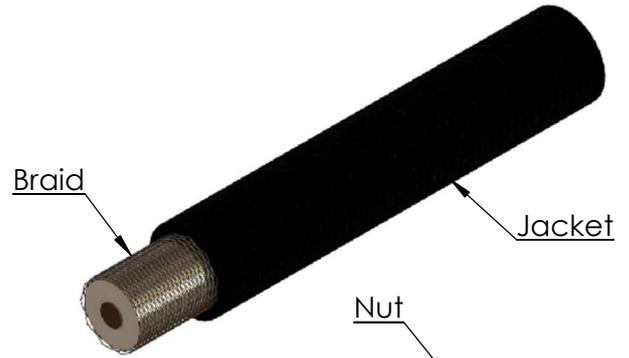
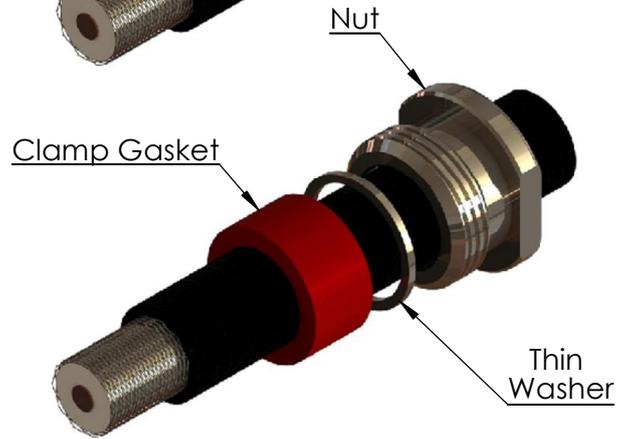


# ASSEMBLY PROCEDURE : AP018

1. Slide the Nut, Thin Washer and Clamp Gasket onto the cable.



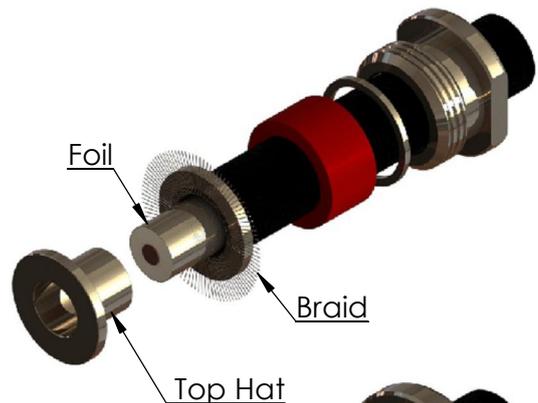
2. Strip the cable jacket to the dimensions given on the connectors datasheet.



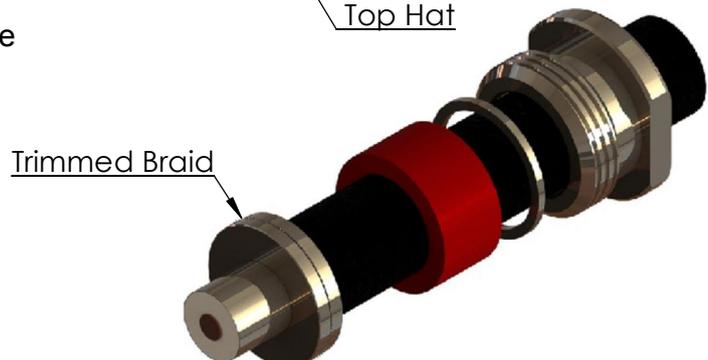
3. Slide the Thick Washer over the Braid up to the cable jacket and fan out the braid.



4. With the Braid fanned out evenly, place the smaller diameter end of the Top Hat contact over cable dielectric/foil. Push the Top Hat contact firmly home up to the Thick Washer, thereby clamping the Braid between the Large diameter of the Top Hat and the Thick Washer. When Pushing the Top Hat home you must ensure that the smaller diameter of the Top Hat contact has successfully passed between the cable dielectric/foil and braid of the cable.



5. Trim the Braid to same diameter as the Top Hat.

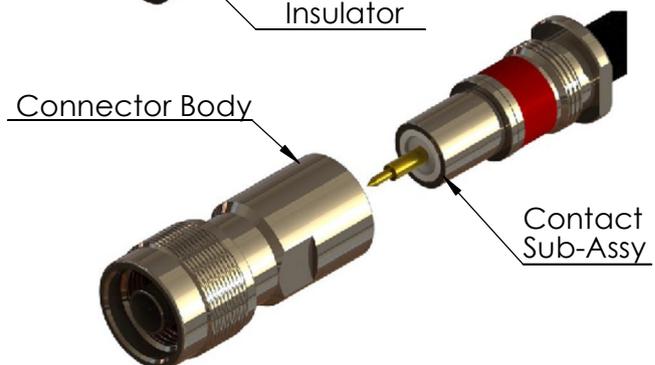
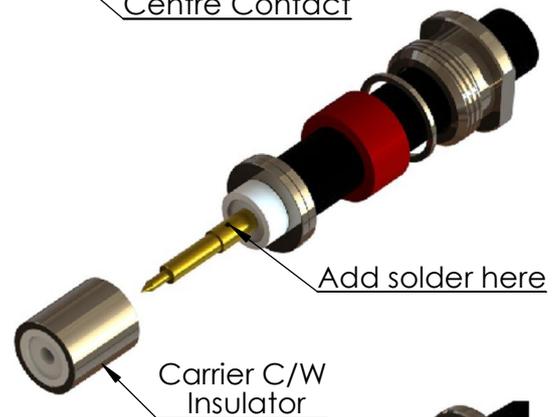
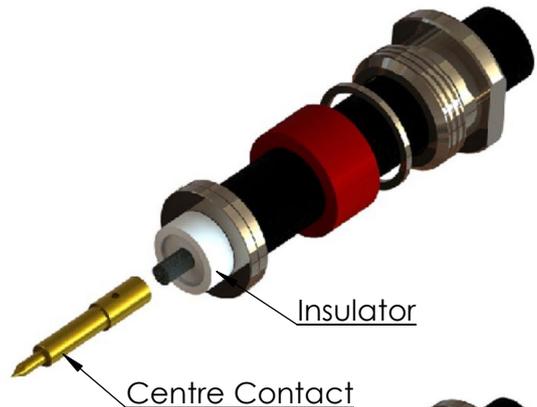


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<b>A4</b>	<b>SHEET 1 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
<b>REVISION :</b>	<b>A00</b>		<b>NAME</b>	<b>SIGNATURE</b>	<b>DATE</b>
<b>ISSUE :</b>	<b>2</b>	<b>DRAWN</b>	GE		10/10/2011
		<b>CHK'D</b>	PS		18/10/2011
		<b>APPV'D</b>			
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# ASSEMBLY PROCEDURE : AP018

6. Carefully trim the cable dielectric/foil level with the end of the Top Hat contact.
7. Check to ensure the cables centre conductor is undamaged, and trim to length given within Datasheet. Then using an appropriate solder, carefully Tin the centre conductor.
8. Place Insulator over tinned centre conductor up to surface of Top Hat.
9. Place the Centre Contact in position over the tinned centre conductor, tightly up against the Insulator and Top Hat. Check that the centre conductor is visible in the inspection hole in Centre Contact. Carefully heat the Centre Contact using the appropriate tool, so that the solder melts, adding additional as required through the inspection hole in the Centre Contact. Care should be taken not to overheat the contact to avoid damaging the Insulator or cable dielectric. Allow to cool and inspect joint.
10. Slide Carrier complete with second Insulator over Centre Contact. Ensure that the carrier is placed over the first Insulator and butts up to the Top Hat contact.
11. Slide the Clamp Gasket and Thin Washer forward up to the Top Hat Contact. Place Contact sub-assembly into Connector body, checking that the Carrier is correctly placed in the Connector Body. Then slide the Nut forward and engage the thread. Using a suitable spanner to hold the Connector body, tighten the Nut to the recommended torque given on the connectors datasheet. Thus clamping the cable in place.
12. Check the Assembly, paying particular attention to the correct position of the Centre Contact.



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<b>A4</b>	<b>SHEET 2 OF 2</b>		<b>DIMENSIONS ARE IN MILLIMETRES</b>		
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