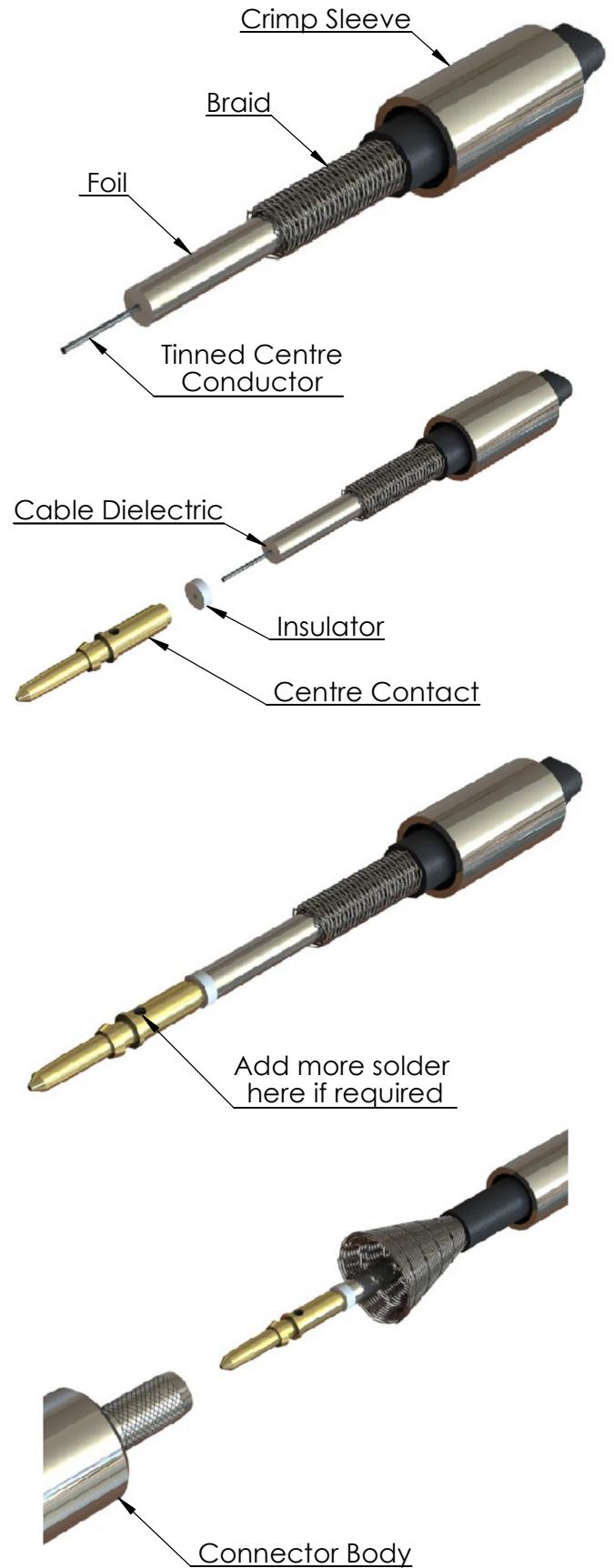



ASSEMBLY PROCEDURE : AP014

1. Slide the crimp sleeve onto the cable.
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.
4. Slide Insulator onto cable centre conductor up to cable dielectric. Ensure centre contact fully emerges undamaged from the end of the Insulator.
5. Slide the centre contact onto the cable conductor up to Insulator.
6. Ensure that the conductor is visible through the contact's inspection hole.
7. Carefully heat the Centre Contact 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.
8. Slide the cable into the connector and push home until the centre contact "CLICKS" into place in the connectors dielectric. Ensure all the braid strands pass outside over the knurled area of the connector.



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A4	SHEET 1 OF 2		DIMENSIONS ARE IN MILLIMETERS		
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ASSEMBLY PROCEDURE : AP014


9. Slide the crimp sleeve forward over the braid and knurled area of the connector to the rear of the connector body.
10. Crimp the crimp sleeve using the appropriate sized crimp tool given on the connectors datasheet (trim excess braid if necessary)



11. Carefully check the assembly.



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