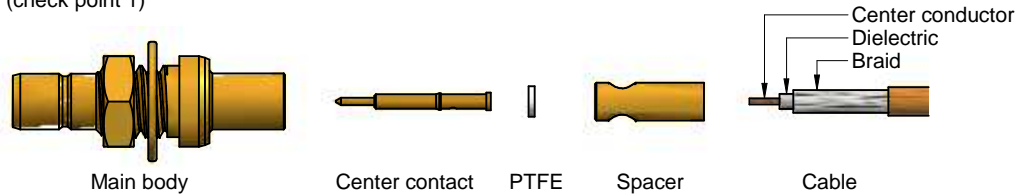


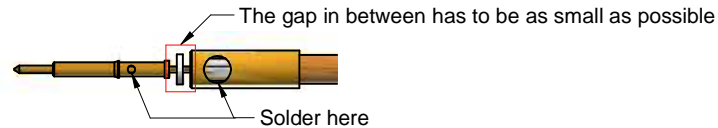
**Step 1.** Prepare connector components and strip coaxial cable according to given dimensions (check point 1)



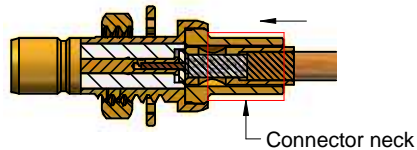
**Step 2.** Slide spacer onto cable until cable jacket meet spacer inner structure  
Place PTFE onto cable dielectric than push center contact onto cable center conductor



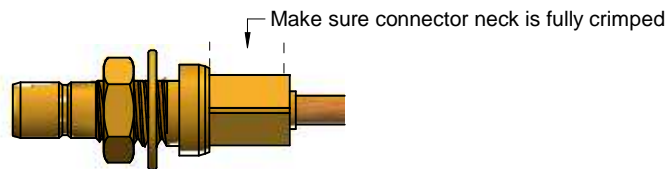
**Step 3.** Solder cable center conductor and cable braid using minimum amount of solder paste through solder hole on center contact and spacer (check point 2)



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



**Step 5.** Crimp connector neck with tool Hex size : .128" (check point 3)



**Assembly Method :**

Center contact : Soldered  
Outer contact : Crimp

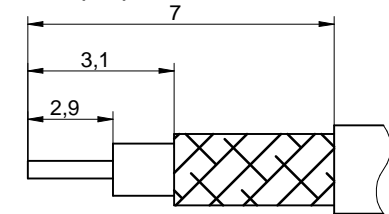
**Crimp Tool PN :** 600600

**Crimp Head PN :** 60060060101



**Cable Type :** Flexible Cable RG178/RG196

**Cable Strip Dimensions (mm) :**



**Check Point :**

1. No components damaged and no cable braid split after stripping
2. No excess solder, melt dielectric, and misaligned center contact after assembling



3. No significant dog ear after crimping



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CREATED  
BMa

CHECKED  
JCh

DESCRIPTION

**Assembly instructions**

**616 264 212 104 20**

REVISION

STATUS

DATE

2020-03-05

BUSINESS UNIT

eiCan