

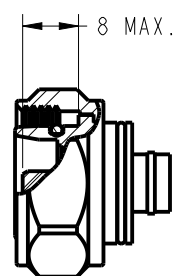
ASSEMBLY INSTRUCTIONS:

THIRD ANGLE PROJ.

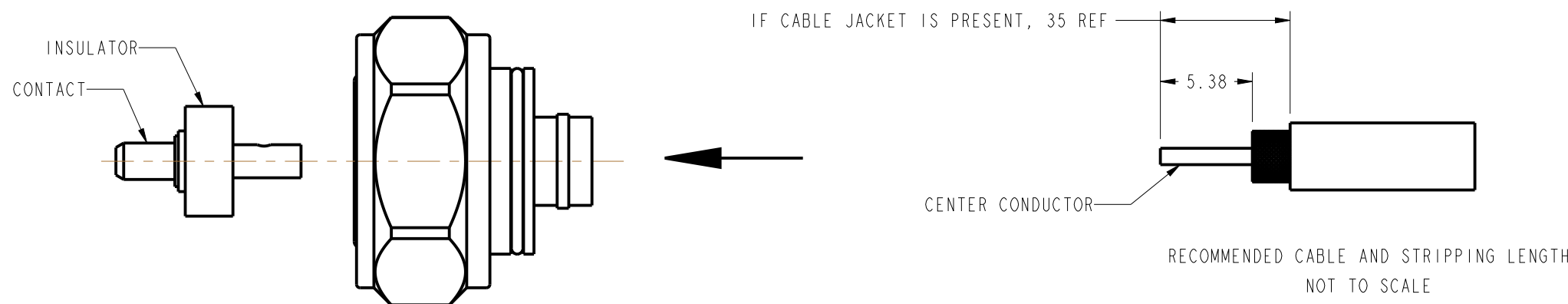
REVISIONS

REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE	10/24/16	02202	KCE

1. STRIP CABLE AS SHOWN
2. SLIP CABLE THROUGH CONNECTOR IN THE DIRECTION SHOWN
3. TRIM A PIECE OF SOLDER WIRE SO IT CAN BE INSERTED INTO THE CONTACT AND REMAIN FLUSH WITH THE BACK OF THE CONTACT.
4. INSERT THE SOLDER WIRE INTO THE CONTACT.
5. SIMULTANEOUSLY APPLY HEAT TO THE BACK OF THE CONTACT AND GENTLY INSERT THE CENTER CONDUCTOR INTO CONTACT UNTIL THE DIELECTRIC BOTTOMS ON THE CONTACT.
6. GENTLY PULL SOLDERED CABLE ASSEMBLY BACK THROUGH THE CONNECTOR AND PRESS CONTACT/INSULATOR ASSEMBLY INTO CONNECTOR UNTIL BOTTOMED. (FIXTURE MAY BE REQUIRED. APPROX. 50 LBF)
7. SOLDER CABLE OUTER CONDUCTOR TO CONNECTOR BODY.



4.3-10 CONTACT DEPTH REF.



UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN METRIC AND TOLERANCES ARE:  
 <0.5mm ± 0.05mm    0.5 - 6mm ± 0.1mm    6 - 30mm ± 0.2mm    30 - 120mm ± 0.3mm    ANGLES ± 1°

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MATERIAL	DRAWN K. ELMES	DATE 27-Sep-16	TITLE 431-124P-52S STRIPPING INSTRUCTIONS (RG-401)		Amphenol RF www.amphenolrf.com
REFERENCE EAR# 6645	ENGINEER K. ELMES	DATE 27-Sep-16	SCALE: 1.0:1.0 SHEET 1 OF 1		
CONFIGURATION LEVEL: In Work	APPROVED K. CAPOZZI	DATE 10/24/16	DWG SIZE B	REV A	DRAWING NO. 349-50926
FINISH					ITEM NO. 349-50926 PART NO. 349-50926