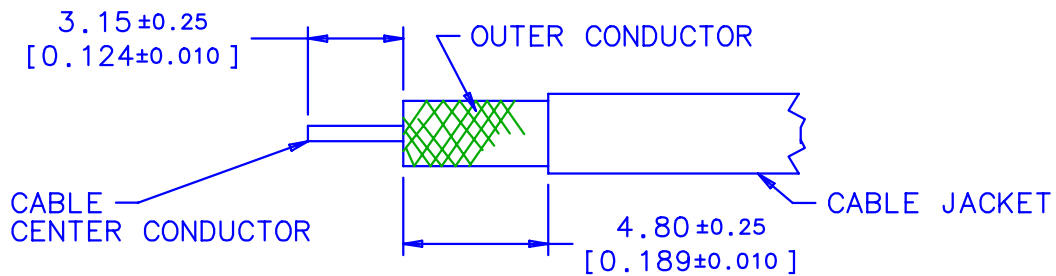
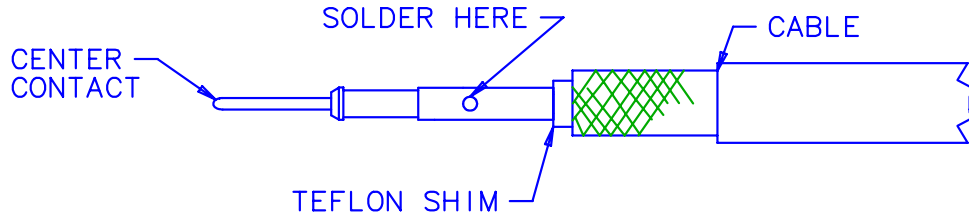


- **STEP 1: CUT THE CABLE TO DESIRED LENGTH. BEFORE STRIPPING THE CABLE, DIP THE END OF THE CABLE INTO FLUX, THEN INTO A SOLDER POT MAINTAINED AT 500 DEG. F TO A DEPTH OF 0.375in. FOR 6 SECONDS MAXIMUM. THIS BONDS THE OUTER CONDUCTOR SHIELDS FOR EASY TRIMMING AND SOLDERING TO THE CONNECTOR.**

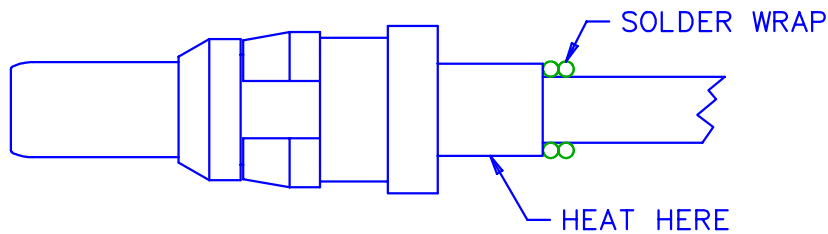


- **STEP 2: STRIP END TO DIMENSIONS SHOWN. MAKE SURE NOT TO NICK OR CUT THROUGH THE CENTER CONDUCTOR. AFTER STRIPPING, PRE-TIN THE CENTER CONDUCTOR.**

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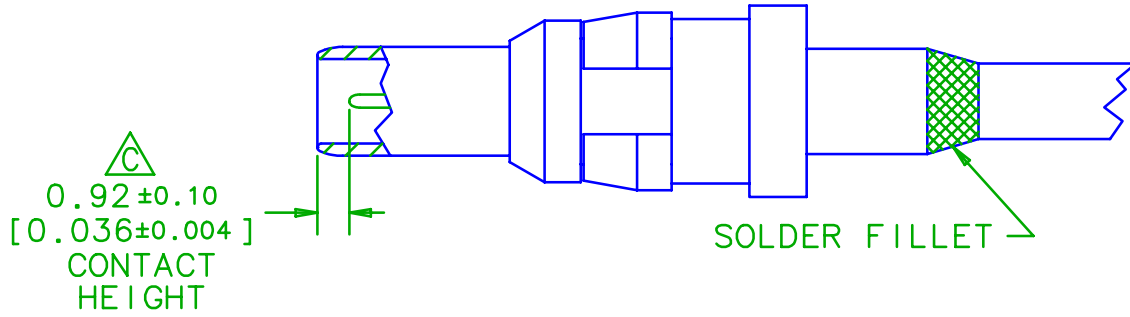


- STEP 3: SLIDE THE TEFLON SPACER OVER THE CENTER CONDUCTOR OF THE CABLE UNTIL IT BOTTOMS OUT AGAINST THE CABLE DIELECTRIC. HEAT THE CENTER CONTACT UNTIL IT IS WARM AND INSERT THE CENTER CONTACT ONTO THE CABLE CONDUCTOR UNTIL IT BOTTOMS OUT AGAINST THE TEFLON SPACER. TO ENSURE PROPER ATTACHMENT, A SMALL AMOUNT OF HEAT COULD BE APPLIED WHERE SHOWN. MAKE SURE NOT TO OVERHEAT THE CENTER CONTACT AND CABLE.



- STEP 4: 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.

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- STEP 5: AFTER THE CABLE ATTACHMENT, THE ASSEMBLY SHOULD APPEAR AS SHOWN AND CONTACT HEIGHT SHOULD MEASURE AS SHOWN.

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