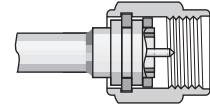
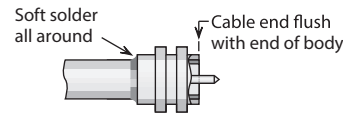
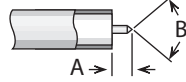
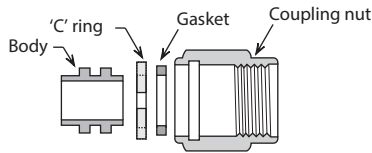


Assembly Procedure G



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

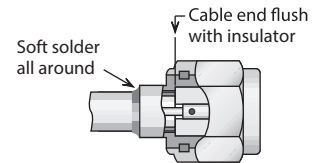
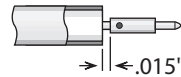
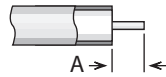
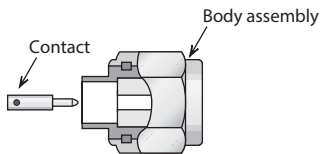
- 2) Soft solder cable jacket to body, making sure that end of cable is flush with end of body. After solder joint has cooled, retrim any protruding dielectric flush with end of body.

- 3) Assemble 'C' ring and gasket to body. Compress 'C' ring and slide body assembly into coupling nut until ring is seated in groove.

Trim Codes

Code	A	B
G/01	.090	70-90°

Assembly Procedure H



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

- 2) Solder contact to center conductor, fixturing to maintain gap as shown. Remove any excess solder from outside of contact.

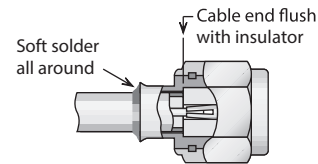
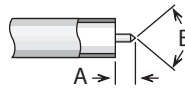
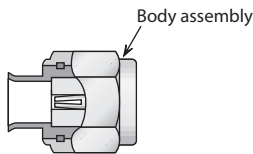
- 3) Insert cable into body and solder cable jacket to body, keeping end of cable flush with insulator as shown.

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

Trim Codes

Code	A
H/01	.090
H/02	.060
H/03	.115
H/04	.150

Assembly Procedure I



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

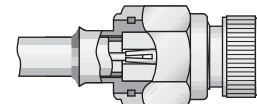
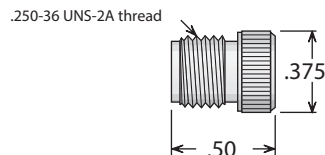
- 2) Insert cable into body and solder cable jacket to body, keeping end of cable flush with insulator as shown.

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

Trim Codes

Code	A	B
I/01	.090	70-90°

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.