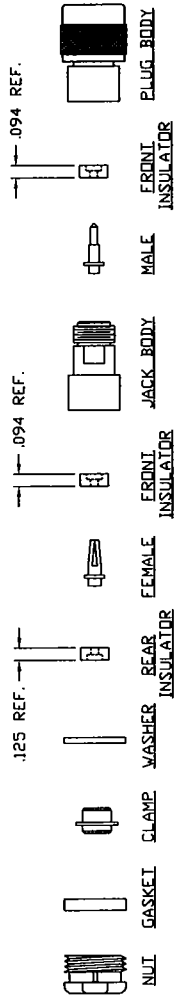


REV. B 090477-000

TITLE: ASSY. INSTRUCTIONS
COAXIAL CONNECTOR
TYPE N

DRAWN	C.B.	DATE	08/24/99
CHK.	E.C.	DATE	08/26/99
DESIGN ENG.	M.W.	DATE	08/26/99
MFG. ENG.	C.P.	DATE	08/26/99
RELEASED	E.C.	DATE	08/26/99



	CUT END OF CABLE EVEN. PLACE NUT & GASKET WITH 'V' GROOVE TOWARD CLAMP, OVER CABLE & CUT OFF JACKET 23/64" FROM END
	COMB OUT BRAID AS SHOWN. CUT OFF CABLE DIELECTRIC 1/8" FROM END OF JACKET.
	PULL BRAID WIRES FORWARD & TAPER TOWARD CENTER CONDUCTOR. PLACE CLAMP OVER BRAID & PUSH BACK AGAINST CABLE JACKET.
	FOLD BACK WIRES AS SHOWN, TRIM TO PROPER LENGTH & FORM OVER CLAMP AS SHOWN. TIN EXPOSED CENTER CONDUCTOR USING MINIMUM AMOUNT OF HEAT. SLIDE ON WASHER, REAR INSULATOR & CONTACT. CONTACT SHOULDER, INSULATOR, & CABLE CORE MUST BUTT AS SHOWN. SOLDER CONTACT TO CENTER CONDUCTOR.
	SLIDE FRONT INSULATOR OVER CONTACT. BE SURE TO PLACE COUNTER BORE END OF INSULATOR TOWARD MATING END OF CONTACT.

INSERT PREPARED CABLE TERMINATION INTO CONNECTOR BODY. MAKE SURE SURE SHARP EDGE OF CLAMP SEATS PROPERLY IN GASKET. TIGHTEN NUT, HOLDING BODY STATIONARY. RECOMMENDED TO TORQUE NUT 61 IN. LBS.

NOTE: FOR ARMORED CABLE SLIDE OVER ARMOR FIRST. PUSH ARMOR & CAP BACK OUT OF WAY & PROCEED WITH ASSEMBLY AS DIRECTED ABOVE USING ARMOR CLAMP IN PLACE OF STANDARD CLAMP NUT. WHEN ASSEMBLY IS COMPLETE STRAIGHTEN BULGE IN ARMOR & TRIM SO IT CAN BE CLAMPED BETWEEN NUT & CAP.

* USE DIVCO #276 (OR HIGH TEMP. ALLOY) SOLDER FOR HIGH TEMP. APPLICATIONS.

