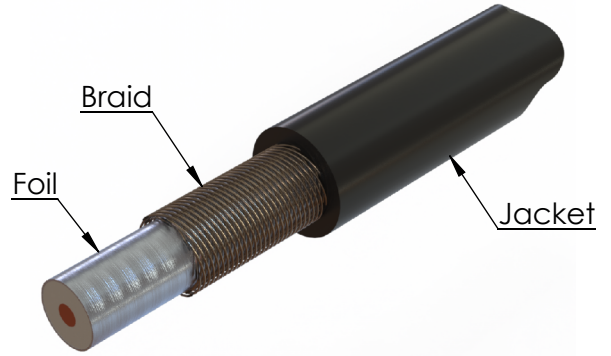
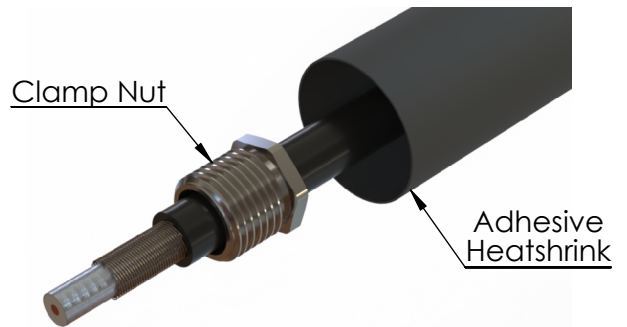


# ASSEMBLY PROCEDURE : AP053

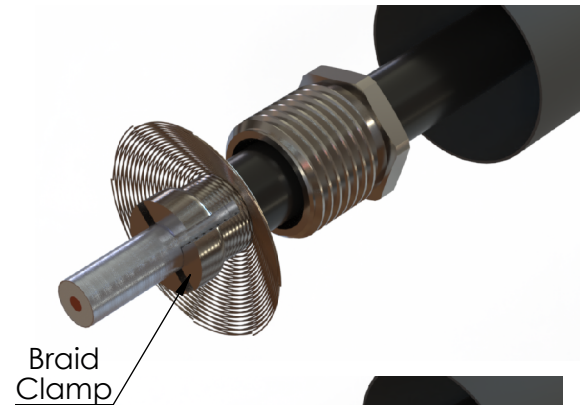
1. Strip the Cable Jacket and braid to the dimensions given within the connectors datasheet.



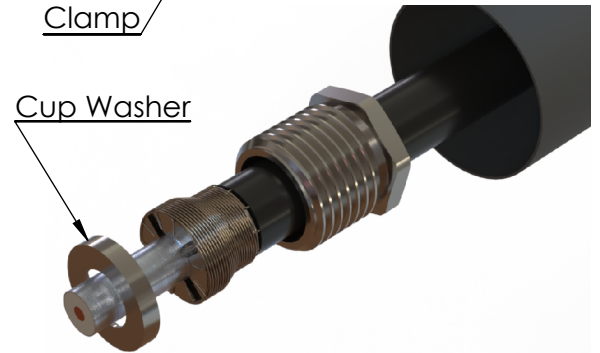
2. Slide the Clamp Nut and Adhesive Heatshrink (not supplied) onto the cable as shown.



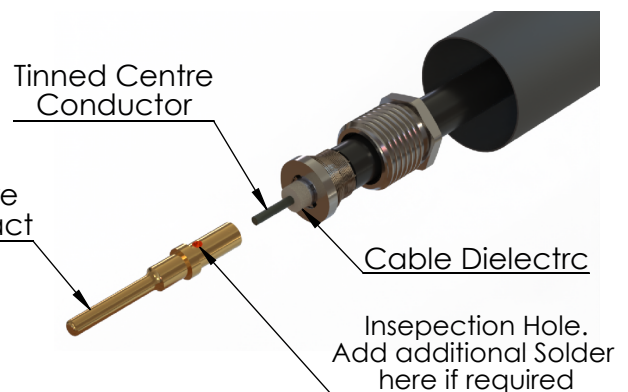
3. Evenly fan out the Braid. Place the Braid Clamp over the Foil trapping the Braid up against the Jacket, with the slots in the Braid Clamp facing away from the Jacket.



4. Bring the Braid forward, carefully wrapping it evenly over the Braid Clamp. Slide the Cup Washer over the Foil & up to the Braid & Braid Clamp, with the recessed side towards the Braid Clamp, thus trapping the Braid.



5. Strip the cable to the dimensions given on the connectors datasheet. Strip the Foil up to the Cup Washer exposing the Cables Dielectric. Check to ensure the cables Centre Conductor is undamaged. Using an appropriate solder, carefully Tin the Centre Conductor. Slide the Centre Contact onto the Tinned Cable Conductor up to Cable Dielectric. Ensure that the conductor is visible through the contact's inspection hole. 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 Cable Dielectric. Allow to cool and inspect joint.

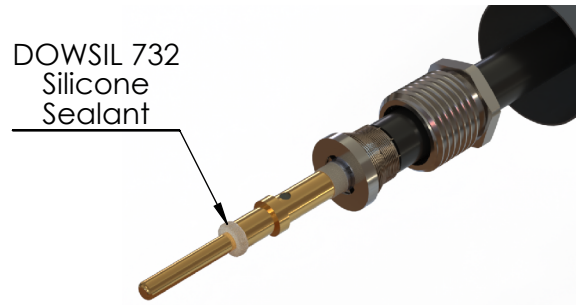


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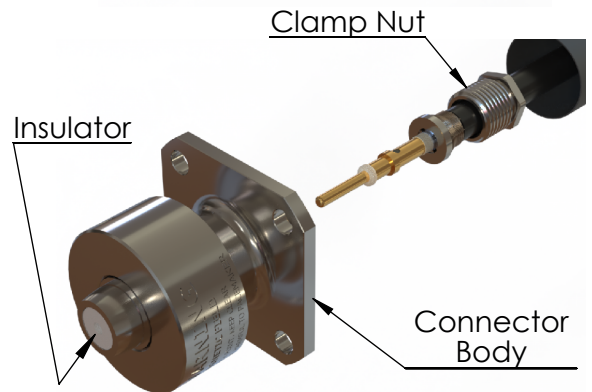
<b>A4</b>	<b>SHEET 1 OF 3</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
<b>REVISION :</b>	<b>A00</b>	<b>NAME</b>	<b>SIGNATURE</b>	<b>DATE</b>	
<b>ISSUE :</b>	<b>1</b>	<b>DRAWN</b>	G.E.		06/01/2025
		<b>CHK'D</b>	P.S.		06/01/2025
		<b>APPV'D</b>			
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# ASSEMBLY PROCEDURE : AP053

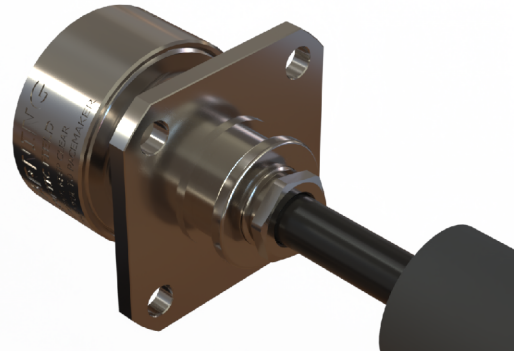
6. Apply a bead of Dow DOWSIL 732 Silicone sealant to the base of the Centre Contact, as shown so the cavity at the shoulder in the insulator will be fully filled when the Centre Contact is inserted.



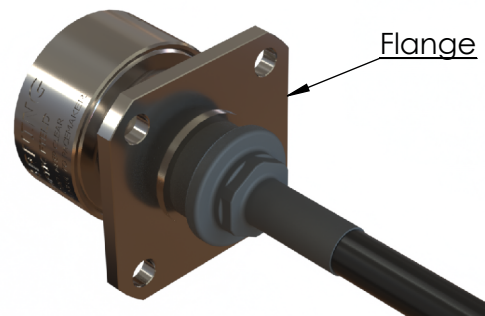
7. Place Contact sub-assembly into Connector body, checking that the Centre Contact is correctly placed in the Insulator.



8. Carefully slide the Clamp Nut forward up to the Braid Clamp and engage the thread. Using a suitable spanner, carefully tighten the Clamp Nut. Thus clamping the cable in place. Check the assembly.

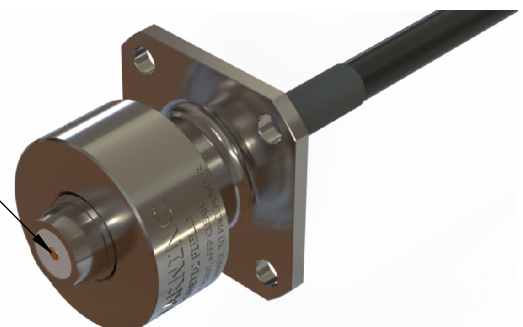



9. Slide the Heatshrink forward over the rear of the Connector Body up to the Flange. Carefully heat the Heatshrink using the appropriate tool. Care should be taken not to overheat the Connector Body and Cable to avoid damage. Allow to cool and inspect joint.



10. Check the front of the Centre Contact to ensure there is no Silicone Sealant on this area of the Contact.

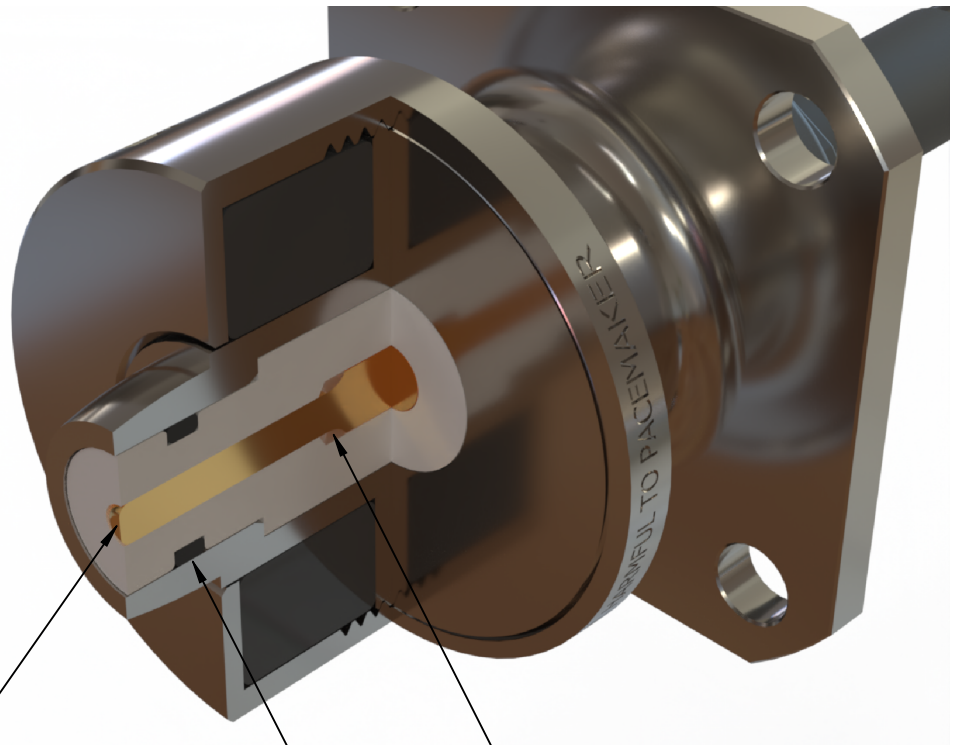
NO silicone permitted on this face.



<b>A4</b>	<b>SHEET 2 OF 3</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>	G.E.		06/01/2025
		<b>CHK'D</b>	P.S.		06/01/2025
		<b>APPV'D</b>			
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# ASSEMBLY PROCEDURE : AP053

## 11. Assembly Notes




Ensure the tip of the Centre Contact is Silicone free after assembly

Ensure this cavity is fully filled by DOW DOWSIL 732 Silicone sealant

O-Ring Pre-greased by manufacturer with RS494-124 or equivalent.

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<b>A4</b>	<b>SHEET 3 OF 3</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>	G.E.		06/01/2025
		<b>CHK'D</b>	P.S.		06/01/2025
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<b>6-8 COLNE ROAD, TWICKENHAM, MIDDLESEX. TW1 4JR</b>		<small>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.</small>			