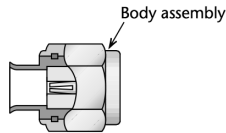
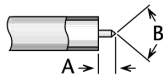


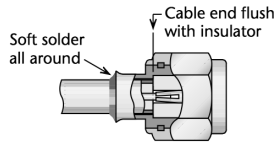
Assembly Procedure I



Trim Codes		
Code	A	B
I/01	.090	70-90°



- 1)** Trim cable as shown. Remove any burrs from jacket and center conductor.



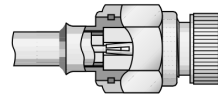
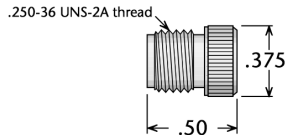
- 2)** Insert cable into body and solder cable jacket to body, keeping end of cable flush with insulator as shown.

Plug body assembly and contact shown; procedure is identical for jack connectors.

Cable Positioner

For .085" Cable:
P/N 63-10072-2

For .141" Cable:
P/N 63-10072-1



Using this positioner in the final step of assembly procedure H or I (for plugs only) will ensure that the contact and insulator are retained in the proper position to meet MIL-C-39012 requirements. The positioner should be screwed finger-tight into the mating end of the connector (as shown at right) before the cable jacket is soldered to the body assembly.