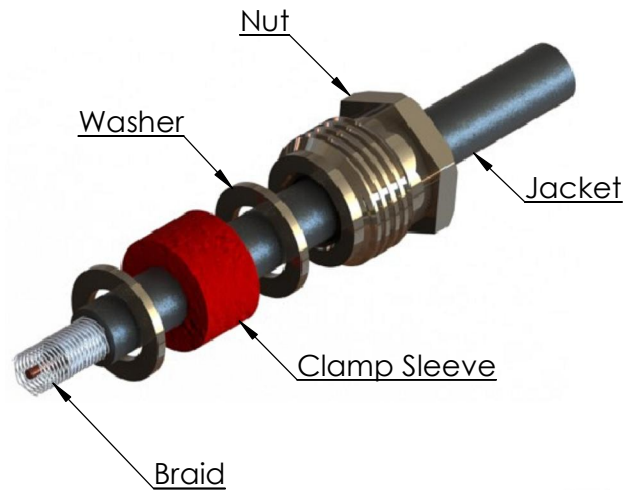
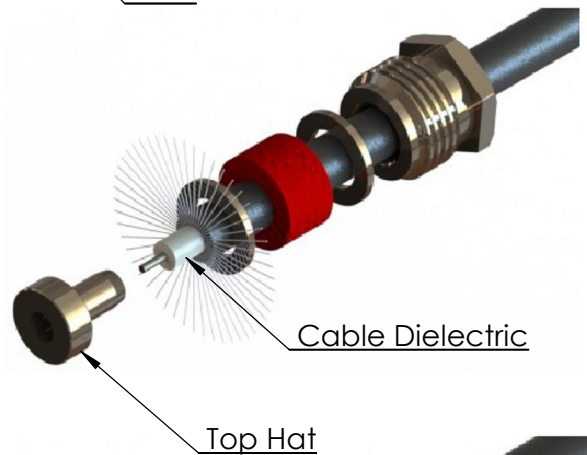


# ASSEMBLY PROCEDURE : AP015

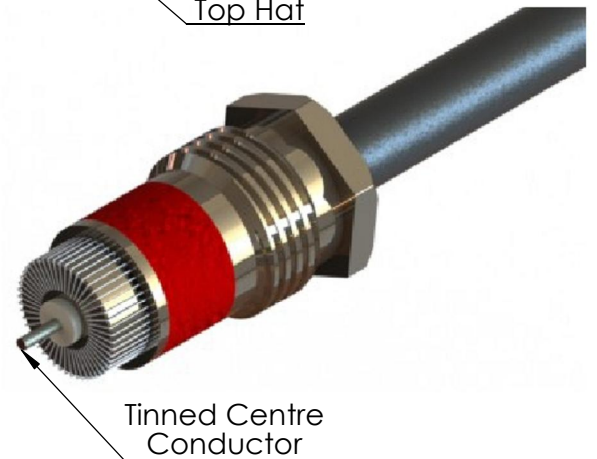
1. Slide the Nut, Washers and Clamp Sleeve onto the cable.
2. Strip the cable to the dimensions given on the connectors datasheet. If the cable has a foil screen please check the datasheet for the stripping length of this screen.



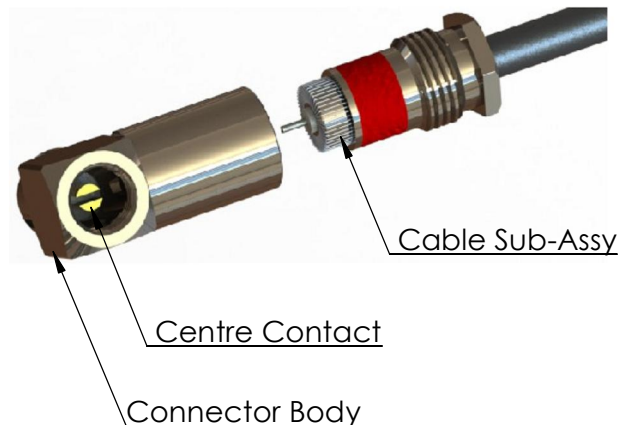
3. With the braid fanned out evenly, place the smaller tapered end of the Top Hat contact over cable dielectric. Push the Top Hat contact firmly home up to the cable jacket. While doing this you must ensure that the smaller diameter with the tapered end of the Top Hat contact has successfully passed between the cable dielectric and braid of the cable.




4. Wrap the fanned out Braid forward evenly over the large diameter and then around the front of the Top Hat contact.
5. Check to ensure the cables centre conductor is undamaged. Then using an appropriate solder, carefully Tin the centre conductor.



6. Check and correct if necessary the orientation of the slot in the Centre Contact in the Connector body. Using an appropriate solder, carefully Tin the slot in the Centre Contact .

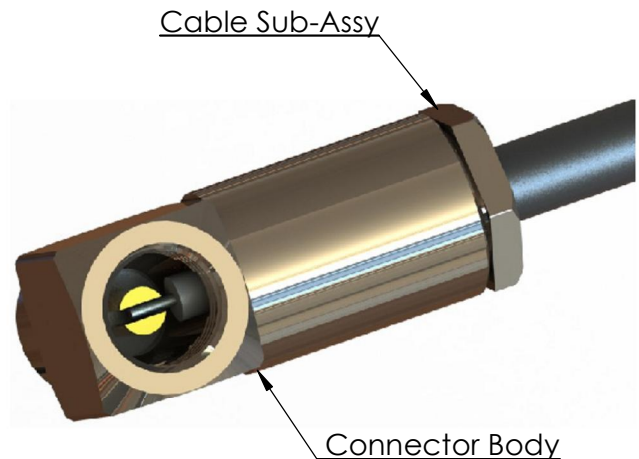


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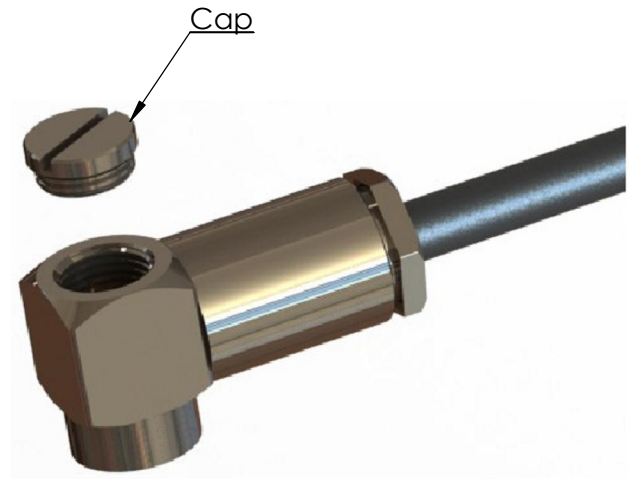
<b>A4</b>	<b>SHEET 1 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETERS</b>		
<b>REVISION :</b>	<b>A00</b>	<b>NAME</b>	<b>SIGNATURE</b>	<b>DATE</b>	
<b>ISSUE :</b>	<b>1</b>	<b>DRAWN</b>	GE		04/01/2011
		<b>CHK'D</b>	IG		05/01/2011
		<b>APPV'D</b>			
<p><b>6-8 COLNE ROAD, TWICKENHAM, MIDDLESEX. TW1 4JR</b></p> <p>THE INFORMATION IS GIVEN AS AN INDICATION ONLY AND IS SUBJECT TO CHANGE WITHOUT NOTICE. IN THE CONTINUAL GOAL TO IMPROVE OUR PRODUCTS, WE RESERVE THE RIGHT TO MAKE ANY MODIFICATIONS NECESSARY WITHOUT PRIOR NOTICE.</p>					

# ASSEMBLY PROCEDURE : AP015

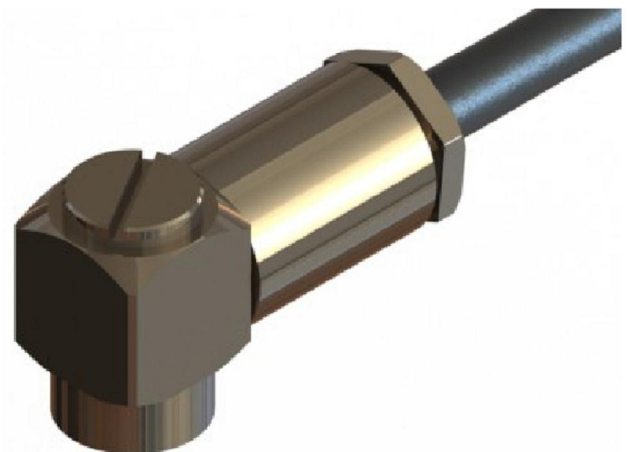
- Carefully place Cable sub-assembly into the Connector body, checking that the tinned Centre conductor is correctly placed in the slot of the Centre Contact. Carefully slide the Washer and Clamp sleeve forward up to the Top Hat Contact. Then carefully slide the second washer and Nut forward and engage 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.




- Checking the Centre Conductor is still in position in the slot of the tinned centre conductor, 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. Screw Cap in place and tighten.



- Carefully check the assembly.



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