

# ASSEMBLY PROCEDURE : AP027

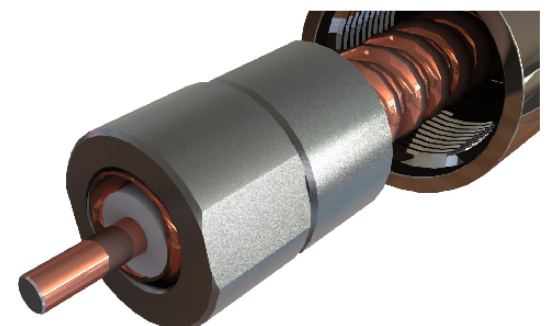
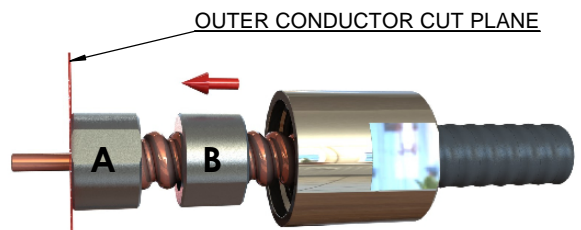
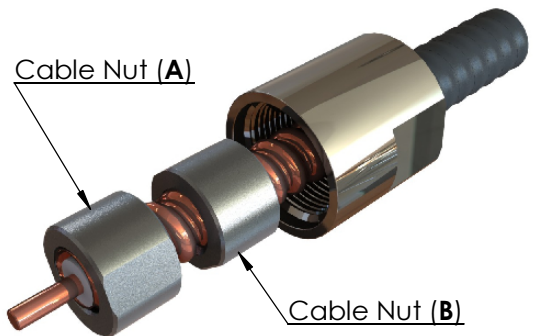
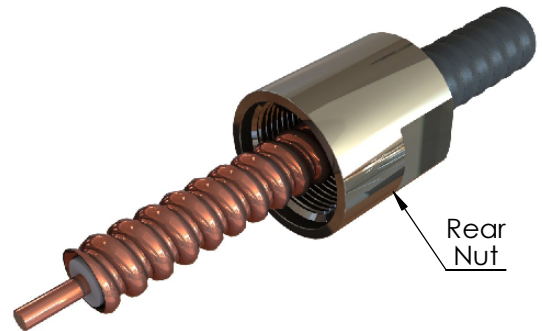
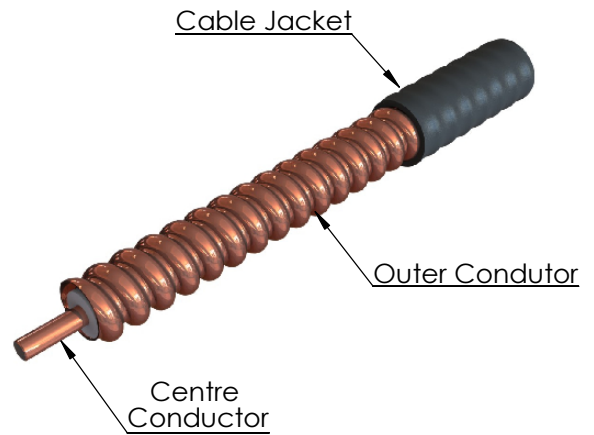
1. Trim the cable to the dimensions given on the connectors datasheet, ensuring the conductors are not damaged. Deburr the centre & outer conductor, removing all metal particles. It is important that the cuts are perpendicular to the axis of the cable. This can be done using a cable nut as a guide, however for RFS SCF14-50J cable, RFS Stripping tool TRIM-14-S is the preferred option. When using the tool it is important to remove **all** the cable jacket up to the final cut made by the tool, and that the centre conductor is deburred.

2. Slide the heatshrink supplied over the cable jacket for use later.


3. Place the rear nut over the outer conductor as shown and rest it up against the cable jacket.

4. Screw the cable nuts onto the cable. Align the end of nut "A" flush with the outer conductors' cut plane, as shown in the diagram. Without moving the position of cable nut "A" carefully screw cable nut "B" back until it butts up against it. Carefully tighten nut "B" against nut "A" using appropriate tooling, thereby firmly locking both the cable nuts onto the cable.

5. Check the assembly, making sure the end of the cable nut "A" and outer conductor are still flush as shown, and that the nuts are firmly locked onto the cable.

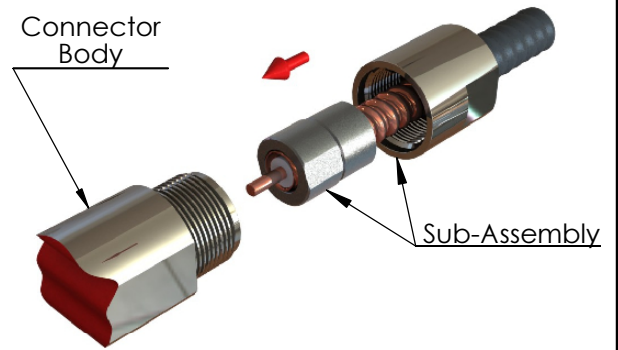


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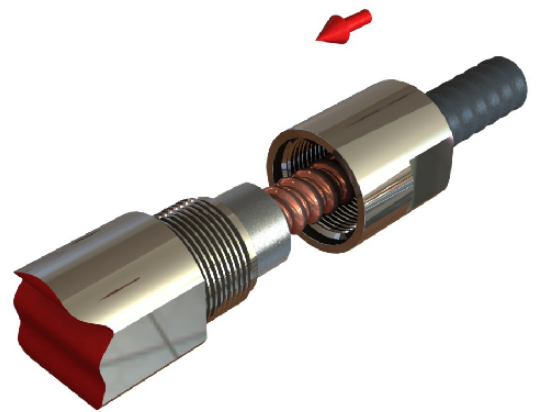
<b>A4</b>	<b>SHEET 1 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
<b>REVISION :</b>	<b>A00</b>	<b>NAME</b>	<b>SIGNATURE</b>	<b>DATE</b>	
<b>ISSUE :</b>	<b>1</b>	<b>DRAWN</b>	GE		31/01/2012
		<b>CHK'D</b>	PS		31/01/2012
		<b>APPV'D</b>			
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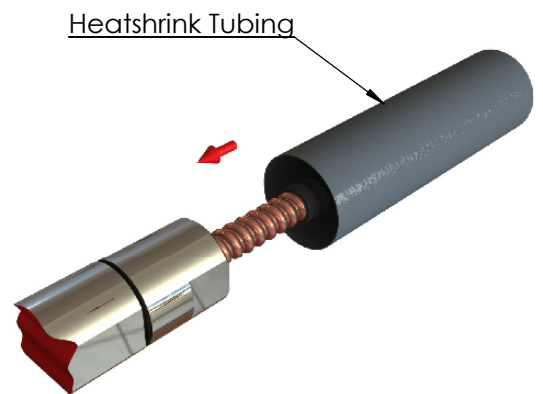
6. Offer the sub-assembly up to the appropriate end of the connector body, without altering the position of the cable nuts on the cable. Locate the centre conductor into the centre contact inside the connector body and firmly push the assembly into the body.



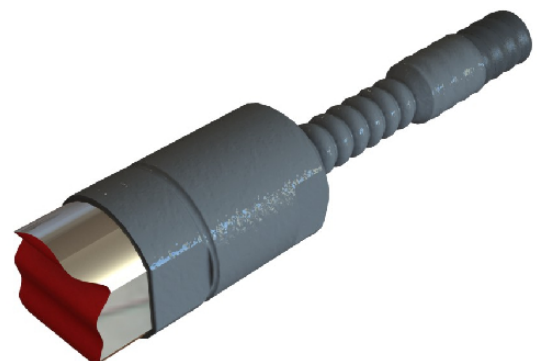
7. Now bring the rear nut forward and engage the thread onto the connector body, and carefully tighten. There should be a small gap of 1mm between the nut & body.




8. Carefully check the assembly. Clean the cable jacket and outer conductor over the area the heatshrink is to fit. Slide the heatshrink sleeve forward over the assembly, ensuring the gap between body & nut is covered.



9. Carefully apply heat from a suitable source to the heatshrink sleeving. Once Shrinking completed, allow the assembly to completely cool before it is touched or subjected to any mechanical load. Check the finished assembly for damage or loose parts.



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<b>A4</b>	<b>SHEET 2 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
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