

NOTE: CARE MUST BE TAKEN WHEN TRIMMING CABLE THAT THE BRAIDS, INSULATORS AND CONDUCTORS OF THE CABLE ARE NOT NICKED OR DAMAGED.

- CUT CABLE END SQUARE. PLACE NUT (ITEM 1), COLLET (ITEM 2), THIN WASHER (ITEM 3), AND GASKET (ITEM 4) OVER THE JACKET.
- REMOVE OUTER JACKET TO 1-17/32" DIMENSION SHOWN.
- COMB OUT BRAID AS SHOWN.
- FOLD BRAID BACK AND TRIM CABLE BACK 1/2".
- COMB OUT BRAID AGAIN AND FORM END AS SHOWN.
- PLACE BRAID CLAMP (ITEM 5) OVER THE OUTER BRAID AND SEAT AGAINST THE OUTER JACKET.
- FOLD THE OUTER BRAID BACK OVER THE BRAID CLAMP, AND PRESS THE OUTER GROUND RING (ITEM 6) OVER THE BRAID AND BRAID CLAMP SO THAT THE OUTER GROUND RING IS FLUSH TO THE EDGE OF THE BRAID CLAMP. TRIM EXCESS BRAID THAT EXTENDS BEYOND THE OUTER DIAMETER OF THE BRAID CLAMP.
- REMOVE INNER JACKET AND INNER BRAID TO 5/16" DIMENSION. REMOVE INNER JACKET AN ADDITIONAL 9/32". DO NOT NICK BRAID.
  - REMOVE INNER DIELECTRIC TO 1/8" DIMENSION TO EXPOSE INNER CONDUCTOR. DO NOT NICK OR UNRAVEL CENTER CONDUCTOR.
  - PLACE THICK WASHER (ITEM 7) AGAINST GROUND RING.
- PLACE THE MALE OR FEMALE CONNECTOR CONTACT (ITEM 10) OVER THE CENTER CONDUCTOR OF THE CABLE AND BUTT IT AGAINST THE CORE. CRIMP OR SOLDER THE CONTACT TO THE CORE.
- PLACE CRIMP SLEEVE (ITEM 8) OVER INNER BRAID OF THE CABLE. SLIDE BODY ASSEMBLY (ITEM 9) OVER THE CORE (INNER DIELECTRIC) AND UNDER THE INNER BRAID UNTIL THE CONTACT BOTTOMS IN THE CONNECTOR. (NOTE: CAUTION MUST BE EXERCISED NOT TO ALLOW ANY OF THE BRAID TO REMAIN INSIDE THE CONNECTOR ASSEMBLY. ALL BRAID MUST BE ON THE OUTSIDE OF THE BODY.) SLIDE THE CRIMP SLEEVE OVER BODY AND BRAID TO WITHIN 1/64" OF THE BODY SHOULDER. CRIMP THE SLEEVE. SLIDE CONNECTOR INTO MAIN CONNECTOR BODY (ITEM 11). TIGHTEN COLLET TO BODY WITH A MINIMUM OF 80 INCH POUNDS OF TORQUE. IT IS RECOMMENDED NOT TO EXCEED 125 INCH POUNDS OF TORQUE. LOCK CLAMP NUT TO COLLET TO PREVENT ROTATION OF CABLE WITHIN THE CONNECTOR.

Crimp Dies are available for above operations. (See page 28 and 29 for part numbers.)

Tri-Loc Inspection Gauges are available. (See page 37 for part numbers.)

ALL DIMENSIONS ARE IN INCHES