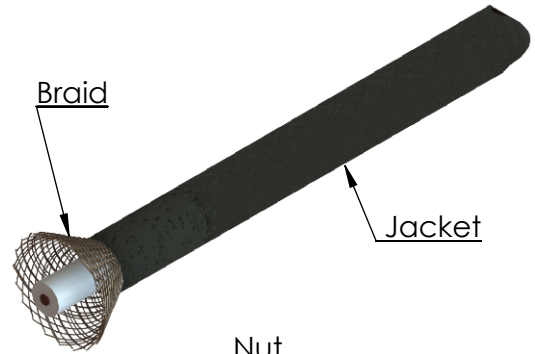
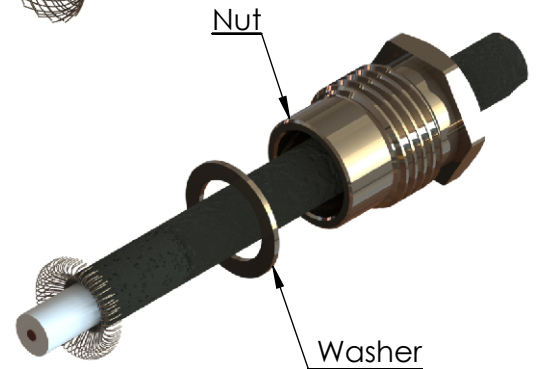


# ASSEMBLY PROCEDURE : AP039

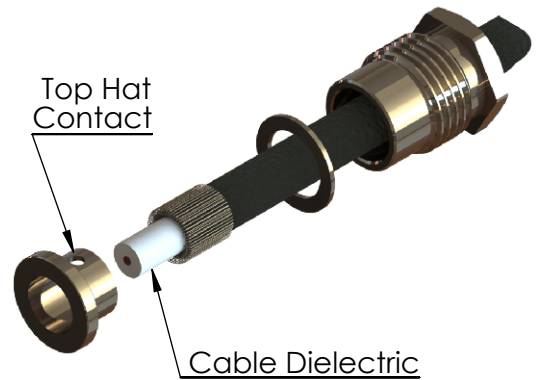
1. Strip the cable jacket to the dimensions given on the connector's datasheet.



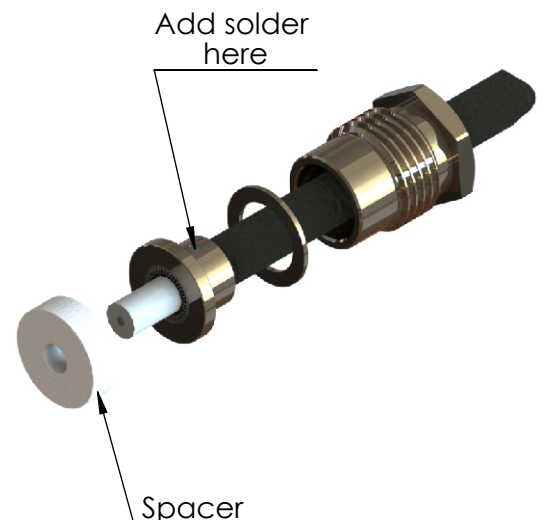
2. Slide the nut and washer onto the cable. With the braid wires fanned out evenly, fold them back over the cables jacket ensuring an even coverage.




3. With care, slide the Top Hat contact, small diameter first, over the braid covered jacket until the larger diameter's end face is level with the trimmed jacket.



4. Using the appropriate tool, solder the Top Hat contact to the braid covering the jacket, adding appropriate solder through the small hole in the contact as required. Care should be taken not to overheat the cable or the Top Hat contact to avoid damaging the cable jacket or dielectric. Allow to cool, clean solder and inspect joint and assembly.

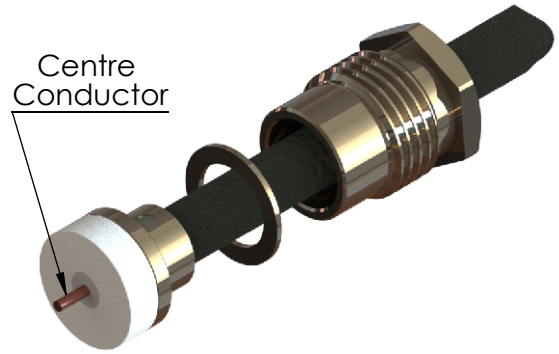


5. Slide the spacer provided over the cable dielectric and up to the Top Hat contact.

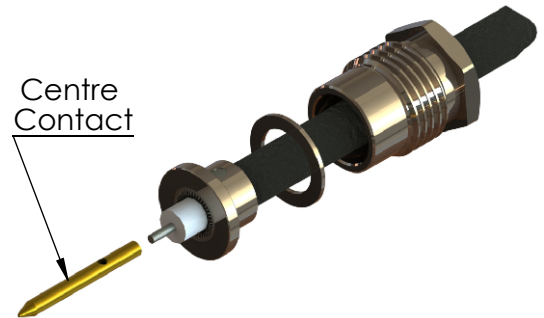
<b>A4</b>	<b>SHEET 1 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
<b>REVISION :</b>	<b>A00</b>	<b>DRAWN</b>	GE		20/02/2014
<b>ISSUE :</b>	<b>2</b>	<b>CHK'D</b>	PS		20/02/2014
<b>6-8 COLNE ROAD, TWICKENHAM, MIDDLESEX. TW1 4JR</b>		<b>APPV'D</b>			
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# ASSEMBLY PROCEDURE : AP039

6. Taking care not to damage the centre conductor, trim the cables dielectric level with the face of the Spacer, thus revealing the centre conductor. Remove Spacer

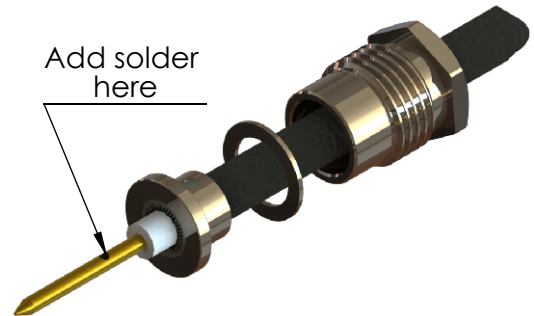


7. Check to ensure the conductor is undamaged. Then using an appropriate solder, carefully Tin the conductor. Once cooled, slide the centre contact onto the tinned conductor.



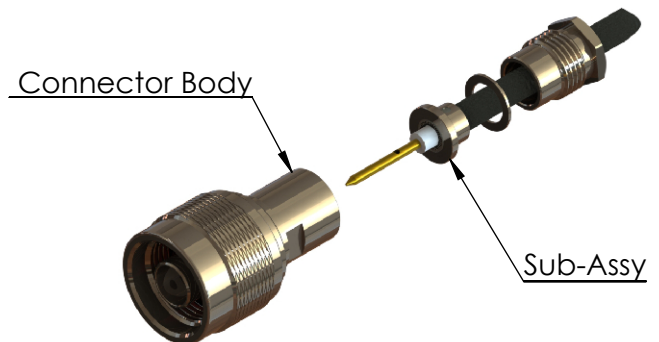
8. Ensure that the conductor is visible through the contact's inspection hole.

9. Carefully heat the Centre contact using the appropriate tool, so that the solder melts, adding appropriate solder through the hole in the contact as required. Care should be taken not to overheat the contact to avoid damaging the cable dielectric.

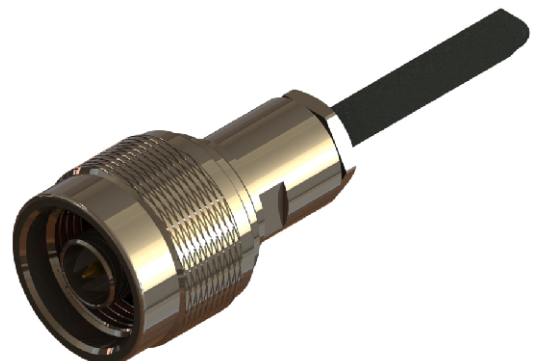


10. Allow to cool. Once cooled, clean any residue solder and inspect the joint.

11. Place sub-assembly into Connector body, engaging centre contact into the connector's dielectric. Then gently push the sub-assembly into the connector body, until the Top Hat Contact is up against the ledge inside the Connector Body. Then slide the washer and nut forward and engage the thread. Using a suitable spanner to hold the Connector body, tighten the nut. Thus clamping the cable in place.



12. Check the assembly, paying attention for any damaged or loose components. Also check that the centre contact is central in the Connector Body.



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<b>A4</b>	<b>SHEET 2 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		20/02/2014
		<b>CHK'D</b>	PS		20/02/2014
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