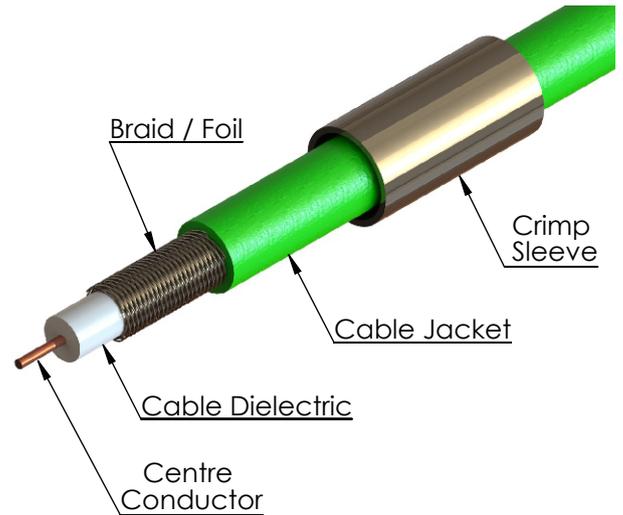
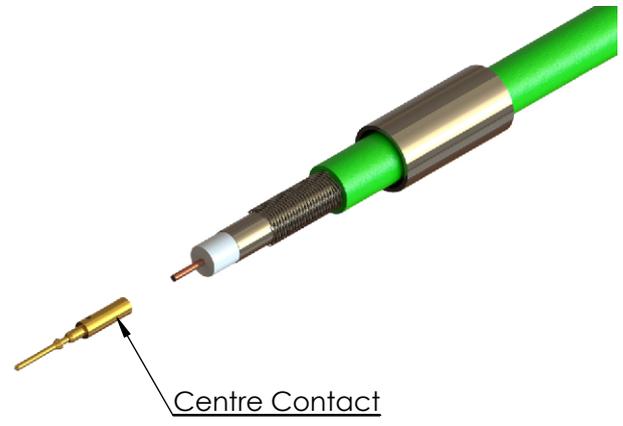


ASSEMBLY PROCEDURE : AP037

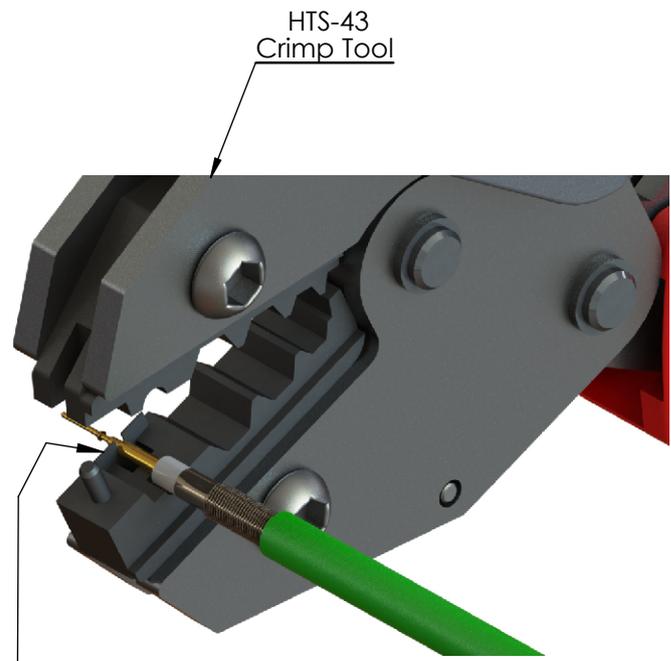
1. Slide the crimp sleeve onto the cable.
2. Strip the cable to the dimensions given on the connectors datasheet. If the cable has a foil screen please check the datasheet for the stripping length of this screen.



3. Slide the centre contact onto the cable centre conductor up to cable dielectric. If the conductor is of stranded construction, ensure all the strands have entered the contact.
4. Ensure that the conductor is visible through the contact's inspection hole.



5. Carefully place Cable and Centre Contact assembly into the crimp tool. The Front of the contact should be placed into the slot in the Contact Stop Plate. Push the Centre Contact forward until the rear diameter of the Centre Contact butts up against the plate as shown. Crimp the centre contact. Remove and carefully check the crimp joint.



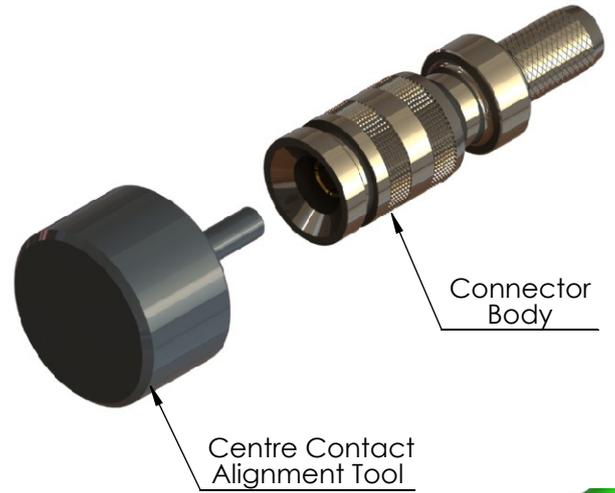
6. Crimp the centre contact. Remove and carefully check the crimp joint.

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A4	SHEET 1 OF 2		DIMENSIONS ARE IN MILLIMETRES		
REVISION :	A00		NAME	SIGNATURE	DATE
ISSUE :	1	DRAWN	GE		29/01/2014
		CHK'D	PS		29/01/2014
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ASSEMBLY PROCEDURE : AP037

7. Take the connector body and place the small diameter of the centre contact alignment tool fully into the front of the connector.



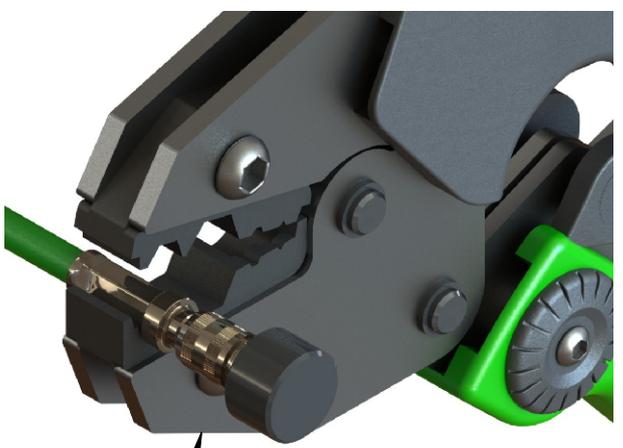
8. Fan the cable braid out. On foil screened cables the foil must remain around the cables dielectric, and pass inside the connectors rear bore. It must never be placed over the knurled area, as the tapes often used in the construction of this screen could insulate all the screens from the connector.



9. Slide the cable into the connector and push home until the centre contact "CLICKS" into place in the connectors dielectric. Ensure all the braid strands pass outside over the knurled area of the connector.

10. Slide the crimp sleeve forward over the braid and knurled area of the connector to the rear of the connector body.

11. Place the crimp sleeve and connector body assembly into the appropriate sized crimp tool given on the connectors datasheet.



12. Crimp the crimp sleeve. Remove from tool and check the crimp (trim excess braid if necessary).

13. Remove the alignment tool from the connector body and retain for further use. Carefully check the whole assembly and ensure the centre contact is central.



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A4	SHEET 2 OF 2		DIMENSIONS ARE IN MILLIMETRES		
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