

Figure 1

INTRODUCTION

This instruction sheet covers the assembly procedures for LEPRA/CON Screw-On Series Right-Angle Plugs. See Figure 1.

NOTE
 Dimensions on this sheet are in inches [with millimeters in brackets]. Figures and illustrations are for identification only and are not drawn to scale.

2. Tape or Fused Coatings: Remove with sandpaper, file, or scraping action of razor blade. Do not damage dielectric.

DANGER
 To prevent personal injury, use caution when handling file or razor blade.

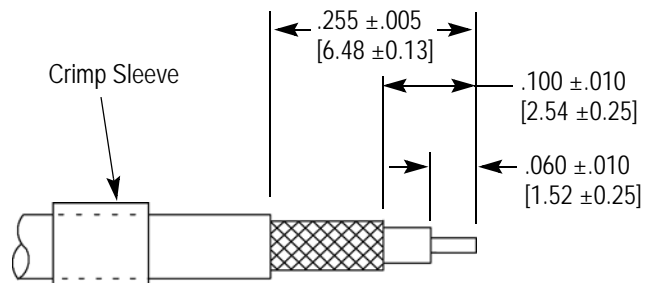
Step 1

Slide the crimp sleeve over the jacket. Strip cable to dimensions shown in Figure 2.

CAUTION
 Be careful not to nick inner conductor or shield.

Note: For assembly to cables with “Mini-Noise” coating, Mini-Noise coating must be removed from surface of cable dielectric as follows:

1. Painted Coatings: Wipe off dielectric surface with a dry cloth. Wipe again using paint thinner or trichloroethane. Do not immerse cable in solvent.



NOTE: Not to Scale

Figure 2

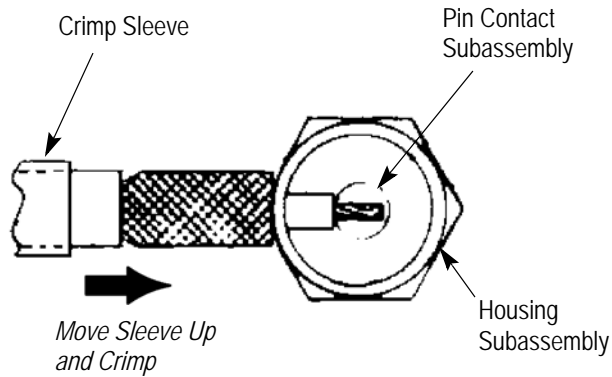


Figure 3

Step 2

Slide pin contact subassembly into housing subassembly. Refer to Figure 3.

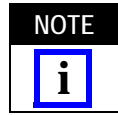
Line up the slot in pin contact subassembly with ferrule on side of housing.

Slide connector ferrule between cable dielectric and shield.

Slide crimp sleeve up to housing body and crimp using TE Connectivity Tool Number 3-1532136-8 (Microdot Tool Number 010-0132-0000) or Thomas & Betts™ Tool Number WT-419D.†

Step 3

Solder inner conductor to pin contact subassembly as shown in Figure 4. Install back-up insulator.



As an option, potting compound may be used in place of back-up insulator.

Put seal disc in place and solder around circumference of seal disc.

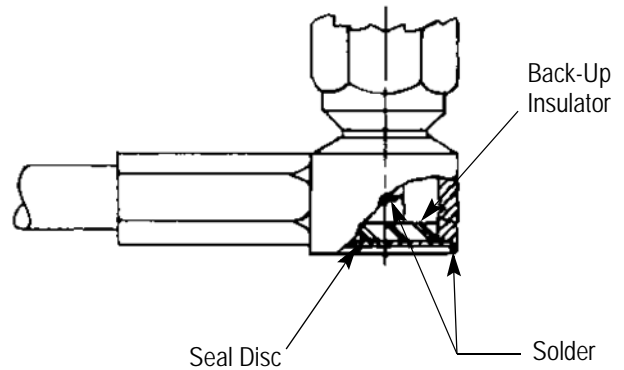


Figure 4

REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.

† Consult manufacturer's literature for current information.