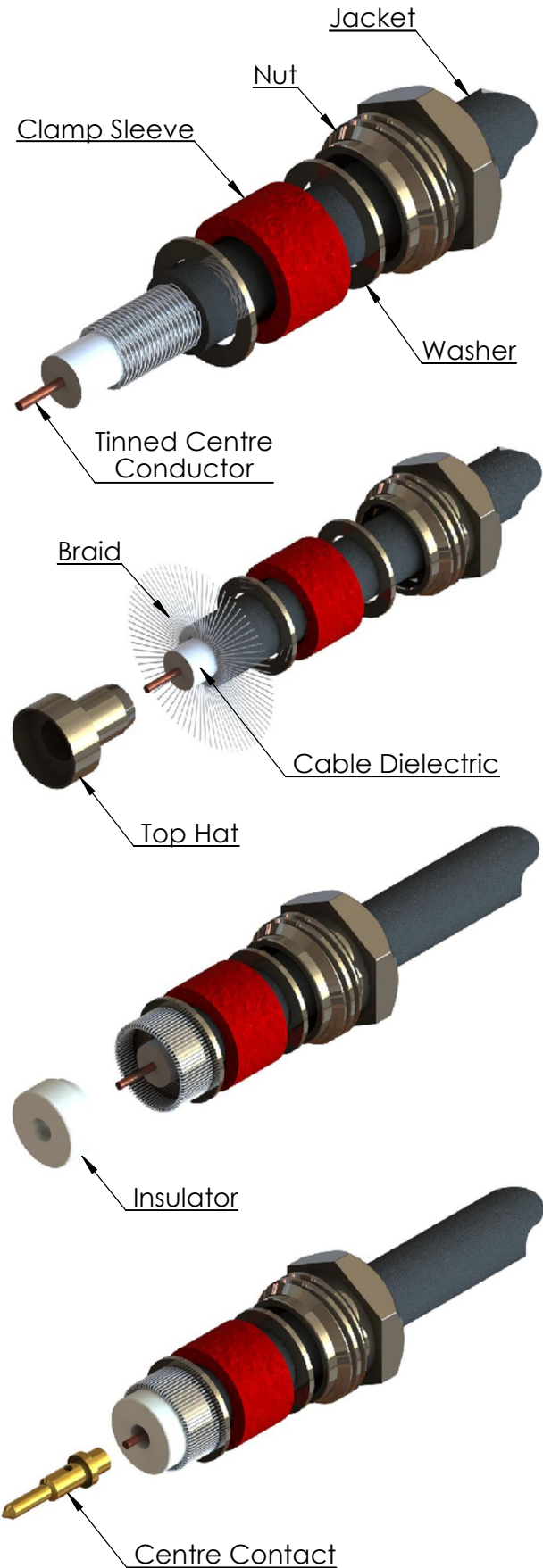


ASSEMBLY PROCEDURE : AP010

- Slide the Nut, Washer, Clamp Sleeve and Washer onto the cable.
- Strip the cable to the dimensions given on the connectors datasheet. If the cable has a foil screen please check the datasheet for the stripping length of this screen.
- Check to ensure the cables centre conductor is undamaged. Then using an appropriate solder, carefully Tin the centre conductor.
- With the braid fanned out evenly, place the smaller tapered end of the Top Hat contact over cable dielectric. Push the Top Hat contact firmly home up to the cable jacket. While doing this you must ensure that the smaller diameter with the tapered end of the Top Hat contact has successfully passed between the cable dielectric and braid of the cable.
- Wrap the fanned out Braid forward evenly over the large diameter and then inside the counter bore of the Top Hat contact. Now carefully place the connectors Small Insulator over the cables Centre contact and dielectric, feeding it inside counter bore of Top Hat Contact, thus trapping and securing the braid. Note the correct orientation of the Insulator.
- Place the Centre Contact in position over the tinned centre conductor, checking that the centre conductor is visible in the inspection hole in Centre Contact. 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.

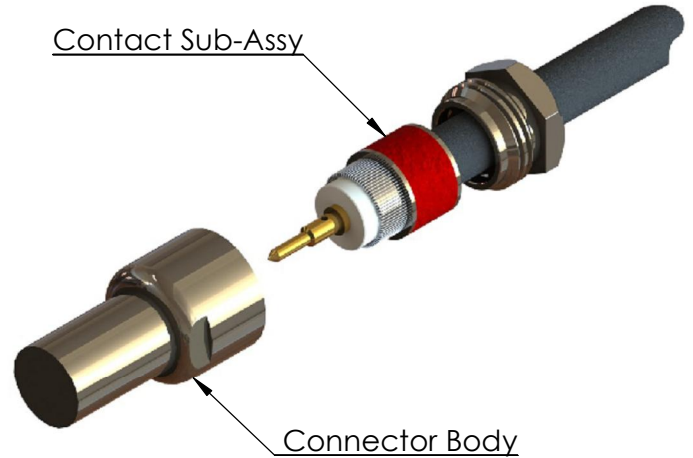


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A4	SHEET 1 OF 2		DIMENSIONS ARE IN MILLIMETERS		
REVISION :	A00	NAME	SIGNATURE	DATE	
ISSUE :	2	DRAWN	GE		04/01/2011
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ASSEMBLY PROCEDURE : AP010


- Carefully place Contact sub-assembly into Connector body, checking that the Centre contact is correctly place in the Connectors front insulator. Carefully slide the Washers and Clamp sleeve forward up to the Top Hat Contact. Then carefully slide the Nut forward and engage the thread. Using a suitable spanner to hold the Connector body, carefully tighten the Nut to the recommended torque given on the connectors datasheet. Thus clamping the cable in place.



- Carefully check the assembly.



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