

Figure 1

INTRODUCTION

This instruction sheet covers the assembly procedures for the Triax Plug. 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

Slide bend relief cap (1), sleeve (2), ring (3), and nut (12) over triax cable as shown in Figure 2. Strip cable per dimensions shown in Figure 2.

Do not disturb the lay of either shield.

CAUTION

Be careful not to nick inner conductor or shield.

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.

ANGER

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

Step 2

Slide insulator (4) and inner solder ring (5) over outer dielectric.

Slide inner sleeve (6) between inner dielectric and inner shield. See Figure 3.

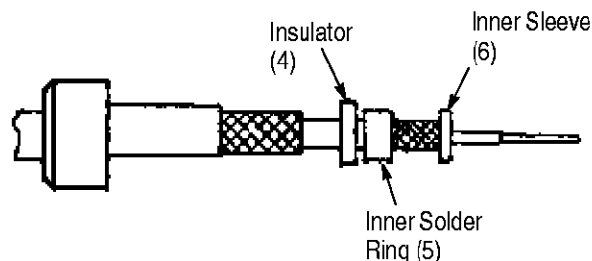


Figure 3

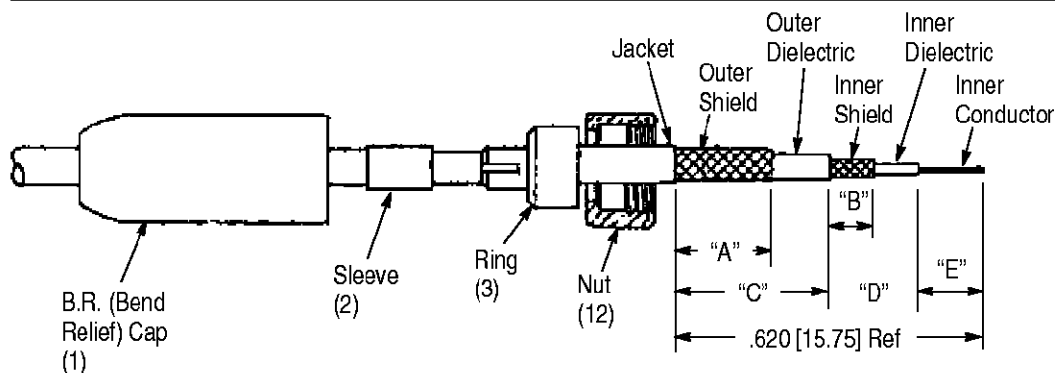


Figure 2

DIM.	LENGTH ±.010 [0.25]
A	.180 [4.57]
B	.100 [2.54]
C	.370 [9.40]
D	.170 [4.32]
E	.080 [2.03]

Step 3

Slide inner solder ring (5) over inner shield until it butts against flange of inner sleeve (6).

Position insulator (4) against inner solder ring (5). See Figure 4.

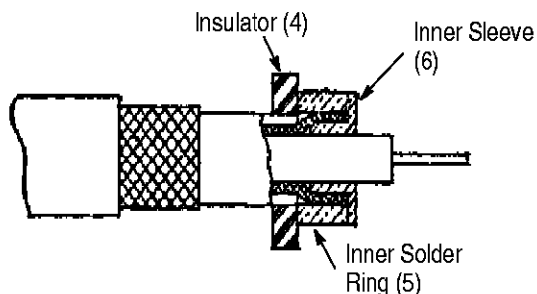


Figure 4

Step 4

If the inner conductor is stranded, it must be tinned. Position insulator (7) and socket contact (8) against inner sleeve (6) as shown in Figure 5.

Holding components firmly in place, apply solder. Use only 1/32 in. diameter resin core solder. See Figure 5.

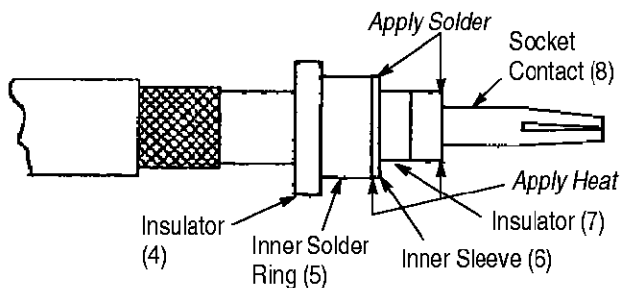


Figure 5

Step 5

Assemble insulator (9) and inner ferrule (10) as shown in Figure 6.

Solder all around rear of inner ferrule (10).

CAUTION

Be careful not to get solder on the two ears.

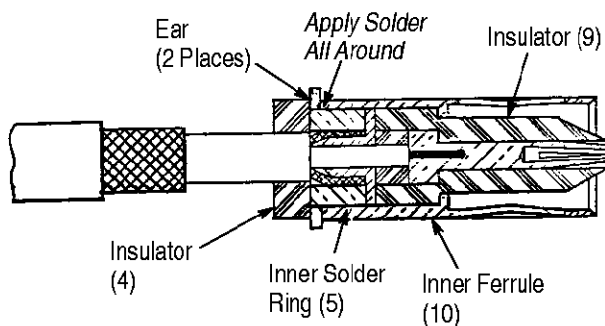


Figure 6

Step 6

Assemble insulator (11) and ferrule (13) so they are flush with the rear of insulator (4).

Position nut (12) and ring (3) as shown in Figure 7.

Solder ring (3) to ferrule (13) all around.

Using small pliers, crimp slotted section of ring (3) as shown in Figure 7.

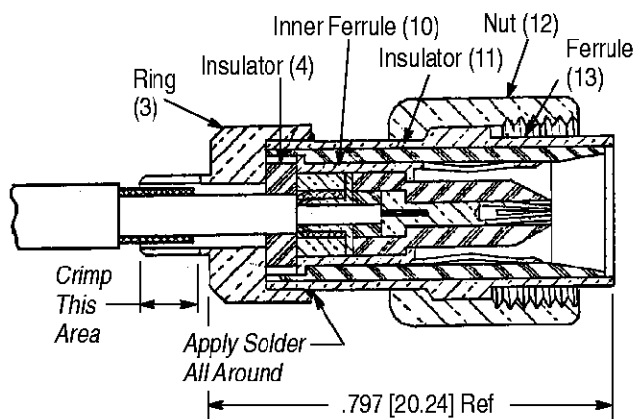


Figure 7

Step 7

Slide sleeve (2) forward over ring (3) and solder all around.

Slide bend relief cap (1) forward until it locks in place over ring (3). See Figure 8.

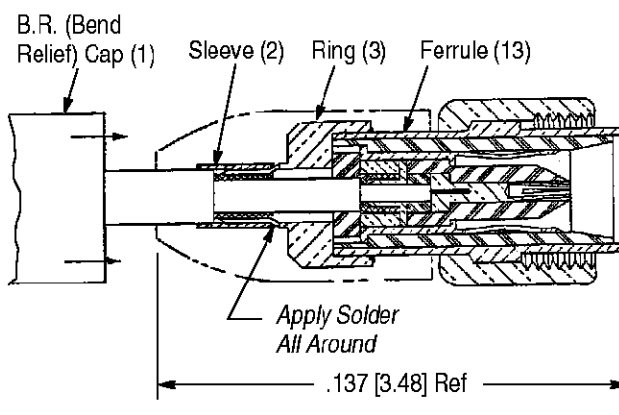


Figure 8

This completes the assembly.

REVISION SUMMARY

Per EC 0990-0894-01

- Initial release of instruction sheet