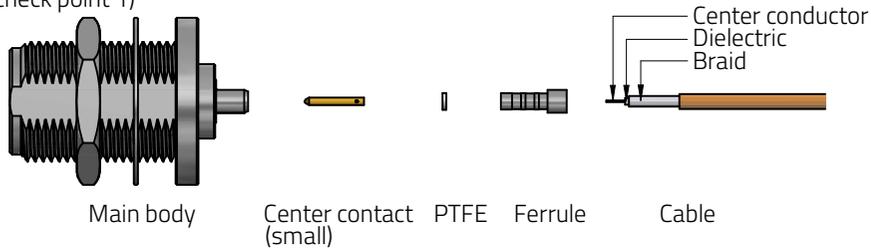


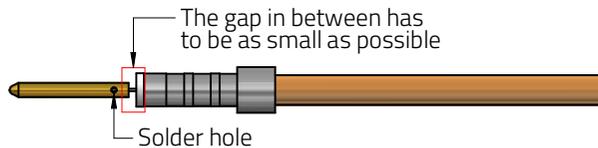
Step 1. Prepare connector components and strip coaxial cable according to given dimensions (check point 1)



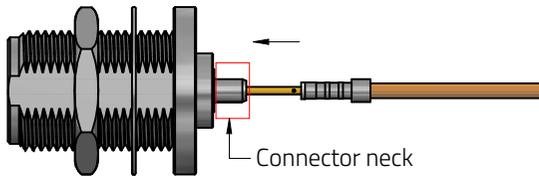
Step 2. Pre-tinned cable center conductor (optional, see check point 2)
Slide ferrule onto cable that will cover cable jacket, cable braid and cable dielectric
Make sure PTFE sits on cable dielectric and locates in front of ferrule



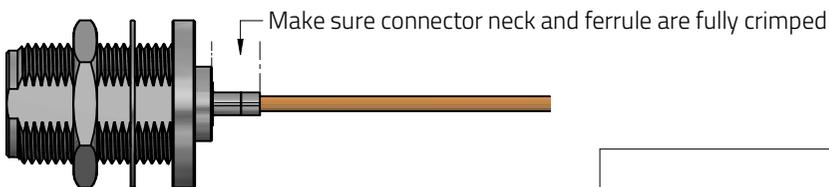
Step 3. Place small center contact in front of PTFE
Solder cable center conductor using minimum amount of solder paster through solder hole (check point 3)



Step 4. Push cable with small center contact into connector main body



Step 5. Crimp ferrule with tool hex size : .1" (check point 4)



Assembly Method :

Center contact : Soldered
Outer contact : Crimp

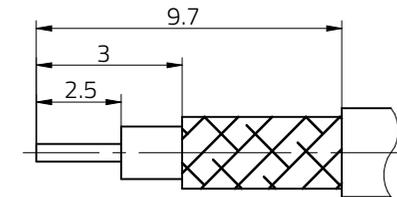
Crimp Tool PN : 600600

Crimp Head PN : 60060060101



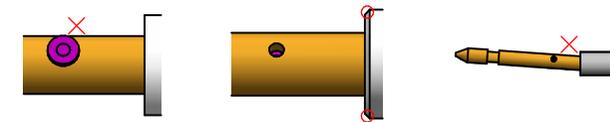
Cable Type : Flexible Cable 1.13

Cable Strip Dimensions (mm) :



Check Point :

1. No damaged components; and no split cable after stripping
2. Assembly can be performed with or without tinned cable
The tinned cable center conductor can enhance the hardness of the cable center conductor and benefit solder process
3. No excess solder, melt dielectric, and misaligned center contact after assembling



4. No significant dog ear after crimping



CREATED CTc	CHECKED JCh	
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DESCRIPTION Assembly instructions 604 255 225 121 20			
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REVISION 001.001	STATUS Valid	DATE 2022-04-15	BUSINESS UNIT eiCan
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