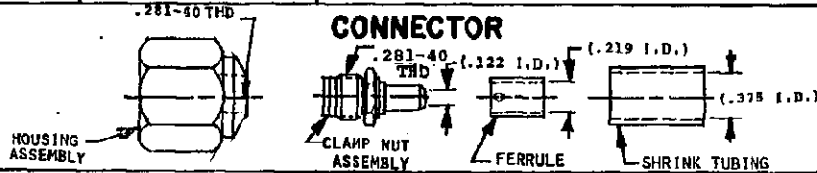


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:	SUPPLIES REQUIRED
RAYTHEON 929017-3 OS 3031-5005-29 SERIES N STRAIGHT CABLE PLUG SOLDER TYPE	5F-142 WITH SOLID CENTER CONDUCTOR	SIDE CUTTERS OR EQUIVALENT SOLDERING IRON THERMO GUN OR EQUIVALENT SMALL FLAT FILE TORQUE WRENCH ADJUSTABLE WRENCH	ISOPROPYL ALCOHOL SOLDER ROSIN CORE 60/40 CUTTING BLADE



ASSEMBLY OPERATIONS

<p>1.0 PREPARE CABLE STEP 1</p> <p>1.1 SLIDE SHRINK TUBING AND FERRULE OVER CABLE JACKET. (NOTE HOLE LOCATION IN THE FERRULE.)</p> <p>1.2 TRIM CABLE TO DIMENSIONS SHOWN. DO NOT SCORE CABLE DIELECTRIC WHEN TRIMMING BRAID. DO NOT CUT ANY STRANDS OF OUTER BRAID WHEN TRIMMING JACKET.</p>	
<p>2.0 PREPARE CABLE STEP 2</p> <p>2.1 FOLD OUTER BRAID BACK TO CABLE JACKET AS SHOWN TO EXPOSE TAPE. DO NOT COMB OUTER BRAID.</p> <p>2.2 REMOVE THE TAPE. DO NOT CUT ANY STRANDS OF THE INNER BRAID. DO NOT COMB INNER BRAID.</p> <p>2.3 PULL OUTER BRAID BACK DOWN OVER INNER BRAID.</p>	
<p>3.0 SOLDER CABLE TO CLAMP NUT ASSEMBLY</p> <p>3.1 FLARE BRAID</p> <p>3.2 SLIDE THE CLAMP NUT ASSEMBLY OVER THE CABLE DIELECTRIC AND UNDER THE INNER BRAID UNTIL MOTION IS RESTRICTED BY THE CABLE JACKET. (NOTE: .100 MIN. DIMENSION)</p> <p>3.3 SLIDE THE FERRULE OVER THE OUTER BRAID UP TO THE SNAP RING ON THE CLAMP NUT ASSEMBLY.</p> <p>3.4 REMOVE ANY STRANDS OF BRAID THAT PROTRUDE BEYOND THE FERRULE. USE SIDE CUTTERS OR EQUIVALENT.</p> <p>3.5 APPLY HEAT TO FERRULE, AND FEED A SUFFICIENT AMOUNT OF SOLDER THROUGH THE HOLES IN THE FERRULE TO FIRMLY SECURE THE BRAID TO THE CLAMP NUT ASSEMBLY AND FERRULE.</p> <p>3.6 REMOVE HEAT AND ALLOW SOLDER JOINT TO COOL. DO NOT ARTIFICIALLY COOL WITH ANY LIQUID. DO NOT DISTURB THE SETUP UNTIL THE SOLDER JOINT IS COOL OR JUST WARM TO TOUCH.</p> <p>3.7 CLEAN SOLDERED AREA WITH ALCOHOL TO REMOVE ANY RESIDUAL FLUX. NOTE: SOLDER JOINT SHOULD WITHSTAND 45 LBS. PULL.</p>	
<p>4.0 ASSEMBLE SHRINK TUBING</p> <p>4.1 POSITION SHRINK TUBING OVER FERRULE TO LOCATION SHOWN.</p> <p>4.2 APPLY HEAT WITH THERMO GUN TO THE SHRINK TUBING UNTIL IT SHRINKS TIGHTLY AROUND THE FERRULE AND CABLE JACKET.</p>	
<p>5.0 PREPARE CABLE END</p> <p>5.1 TRIM THE CABLE DIELECTRIC FLUSH WITH THE FACE OF THE CLAMP NUT ASSEMBLY TO EXPOSE THE CABLE CENTER CONDUCTOR. DO NOT SCORE THE CABLE CENTER CONDUCTOR. TRIM CABLE CENTER CONDUCTOR TO DIMENSION SHOWN AND POINT WITH A SMALL FILE.</p> <p>1.10 CLEAN CABLE END WITH ALCOHOL.</p>	
<p>6.0 COMPLETE CABLE ASSEMBLY</p> <p>6.1 CAREFULLY INSERT THE CLAMP NUT ASSEMBLY INTO THE HOUSING ASSEMBLY.</p> <p>6.2 SCREW THE CLAMP NUT TO THE HOUSING ASSEMBLY AND TORQUE TO 15-20 IN LBS.</p>	