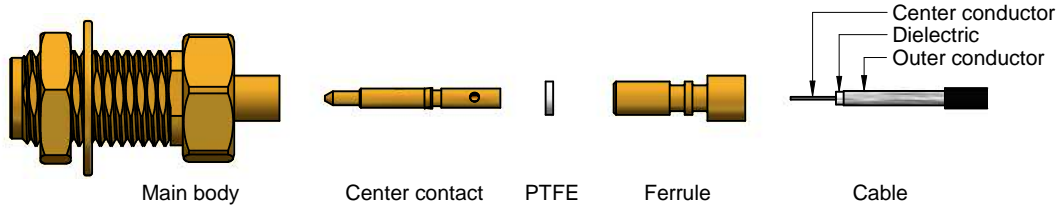
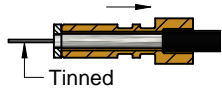


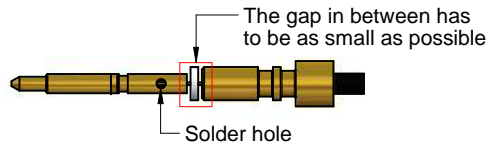
Step 1. Prepare connector components and strip coaxial cable according to given dimensions (check point 1)



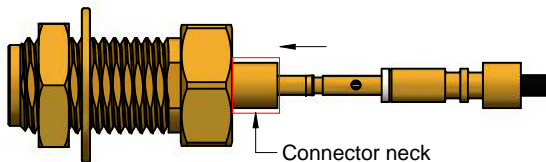
Step 2. Pre-tinned cable center conductor (optional, see check point 2)
Slide ferrule onto cable that will cover cable jacket, cable outer conductor and cable dielectric
Make sure PTFE sits on cable dielectric and locates in front of ferrule



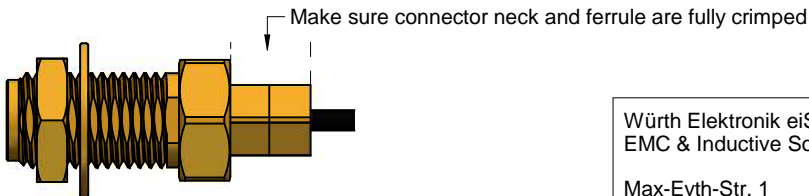
Step 3. Place center contact in front of PTFE
Solder cable center conductor using minimum amount of solder paste through solder hole (check point 3)



Step 4. Push cable with center contact into connector main body



Step 5. Crimp ferrule with tool hex size : .1" (check point 4)



Assembly Method :

Center contact : Soldered
Outer contact : Crimp

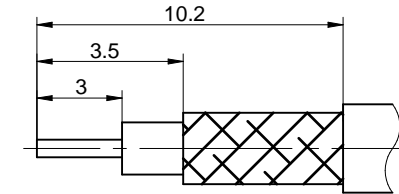
Crimp Tool PN : 600600

Crimp Head PN : 60060060101



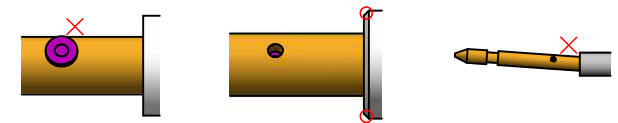
Cable Type : Flexible Cable 1.37

Cable Strip Dimensions (mm) :

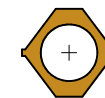


Check Point :

1. No damaged components; and no split cable after stripping
2. Assembly can be performed with or without tinned cable
The tinned cable center conductor can enhance the hardness of the cable center conductor and benefit solder process
3. No excess solder, melt dielectric, and misaligned center contact after assembling



4. No significant dog ear after crimping



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CREATED
BMa

CHECKED
JCh

DESCRIPTION

Assembly instructions

630 264 202 123 20

REVISION

STATUS

DATE

2021-01-25

BUSINESS UNIT

eiCan