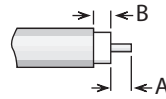
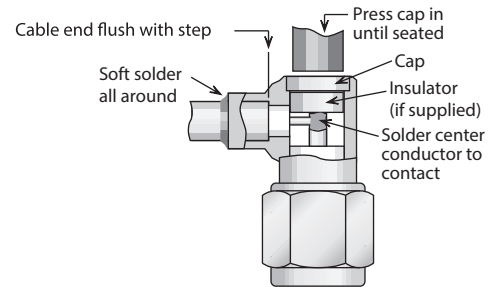


Assembly Procedure J

Trim Codes		
Code	A	B
J/01	.109	.047
J/02	.059	.039
J/03	.059	.079
J/04	.050	.059

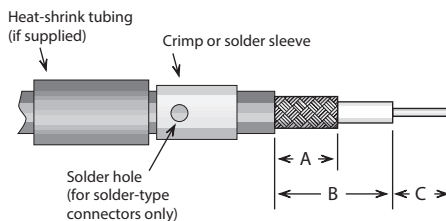


- 1) Trim cable as shown. Remove any burrs from jacket and center conductor.

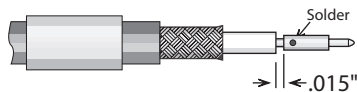


- 2) Soft solder cable jacket to body, making sure that end of cable is flush with step in body. Solder center conductor into contact slot, assemble insulator disc (if supplied), then press cap into body until seated or screw into place.

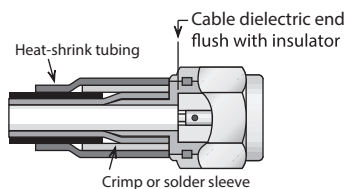
Assembly Procedure K



- 1) Trim cable per chart. Slide crimp (or solder) sleeve and heat-shrink tubing (if supplied) back onto cable.



- 2) Solder contact onto center conductor, fixturing to maintain gap as shown. Flare cut end of braid slightly by rotating dielectric.



- 3) Insert cable/contact into rear of body, with all braid wires on outside of crimp tail. Push cable in until cable dielectric bottoms in connector. Trim excess braid wires even with shoulder of body. Slide crimp sleeve forward until flush with body and crimp (see page 211 for hex die sizes). (For solder-type connectors, solder braid to body and sleeve through hole in sleeve.) Slide heat-shrink tubing into place and shrink with hot-air gun.

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

Trim Codes							
Code	A	B	C	Code	A	B	C
K/01	.250	.270	.110	K/07	.220	.290	.135
K/02	.200	.270	.140	K/08	.420	.620	.090
K/03	.225	.290	.110	K/09	.090	.135	.160
K/04	.225	.330	.110	K/10	.250	.415	.115
K/05	.250	.330	.110	K/11	.250	.400	.150
K/06	.250	.315	.095	K/12	.282	.390	.140