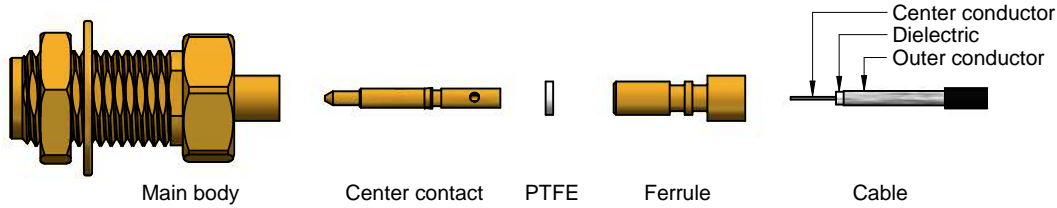
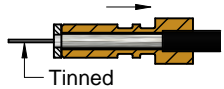


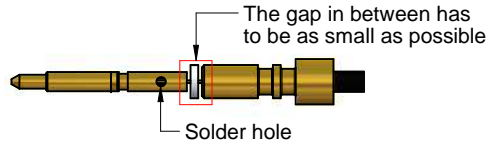
**Step 1.** Prepare connector components and strip coaxial cable according to given dimensions (check point 1)



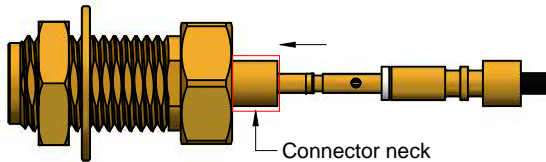
**Step 2.** Pre-tinned cable center conductor (optional, see check point 2)  
Slide ferrule onto cable that will cover cable jacket, cable outer conductor and cable dielectric  
Make sure PTFE sits on cable dielectric and locates in front of ferrule



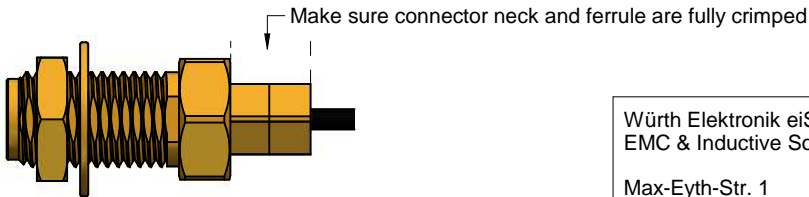
**Step 3.** Place center contact in front of PTFE  
Solder cable center conductor using minimum amount of solder paste through solder hole (check point 3)



**Step 4.** Push cable with 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

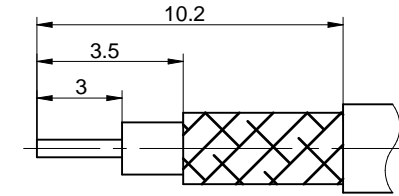
**Crimp Tool PN :** 600600

**Crimp Head PN :** 60060060101



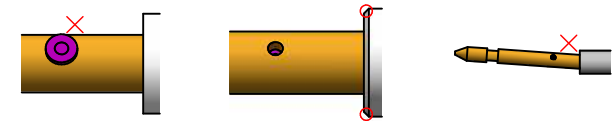
**Cable Type :** Flexible Cable 1.13

**Cable Strip Dimensions (mm) :**

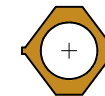


**Check Point :**

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



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CREATED  
BMa

CHECKED  
JCh

DESCRIPTION

**Assembly instructions**

**630 264 202 121 20**

REVISION

STATUS

DATE

2021-01-25

BUSINESS UNIT

eiCan