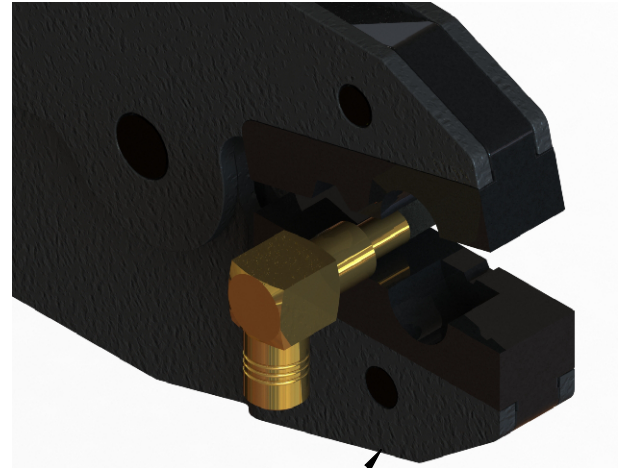


Note: Care should be taken as excessive amounts of Solder around this joint can lead to a short circuit against the Connector Body sides or Crimp Sleeve.

<b>A4</b>	<b>SHEET 1 OF 2</b>	<b>DIMENSIONS ARE IN MILLIMETRES</b>		
<b>REVISION :</b>	<b>A00</b>	<b>NAME</b>	<b>SIGNATURE</b>	<b>DATE</b>
<b>ISSUE :</b>	<b>1</b>	<b>DRAWN</b>	GE	01/12/2014
		<b>CHK'D</b>	IG	01/12/2014
		<b>APPV'D</b>		
<b>6-8 COLNE ROAD, TWICKENHAM, MIDDLESEX. TW1 4JR</b>				
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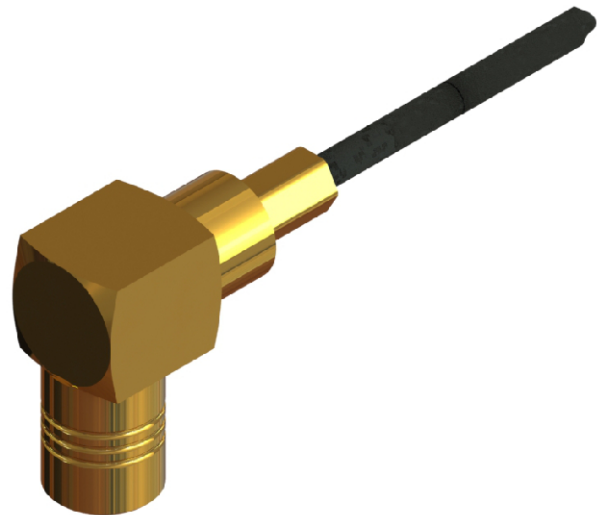
# ASSEMBLY PROCEDURE : AP040

7. Slide the Crimp Sleeve forward over the Braid and knurled area of the connector up to the main connector body. The large diameter of the Crimp Sleeve covering over the solder area.
1. Crimp the Crimp Sleeve using the appropriate sized crimp tool given on the connectors datasheet.




Crimp Tool

2. Carefully check the assembly.



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<b>A4</b>	<b>SHEET 2 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
<b>REVISION :</b>	<b>A00</b>	<b>NAME</b>	<b>SIGNATURE</b>	<b>DATE</b>	
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