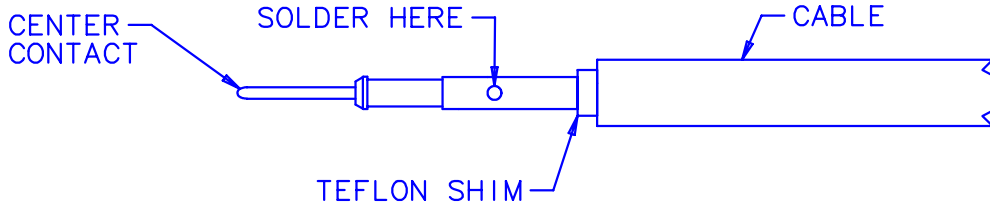
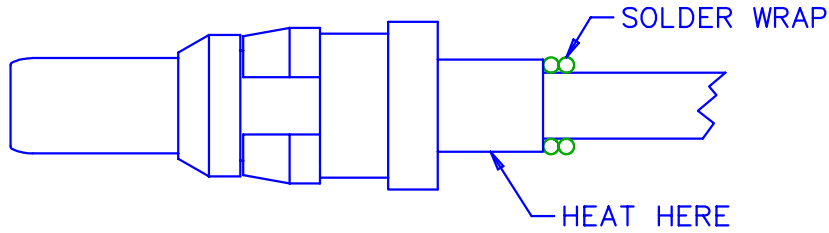


- STEP 1: CUT THE CABLE TO DESIRED LENGTH, AND STRIP END TO DIMENSIONS SHOWN. MAKE SURE NOT TO NICK OR CUT THROUGH THE CENTER CONDUCTOR. AFTER STRIPPING, PRE-TIN THE CENTER CONDUCTOR.

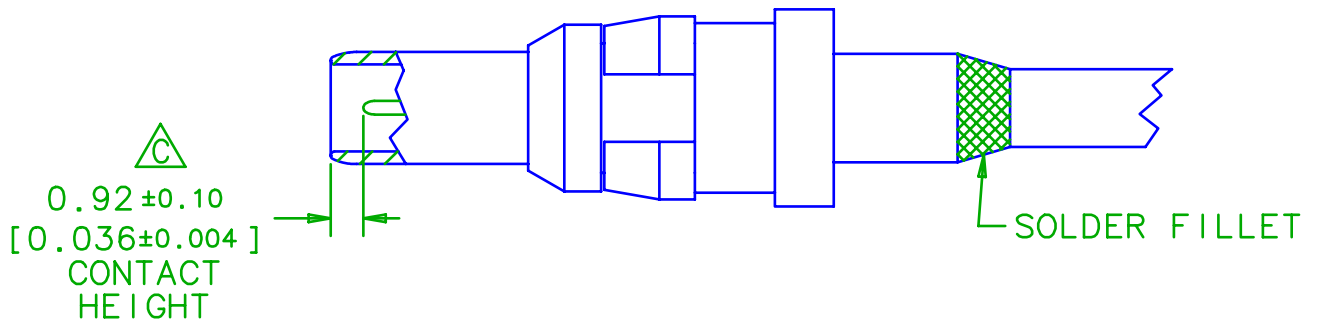


- STEP 2: SLIDE THE TEFLON SPACER OVER THE CABLE CENTER CONDUCTOR AND BOTTOM IT AGAINST THE CABLE DIELECTRIC. HEAT THE CABLE CENTER CONDUCTOR UNTIL IT IS WARM, AND INSERT THE CENTER CONTACT ONTO THE CABLE CENTER CONDUCTOR UNTIL IT BOTTOMS AGAINST THE TEFLON SPACER. TO ENSURE PROPER ATTACHMENT, A SMALL AMOUNT OF HEAT COULD BE APPLIED WHERE SHOWN. MAKE SURE NOT TO OVERHEAT THE CENTER CONTACT AND CABLE.

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B	DCR 11438	4/22/99	MDL				REV: C
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- STEP 3: SLIDE THE CABLE AND CENTER CONDUCTOR ASSEMBLY INTO THE PIN ASSEMBLY, MAKING SURE THAT THE CONNECTOR CENTER CONDUCTOR IS ALIGNED WITH THE CONNECTOR DIELECTRIC HOLE. APPLY A SMALL AMOUNT OF FORCE TO PUSH THE CONTACT THROUGH UNTIL IT SNAPS INTO PLACE. ONCE A SNAP IS FELT, THE CENTER CONDUCTOR IS IN THE PROPER PLACE. WRAP 2 TO 3 TURNS OF 0.50mm (0.020in.) DIAMETER SOLDER AROUND THE COPPER JACKET OF THE CABLE AS SHOWN. APPLY HEAT TO THE CONNECTOR HOUSING WHERE NOTED, UNTIL SOLDER FLOWS. DO NOT OVERHEAT THE CONNECTOR. CLEAN THE AREA OF FLUX USING A NON-ALCOHOL BASED SOLVENT.



- STEP 4: AFTER THE CABLE ATTACHMENT, THE ASSEMBLY SHOULD APPEAR AS SHOWN AND CONTACT HEIGHT SHOULD MEASURE AS SHOWN.

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