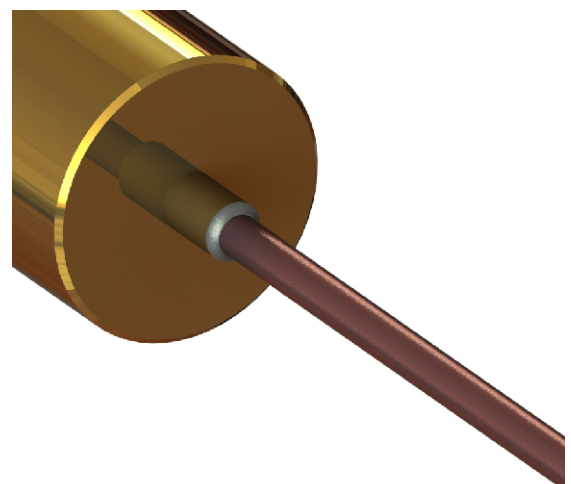
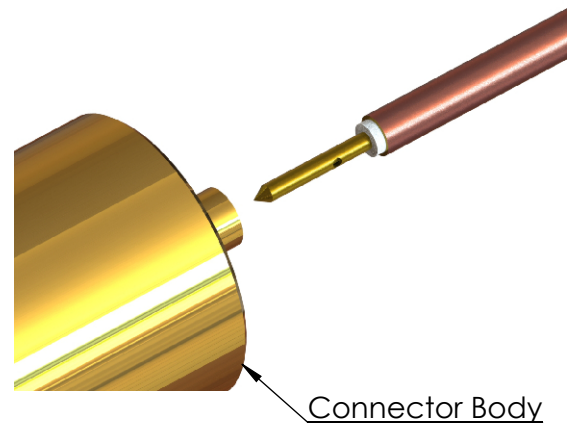
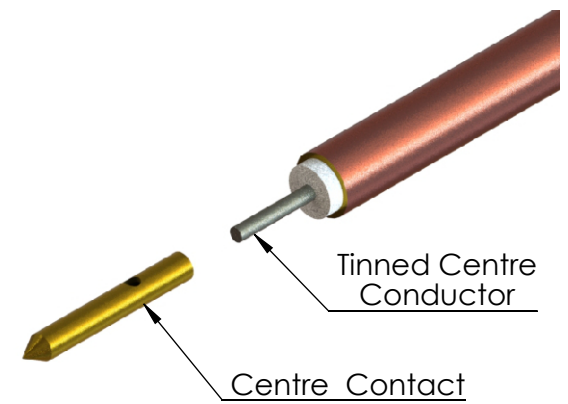
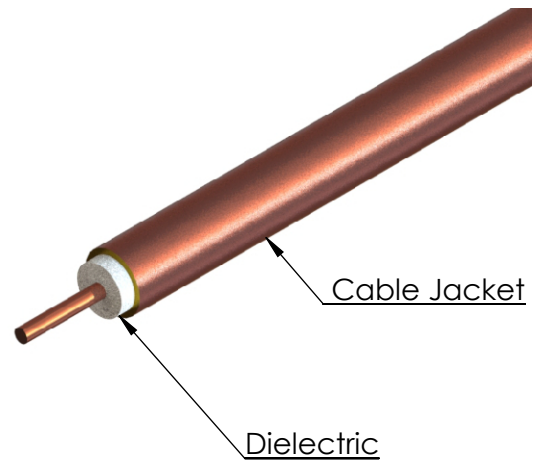



# ASSEMBLY PROCEDURE : AP033

1. Strip the cable to the dimensions given on the connectors datasheet.
2. Check to ensure the cables centre conductor is undamaged. Then using an appropriate solder, carefully Tin the centre conductor.
3. Slide the centre contact onto the Tinned cable conductor up to cable dielectric.
4. Ensure that the conductor is visible through the contact's inspection hole.
5. Carefully heat the Centre Contact using the appropriate tool, so that the solder melts, adding appropriate solder as required. Care should be taken not to overheat the contact to avoid damaging the cable dielectric. Allow to cool, clean solder and inspect the joint.
6. Clean the end of the cable jacket and introduce the centre contact/cable assembly into the connector body until the centre contact locates into the connector bodies insulator, if present. Then push home fully.
7. Using the appropriate tool, solder the cable jacket to the body producing a fillet as shown. Note: Resistance soldering is recommended for this operation. Care should be taken not to overheat the cable or the connector body to avoid damaging the Insulator or cable dielectric. Allow to cool, clean solder and inspect joint and assembly.



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<b>A4</b>	SHEET 1 OF 1		DIMENSIONS ARE IN MILLIMETRES		
REVISION :	A00	NAME	SIGNATURE	DATE	
ISSUE :	1	DRAWN	GE		07/05/2013
		CHK'D	PS		07/05/2013
		APPV'D			
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