

DO NOT use these instructions for assembling plugs to cable with low temperature dielectric. Consult factory. Special connectors required.

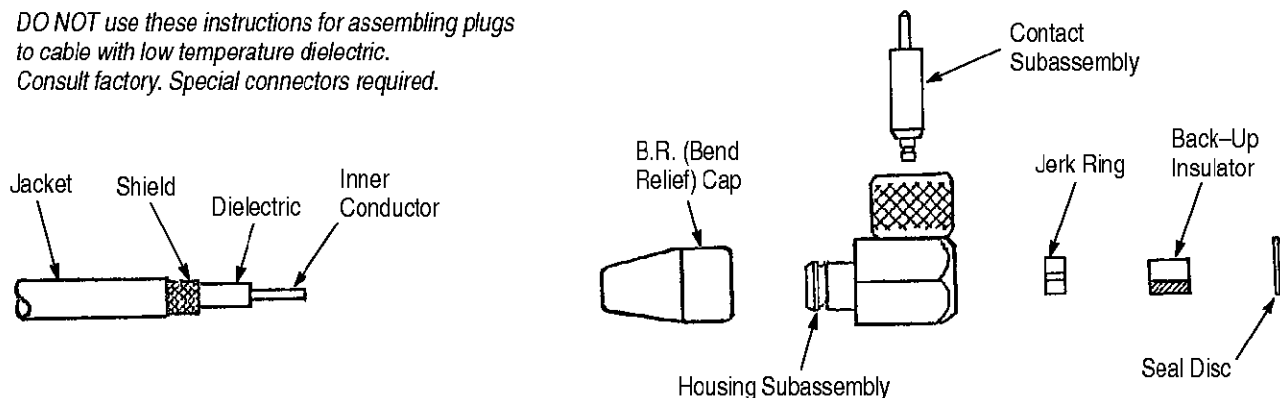


Figure 1

INTRODUCTION

This instruction sheet covers the assembly procedures for the Right-Angle Plugs. See Figure 1.

NOTE

Dimensions on this sheet are in inches [with millimeters in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

Step 1

Slip bend relief cap and housing subassembly over coax cable.

Step 2

Strip jacket from cables .50 inch [12.7 mm]. See Figure 2.

CAUTION

Be careful not to nick shield.

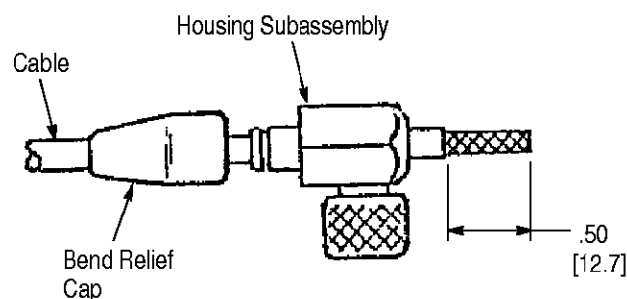


Figure 2

Note: For assembly to cables with "Mini-Noise" coating, Mini-Noise coating must be removed from surface of cable dielectric as follows:

1. Painted Coatings: Wipe off dielectric surface with a dry cloth. Wipe again using paint thinner or trichloroethane. Do not immerse cable in solvent.

2. Tape or Fused Coatings: Remove with sandpaper, file, or scraping action of razor blade. Do not damage dielectric.

DANGER

To prevent personal injury, use caution when handling file or razor blade.

Step 3

Place jerk ring .063 [1.60] from end of jacket. See Figure 3.

Crimp jerk ring on the shield.

NOTE

Care should be taken to keep the jerk ring round.

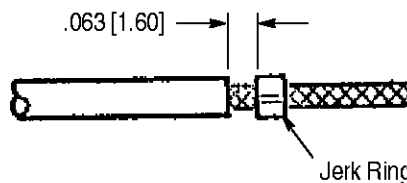


Figure 3

Step 4

Unbraid shield back to the jerk ring.

Twist wires into two equal groups and solder to jerk ring.

Cut shield wires close to jerk ring. See Figure 4.

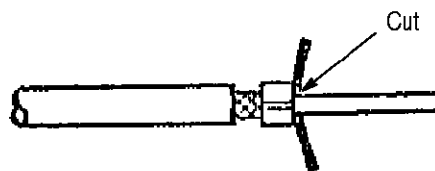


Figure 4

Step 5

Strip dielectric as shown in Figure 5.

Step 6

Wrap resin core solder (KESTER™ Solder “44”) around shield between jacket and jerk ring. See Figure 5.

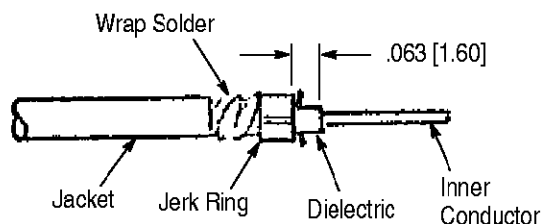


Figure 5

Step 7

Pull cable so that solder around shield is at the bottom of the housing subassembly.

Hold housing subassembly in an upright position. This ensures even distribution of solder.

Pull cable taut and apply heat to housing subassembly. See Figure 6.

When solder has melted, a slight give of the cable will be noted, allow to cool, keeping tension on the cable.

Step 8

Press pin subassembly into the ferrule with tool described in Step 12.

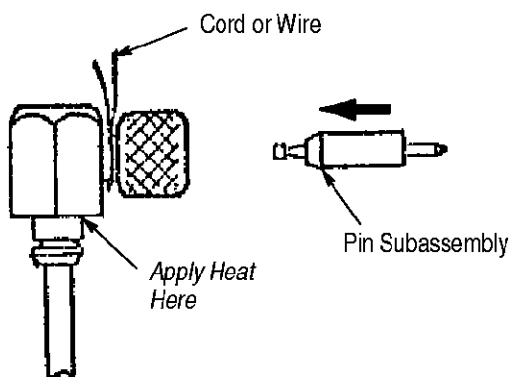


Figure 6

Step 9

Trim inner conductor so that it will wrap around no more than two-thirds of the pin.

Solder inner conductor to pin. See Figure 7.

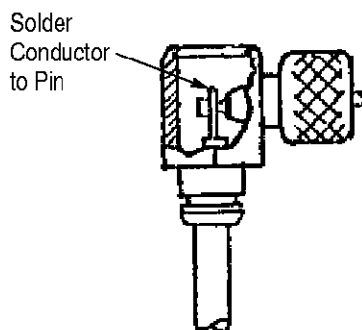


Figure 7

Step 10

Insert back-up insulator into the angle block, curved side against the round bore of the angle block. See Figure 8.

Step 11

Fill angle block with potting compound. See Figure 8. Compound should have good dielectric properties and low water absorption.

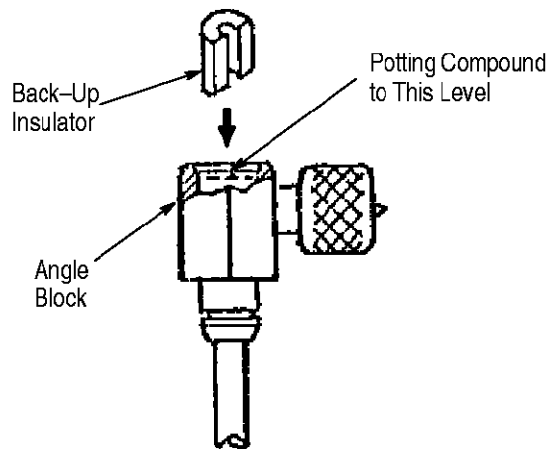


Figure 8

Step 12

Place seal disc in head of housing subassembly, convex side up.

With tool, swage the end of the angle block over the seal disc. See Figure 9.

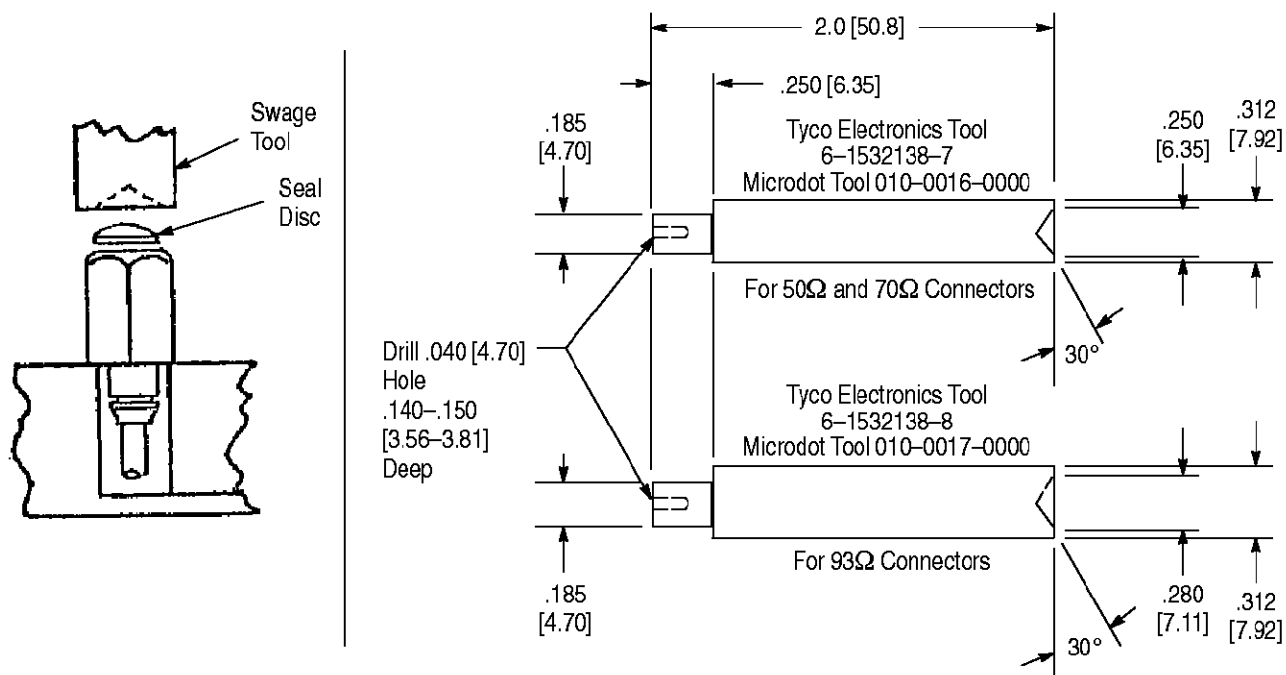


Figure 9

Step 13

Pull bend relief cap into position. See Figure 10.
This completes assembly.

REVISION SUMMARY

Per EC 0990-0900-01

- Initial release of instruction sheet

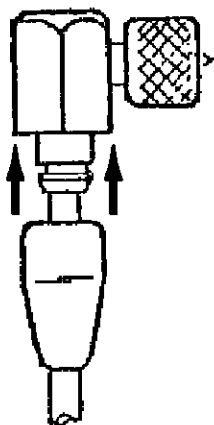


Figure 10