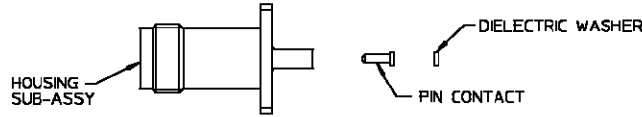


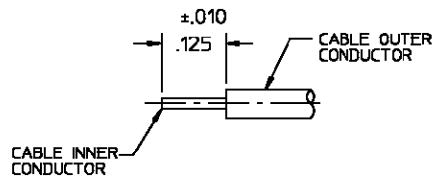
CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
TNC FLANGE MOUNT CABLE JACK DIRECT SOLDER ATTACHMENT	.085 SR COAXIAL CABLE	NO SPECIAL TOOLING IS REQUIRED

CONNECTOR

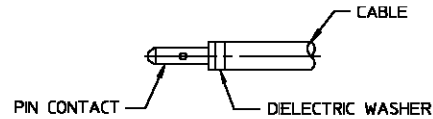


ASSEMBLY OPERATIONS

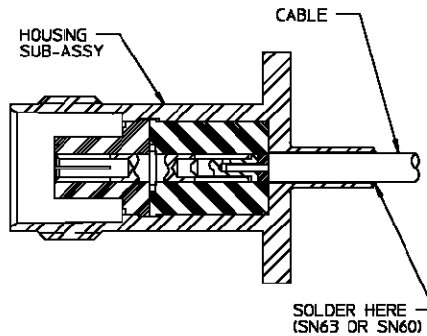
- 1.0 PREPARATION OF CABLE
1.1 TRIM CABLE TO DIMENSIONS SHOWN.



- 2.0 SOLDERING OF PIN CONTACT TO CABLE INNER CONDUCTOR
2.1 TIN INNER CONDUCTOR OF CABLE.
2.2 PLACE DIELECTRIC WASHER ON INNER CONDUCTOR. PLACE A SMALL AMOUNT OF SOLDER IN THE I.D. OF THE PIN CONTACT THEN SLIDE THE PIN CONTACT ONTO THE CABLE INNER CONDUCTOR.
2.3 APPLY HEAT TO THE PIN CONTACT AND PUSH FIRMLY UP AGAINST THE DIELECTRIC WASHER.
2.4 REMOVE EXCESS SOLDER.



- 3.0 SOLDERING OF HOUSING SUB-ASSY TO CABLE
3.1 INSERT PIN CONTACT CABLE TERMINATION INTO THE HOUSING SUB-ASSY. PUSH FIRMLY SO THAT THE PIN CONTACT FULLY ENGAGES THE INTERNAL SOCKET CONTACT.
3.2 APPLY HEAT AND SOLDER (SN63 OR SN60) TO THE CABLE ENTRY.



- 4.0 INSPECTION OF COMPLETED ASSEMBLY
4.1 INSPECT CONNECTOR ASSY TO THE DIMENSIONS SHOWN TO ASSURE THAT INTERNAL PARTS HAVE NOT SHIFTED DURING ASSEMBLY.

