

# ASSEMBLY PROCEDURE : AP016

1. Slide the Nut, Washer and Gasket onto the cable. Note the Groove in the gasket should face away from the Nut with the plain face towards the Washer.

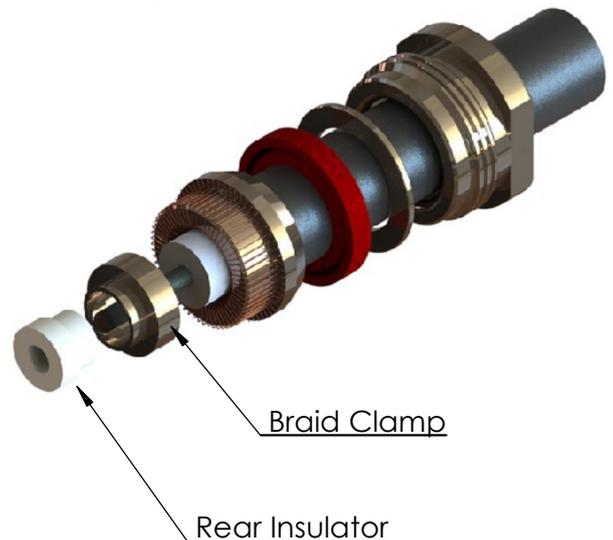
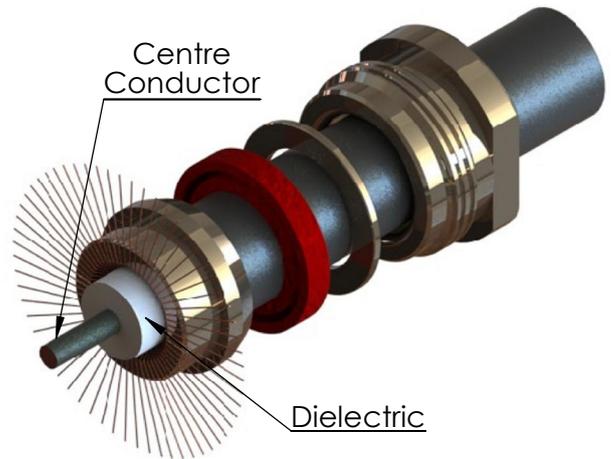
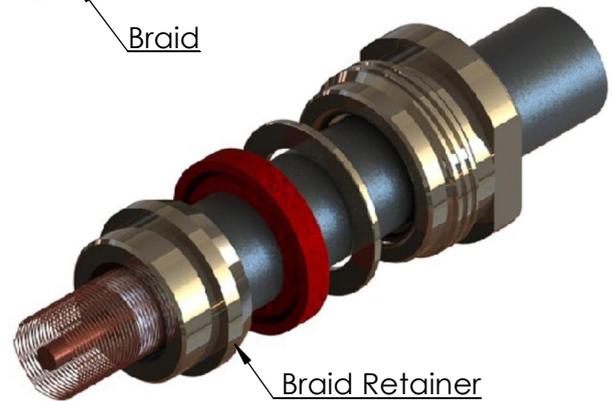
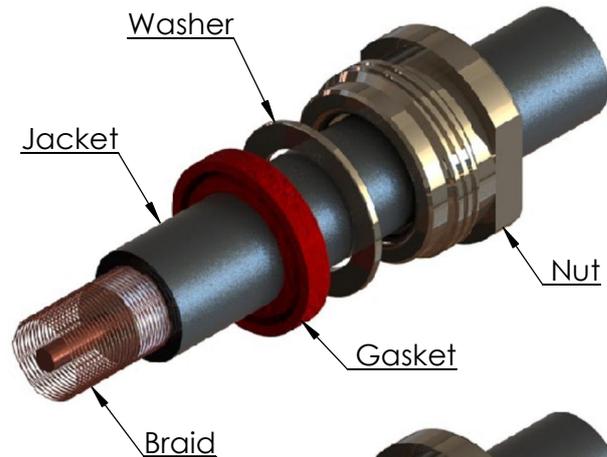
2. Strip the cable to the dimensions given on the connector's datasheet. If the cable has a foil screen please check the datasheet for the stripping length of this screen.

3. Making sure it is orientated as shown, slide the Braid Retainer over the braid until it stops against the Cable Jacket.

4. Carefully fan out the Braid back over the front of the Braid Retainer.

5. Check to ensure the cable's centre conductor is undamaged. Then using an appropriate solder, carefully Tin the Centre Conductor.

6. Noting orientation, carefully slide Braid Clamp over the cables Dielectric, until it stops against the cable Braid and Braid Retainer. Then Slide the Rear Insulator Over the Tinned Centre Conductor, so that the smaller diameter passes inside the Braid Clamp and stops against the Braid Clamp.

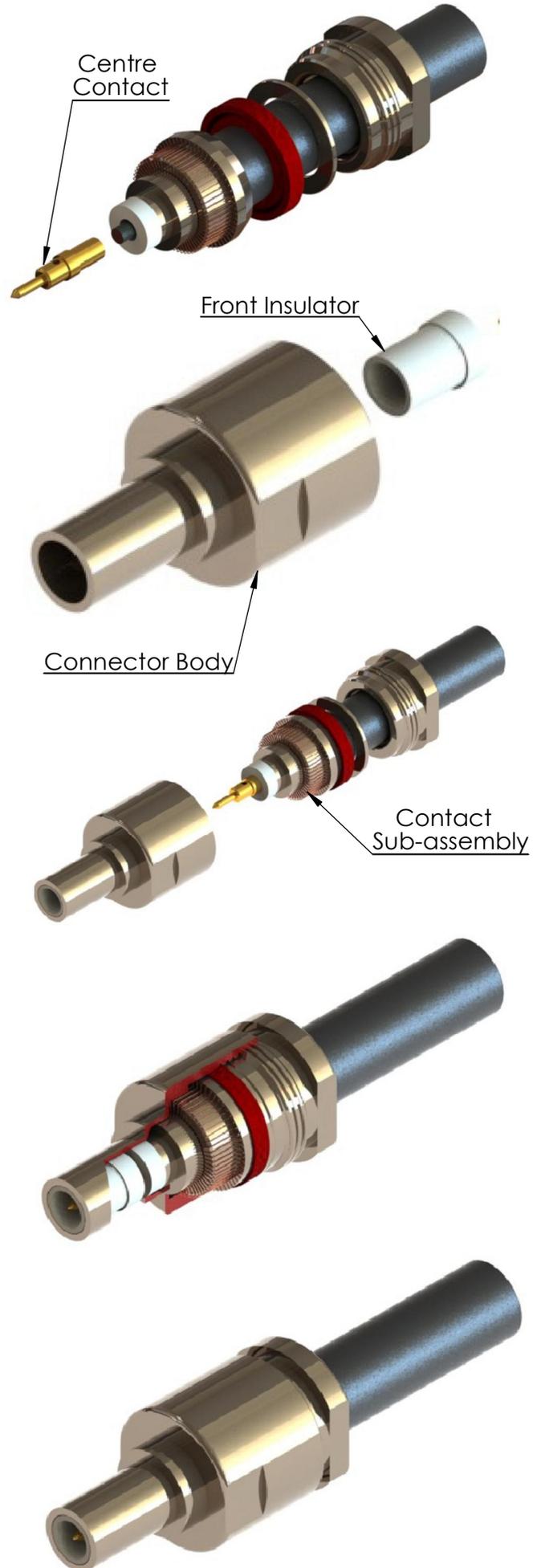


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<b>A4</b>	<b>SHEET 1 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
<b>REVISION :</b>	<b>A00</b>	<b>NAME</b>	<b>SIGNATURE</b>	<b>DATE</b>	
<b>ISSUE :</b>	<b>2</b>	<b>DRAWN</b>	GE		02/08/2011
		<b>CHK'D</b>	IG		02/08/2011
		<b>APPV'D</b>			
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7. Slide the centre contact onto the Tinned cable conductor up to cable dielectric.
8. Ensure that the conductor is visible through the contact's inspection hole.
9. Carefully heat the Centre Contact using the appropriate tool, so that the solder melts, adding additional as required through hole in contact. Care should be taken not to overheat the contact to avoid damaging the Sleeve or cable dielectric. Allow to cool and inspect joint.
10. Check to ensure Front insulator is correctly inserted into the Connector body
11. Place Contact sub-assembly into Connector body, checking that the Centre contact is correctly placed in the Front insulator. Carefully slide the Gasket forward up to the Braid Retainer. Then carefully slide the 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.
12. Check the assembly.



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