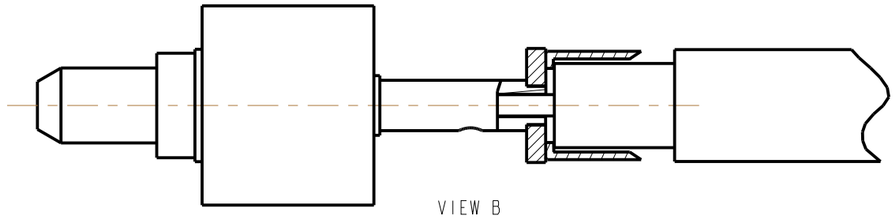
THIRD ANGLE PROJ.

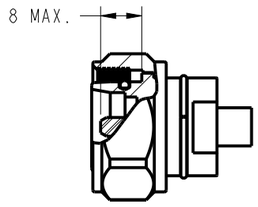
REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE	10/24/16	02202	KCE

ASSEMBLY INSTRUCTIONS:

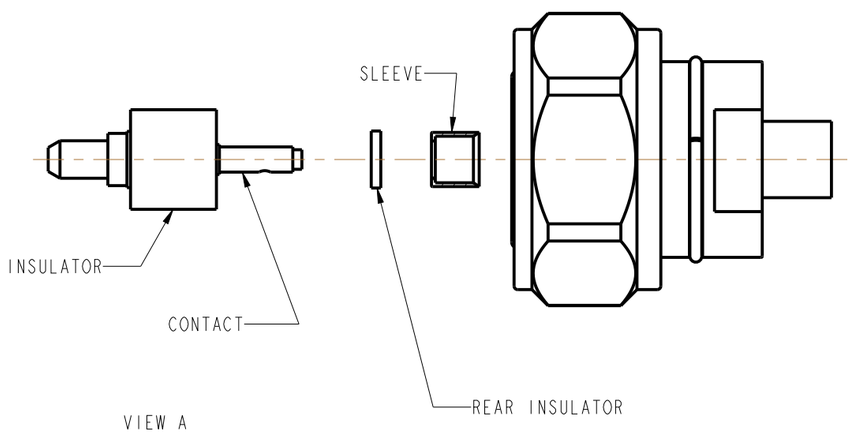
1. STRIP CABLE AS SHOWN
2. SLIP CABLE THROUGH CONNECTOR IN THE DIRECTION SHOWN (VIEW A)
3. INSERT CENTER CONDUCTOR THROUGH SLEEVE AS ORIENTED IN (VIEW B)
4. INSERT REAR INSULATOR ONTO CONTACT (VIEW B)
5. TRIM A PIECE OF SOLDER WIRE SO IT CAN BE INSERTED INTO THE CONTACT AND REMAIN FLUSH WITH THE BACK OF THE CONTACT.
6. INSERT THE SOLDER WIRE INTO THE CONTACT.
7. SIMULTANEOUSLY APPLY HEAT TO THE BACK OF THE CONTACT AND GENTLY INSERT THE CENTER CONDUCTOR THROUGH REAR INSULATOR AND INTO CONTACT UNTIL THE SLEEVE BOTTOMS ON REAR INSULATOR.
8. GENTLY PULL SOLDERED CABLE ASSEMBLY BACK THROUGHT THE CONNECTOR AND PRESS CONTACT/INSULATOR ASSEMBLY INTO CONNECTOR UNTIL BOTTOMED. (FIXTURE MAY BE REQUIRED. APPROX. 65LBF)
9. SOLDER CABLE OUTER CONDUCTOR TO CONNECTOR BODY.



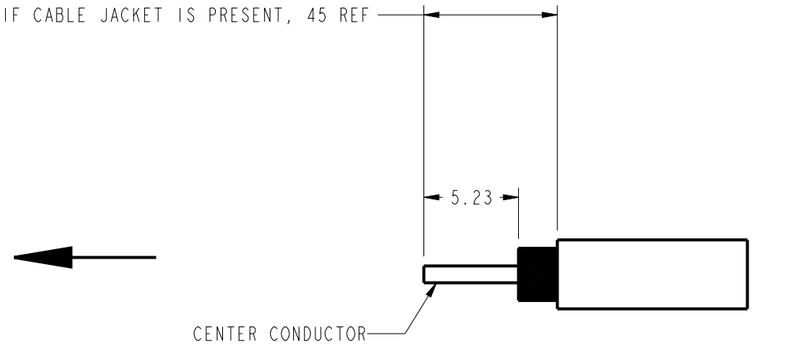
VIEW B



4.3-10 CONTACT DEPTH REF.



VIEW A



RECOMMENDED CABLE AND STRIPPING LENGTH
NOT TO SCALE

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN METRIC AND TOLERANCES ARE:

<0.5mm	0.5 - 6mm	6 - 30mm	30 - 120mm	ANGLES
± 0.05mm	±0.1mm	±0.2mm	± 0.3mm	±1°

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MATERIAL

REFERENCE
EAR# 6645

CONFIGURATION LEVEL: In Work

FINISH

DRAWN	K. ELMES	DATE 26-Sep-16
ENGINEER	K. ELMES	DATE 26-Sep-16
APPROVED	K. CAPOZZI	DATE 10/24/16
CAD FILE		

TITLE
431-123P-52S
STRIPPING
INSTRUCTIONS (RG-402)

SCALE: 2.0:1.0 SHEET 1 OF 1

DWG SIZE B REV A

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DRAWING NO. 349-50925
ITEM NO. 349-50925
PART NO. 349-50925