Screw-On Series
Straight Solderless Plugs

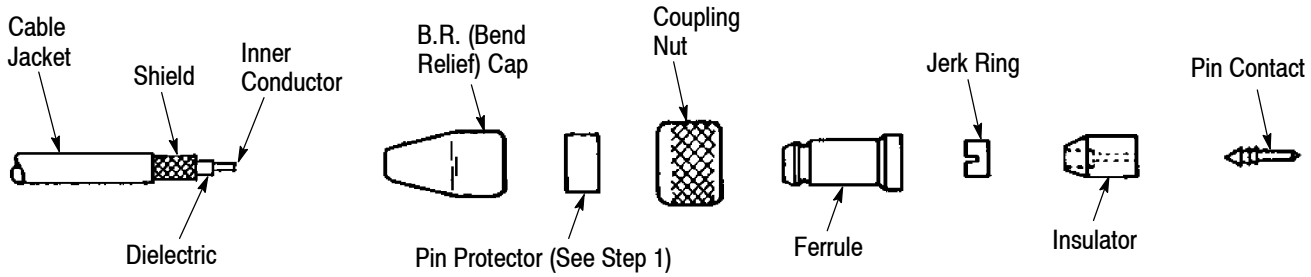


Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly procedures for the Screw-On Series Straight Solderless 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.

CAUTION

SPECIAL HANDLING
Wear rubber gloves when assembling.

Step 1

Slide bend relief cap, nut, and ferrule over cable jacket. See Figure 2.

NOTE

If assembly is supplied with a pin protector, slide it over cable jacket after the bend relief cap.

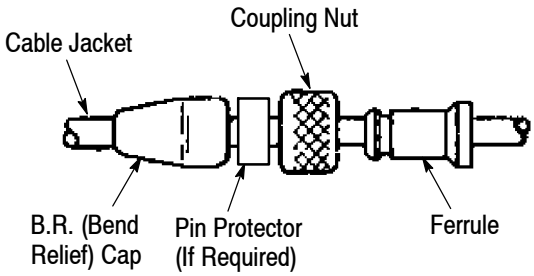


Figure 2

Step 2

Strip cable to dimension shown in Figure 3.

CAUTION

Be careful not to nick 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.

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.

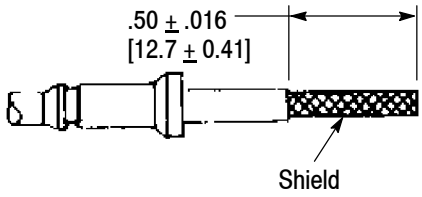


Figure 3

Step 3

Place jerk ring, slotted end first, over the shield. The slotted end butts against the end of the jacket. See Figure 4.

Squeeze the ring snugly around the shield. Squeeze the slotted end of the ring to a slight taper. Use TE Connectivity Tool 4-1532129-2 (MICRODOT* Tool 010-0009-0000) or suitable pliers.

NOTE

Care should be taken to keep the jerk ring round.

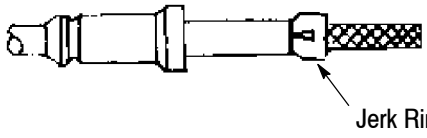


Figure 4

Step 4

Unbraid shield wires and cut close to jerk ring. See Figure 5.

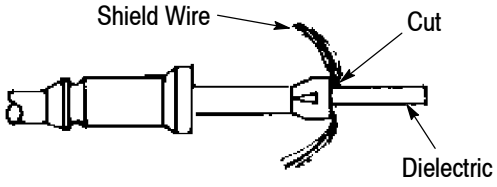


Figure 5

Step 5

Trim end of cable and strip dielectric to dimensions shown in Figure 6.

If inner conductor is stranded, it must be tinned.

CAUTION

Be careful not to nick inner conductor.

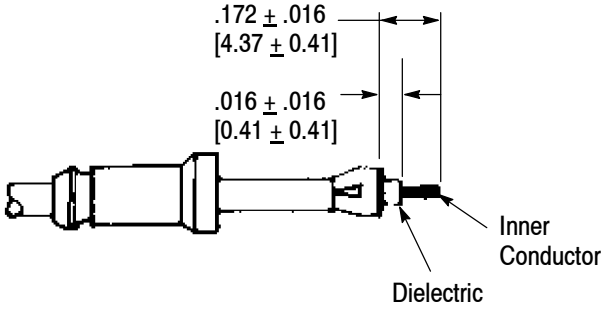


Figure 6

Step 6

Slip PTFE insulator over inner conductor and dielectric until insulator is against shield wires. See Figure 7.

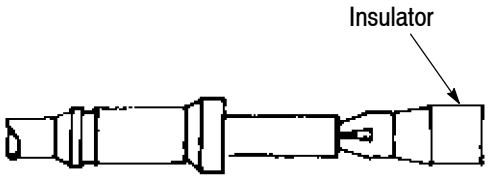


Figure 7

Step 7

Hold ferrule in one hand. With the other hand, push on insulator until jerk ring and part of the insulator start inside the ferrule. See Figure 8.

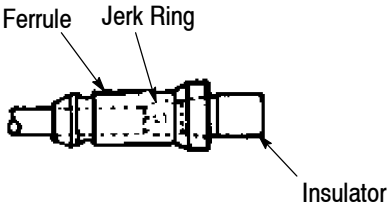
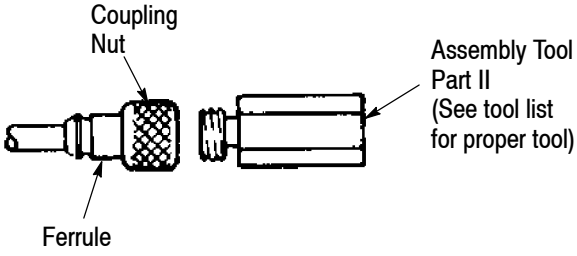


Figure 8

Step 8

Slide coupling nut over ferrule.

Screw coupling nut to Part II on tool until fully seated. See Figure 9.



ASSEMBLY TOOLS		
TE PART NUMBER	**MICRODOT PART NUMBER**	**OHM / THD**
4-1532129-0	010-0003-0000	50 Ohm (.190-32 THD)
3-1532136-2	010-0004-0000	70 Ohm (.216-32 THD)
4-1532129-1	010-0005-0000	93 Ohm (.250-32 THD)

CAUTION: Tools listed are most common. See individual drawings for exceptions.

Figure 9

Step 9

Insert contact pin, with barbed end out, in small hole at the end of Part I.

Screw into Part II as far as possible, forcing contact pin completely into insulator.

Remove Part I and Part II. See Figure 10.

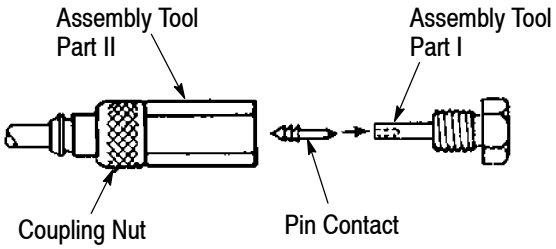


Figure 10

Step 10

Position pin protector, if provided, behind coupling nut.

Bring the bend relief cap up and snap it over groove in ferrule body. See Figure 11.

This completes assembly.

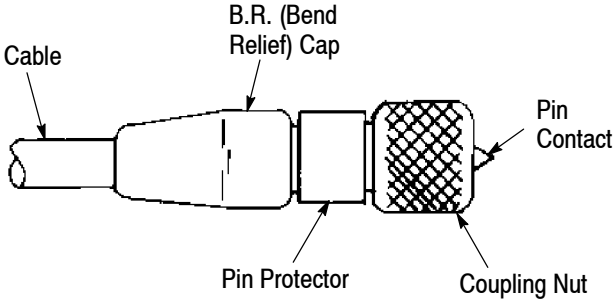


Figure 11

2. REVISION SUMMARY

- Material changed to PTFE