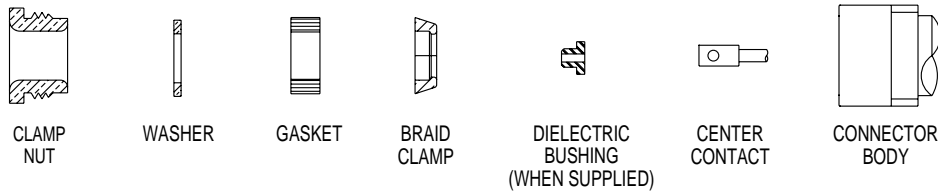


# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE A

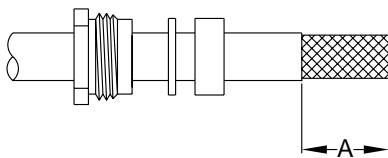


\*For cables RG-62A and 71/U only. When using this dielectric bushing subtract 1/32" from dimension B and add 1/32" to dimension C.

### TRIM DIMENSIONS

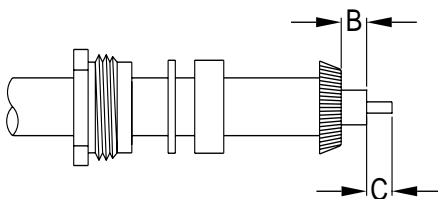
TRIM CODE	A	B	C
01	3/8	7/64	7/64
02	21/32	9/64	7/32
03	5/8	9/64	3/16

### STEP 1



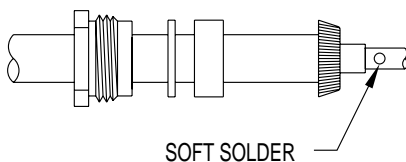
Slide clamp nut, washer and gasket onto cable as shown. Cut off jacket to dimension A as shown.

### STEP 2



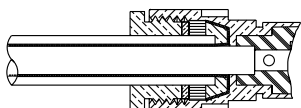
Comb out braid wires. Slide braid clamp over braid, being certain that clamp seats squarely against cut end of jacket. Form braid wires smoothly over clamp as shown and trim off excess braid wire. Cut dielectric to dimension B and conductor to dimension C as shown.

### STEP 3



Place dielectric bushing (if required) into cable dielectric. Seat center conductor firmly against cable dielectric and solder to cable conductor. Remove excess solder from outside of contact.

### STEP 4

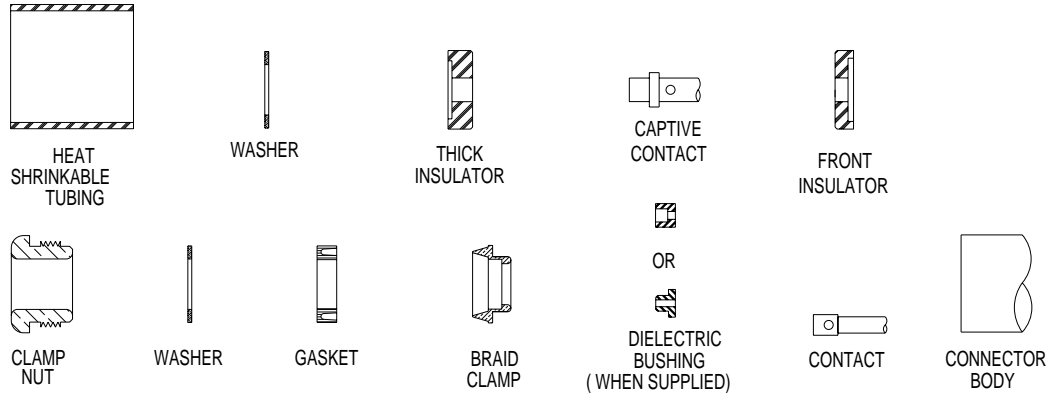


Insert assembly into connector body, being certain that braid clamp is seated. Tighten clamp nut with a wrench.

All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE B



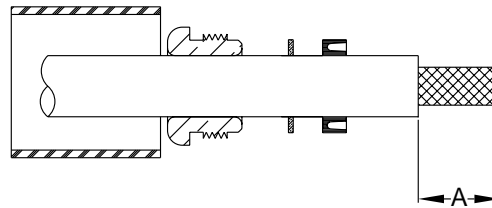
\*For cables RG-174, 188 and 316/U.

\*\*For cables RG-62A and 71B/U only. When using this dielectric bushing, subtract 1/32" from dimension B and add 1/32" to dimension C.

### TRIM DIMENSIONS

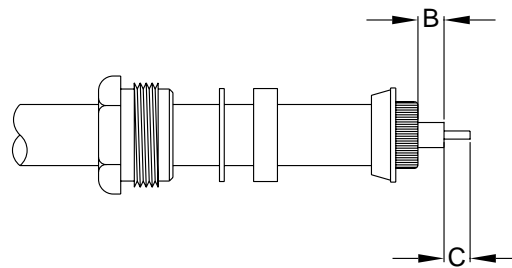
TRIM CODE	A	B	C
01	11/32	7/64	7/64
02	11/32	3/64	5/32
03	5/16	1/16	7/64
04	15/32	3/16	9/64
05	3/8	5/64	5/32
06	13/32	1/8	5/32
07	5/16	3/64	1/8
08	5/8	9/32	7/32
09	13/16	9/32	15/64
10	23/32	15/32	1/8
11	13/16	37/64	7/64
12	13/32	3/64	7/32
13	7/16	7/64	3/16
14	15/32	7/64	7/32
15	13/32	3/32	3/16
16	7/16	1/8	7/32
17	11/16	25/64	5/32
18	3/8	3/64	3/16
19	7/16	1/8	3/16
20	11/32	1/16	7/32
21	7/16	5/64	7/32
22	11/32	3/32	7/64
23	11/32	3/64	5/32
24	7/16	9/64	3/16
25	15/32	7/64	7/32

#### STEP 1



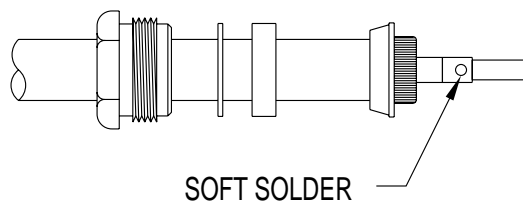
Slide heat shrinkable tubing (if supplied), clamp nut, washer and gasket onto cable as shown. Cut off jacket to dimension A as shown. Be sure v-groove faces away from nut as shown.

#### STEP 2



Comb out braid wires. Slide braid clamp over braid, being certain that clamp seats squarely against cut end of jacket. Form braid wires smoothly over clamp as shown and trim off excess braid wire. Cut dielectric to dimension B and conductor to dimension C as shown.

#### STEP 3

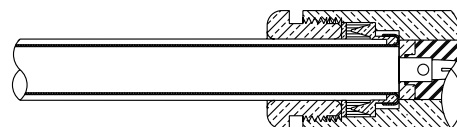


SOFT SOLDER

Place dielectric bushing (if required) over or into dielectric as necessary. Seat center contact firmly against cable dielectric and solder to cable conductor. Remove excess solder from outside of contact. For captive contacts, assemble

washer and thicker insulator, then solder center contact to cable conductor. Then assemble other insulator with counter bore facing slotted or pointed end of contact.

#### STEP 4

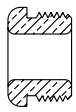


Insert assembly into connector body, being certain that braid clamp is seated. Tighten clamp nut with a wrench.

All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE C

CLAMP  
NUT

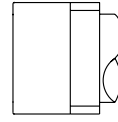
WASHER



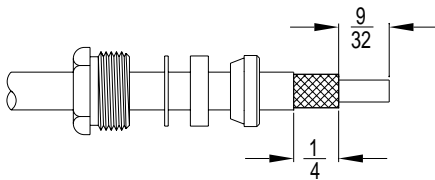
GASKET

BRAID  
CLAMP

FERRULE

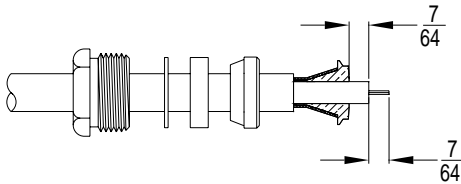
CENTER  
CONTACTCONNECTOR  
BODY

### STEP 1



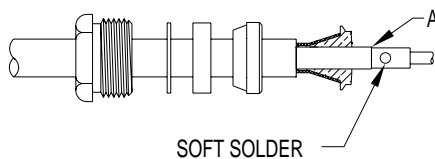
Slide nut, washer, gasket and collar onto cable as shown. Cut off the jacket and braid to dimensions shown.

### STEP 2



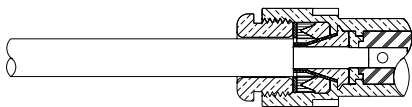
Force ferrule under braid until it stops. Trim off excess braid wires flush with shoulder of ferrule as shown. Cut off dielectric and conductor to dimensions shown.

### STEP 3



Seat center contact firmly against cable dielectric and solder to cable conductor. Remove excess solder from outside of contact.

### STEP 4



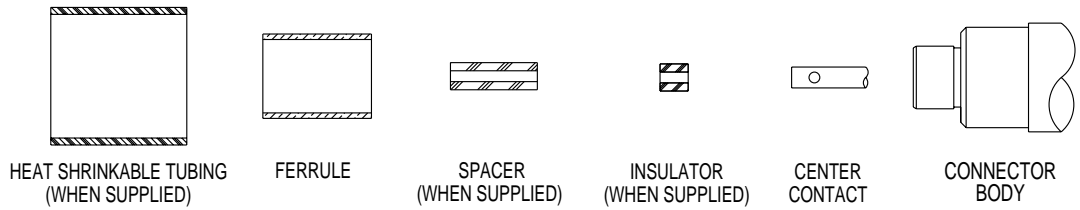
Insert assembly into connector body, being certain that ferrule is seated. Tighten clamp nut with a wrench.

All dimensions in inches

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# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

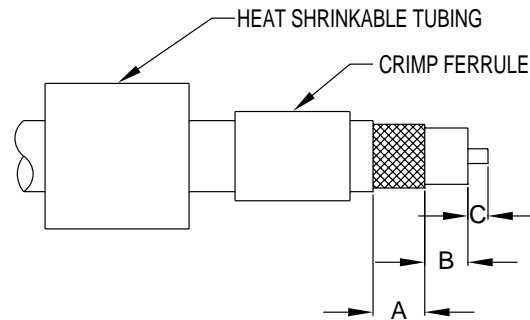
## FIGURE D



### TRIM DIMENSIONS

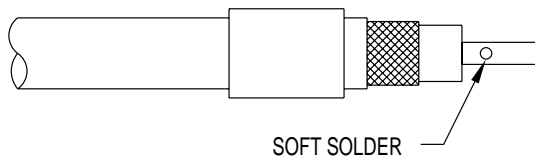
TRIM CODE	A	B	C
01	9/32	15/64	7/64
02	9/32	11/64	7/64
03	5/16	1/2	5/32
04	5/16	1/4	7/32
05	9/32	5/32	3/16
06	5/16	5/32	3/16
07	1/4	7/32	5/32
08	1/4	3/16	5/32
09	1/4	13/64	7/32
10	3/8	3/16	3/16
11	7/8	9/64	9/64
12	5/16	9/64	5/32
13	25/64	17/32	9/32
14	5/16	5/32	5/32
15	11/32	11/64	3/16
16	11/32	19/64	7/64
17	7/32	5/32	5/32
18	9/32	9/32	7/64
19	11/32	17/64	7/64
20	3/8	5/32	3/16
21	3/8	3/32	3/16
22	5/16	1/8	9/64
23	9/32	1/16	3/16

### STEP 1



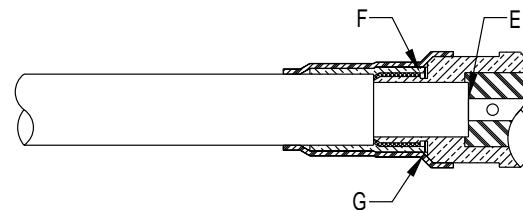
Cut cable to dimensions shown. Slide heat shrinkable tubing (when supplied) and ferrule onto cable as shown.

### STEP 2



Slide cable spacer and insulator (when supplied for small cables) onto the cable center conductor. Seat center contact firmly against cable dielectric and solder to cable conductor. Remove excess solder from outside of contact. If crimp type contact, crimp with proper crimp tool.

### STEP 3

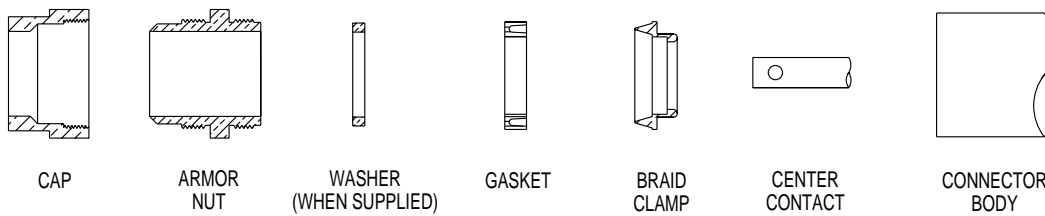


Slide the tapered portion of the connector body over the dielectric and under the braid, until the dielectric butts against the insulator at point E. When contact is undercut captive type insert cable until it snaps into place. Trim excess braid wire even with the body shoulder at point F. Slide ferrule over the braid, butting against body shoulder at point G. Crimp ferrule over braid using proper crimp tool. See page 84 for recommended die cavity sizes. Slide heat shrinkable tubing over ferrule and body shoulder. Shrink with heat source.

All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

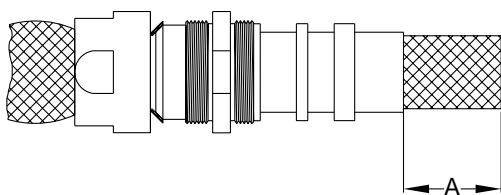
## FIGURE F



### TRIM DIMENSIONS

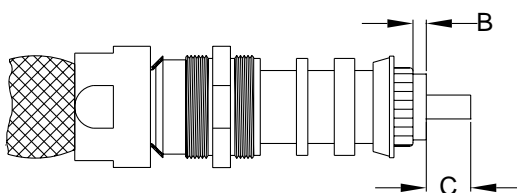
TRIM CODE	A	B	C
01	11/32	3/64	5/32
02	5/16	3/64	1/8
03	5/8	9/32	7/32
04	13/32	3/64	7/32
05	3/8	3/64	3/16
06	2 1/16	1 15/32	1 31/32

### STEP 1



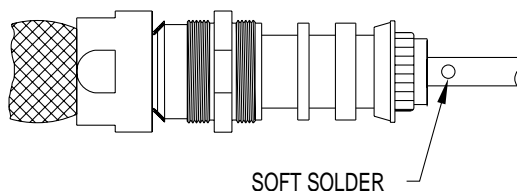
Slide cap over armor. Cut armor back 1 3/32". Bulge armor by pushing back over cable approximately 4". Slide armor nut, washer and gasket over cable jacket as shown, being sure v-groove faces away from nut. Cut off jacket to dimension A as shown.

### STEP 2



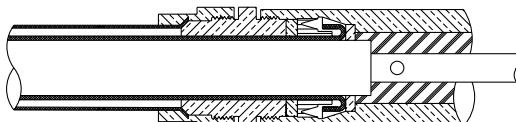
Unbraid and comb out braid wires. Slide braid clamp over braid, being certain that clamp seats squarely against cut end of jacket. Form braid wires smoothly over braid clamp as shown and trim off excess braid wire. Cut dielectric to dimension B and conductor to dimension C as shown.

### STEP 3



Except for trim code 06 seat center contact firmly against cable dielectric and solder to cable conductor. Remove excess solder from outside of contact. For trim code 06 file end of conductor round. Disregard all armor instructions when using RG-17/U cable.

### STEP 4

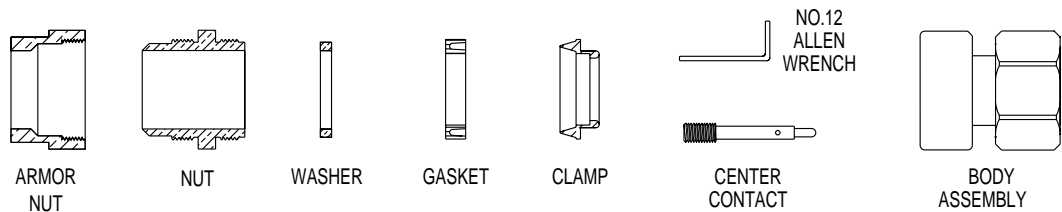


Insert assembly into connector body, being certain that braid clamp is seated. Tighten armor nut with a wrench. Straighten bulge in armor. Cut armor so that it can be clamped between cap and armor nut. Tighten cap onto nut securely with a wrench.

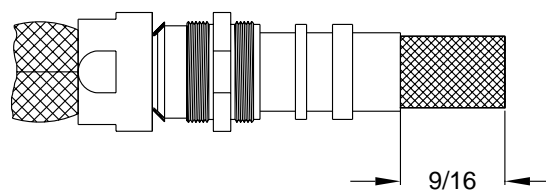
All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE

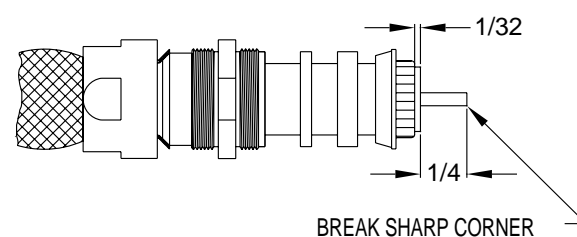


### STEP 1



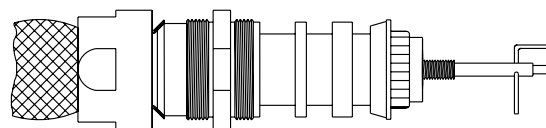
Cut end of cable even. Slide cap over cable armor. Bulge armor braid by pushing armor back on cable 6". Push nut, washer and gasket over cable jacket. Make sure gasket v-groove faces clamp. Remove cable jacket  $\frac{9}{16}$ ". Make sure edge of jacket is evenly cut.

### STEP 2



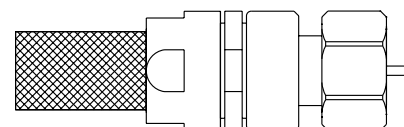
Comb out braid wires. Push clamp over braid and seat on edge of cable jacket. Cut exposed braid so that approximately  $\sim$  remains to form over clamp. Cut cable dielectric  $\frac{1}{32}$ " beyond braid. Cut exposed center conductor to  $\sim$ .

### STEP 3



With the help of an allen wrench as shown, screw self-tapping contact on exposed cable center conductor until it seats firmly against the cable dielectric. Make sure contact is in line with cable center conductor.

### STEP 4

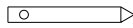


Insert the center contact into the body assembly and screw the body assembly onto it until the cable dielectric seats firmly against the insulator. Then, holding the body stationary, screw and tighten the nut securely with a wrench. Straighten bulge in armor. Cut armor so that it can be clamped between nut and armor nut. Tighten armor nut securely on nut with a wrench.

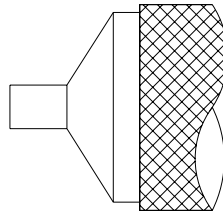
All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE G



CONTACT

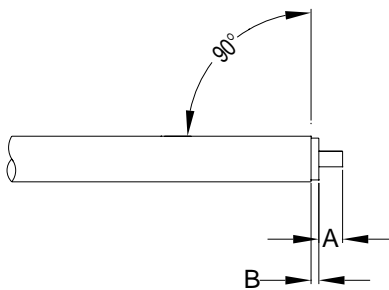


CONNECTOR BODY

### TRIM DIMENSIONS

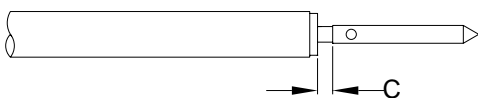
TRIM CODE	A	B	C
01	.125	—	.021
02	.125	.041	—
03	.141	—	.032
04	.100	—	.015

### STEP 1



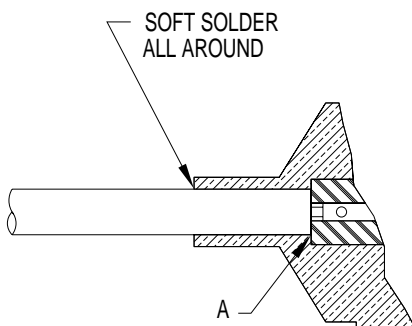
Trim cable jacket and dielectric to dimensions shown. Remove all burrs.

### STEP 2



Soft solder center contact to cable conductor being careful to maintain gap. Seat contact firmly against cable dielectric for trim code 02. Remove excess solder from surface of contact.

### STEP 3

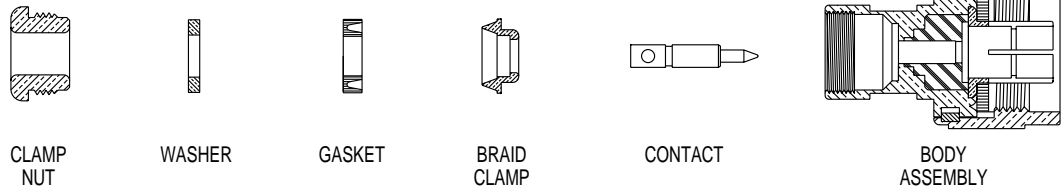


Insert cable and contact into body and seat firmly against the insulator at point A. Soft solder cable to body being careful to leave no voids.

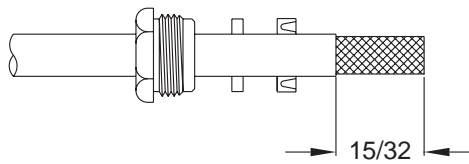
All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE

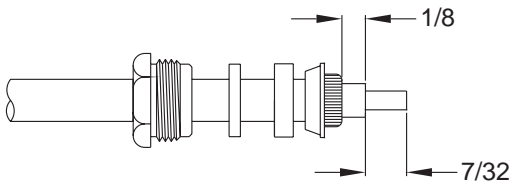


### STEP 1



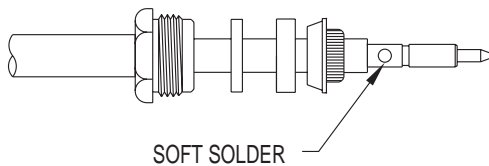
Slide clamp nut, washer (if supplied) and gasket unto cable as shown. Cut off jacket to dimension shown.

### STEP 2



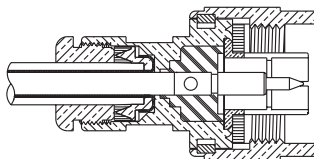
Comb out braid wires. Slide braid clamp over braid, being certain that clamp seats squarely against cut end of jacket. Form braid wires smoothly over clamp as shown and trim off excess lengths of braid wires. Cut dielectric and conductor to dimensions shown.

### STEP 3



Seat center contact firmly against cable dielectric and soft solder to cable conductor. Remove excess solder from outside of contact.

### STEP 4



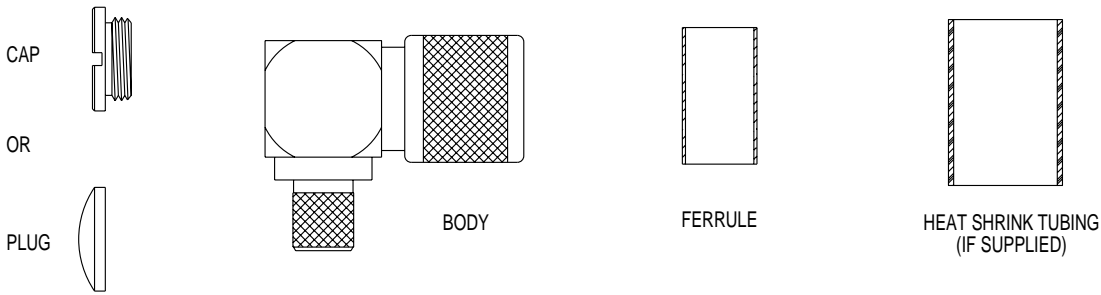
Insert assembly into connector until the contact snaps into place. Be sure the braid clamp is seated, then tighten clamp nut with a wrench.

All dimensions in inches



# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

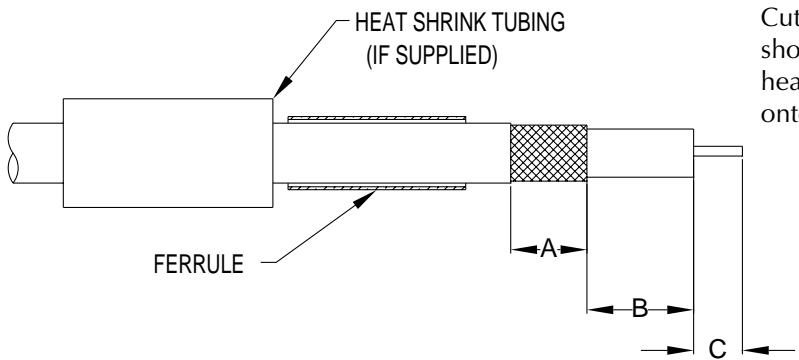
## FIGURE J



### TRIM DIMENSIONS

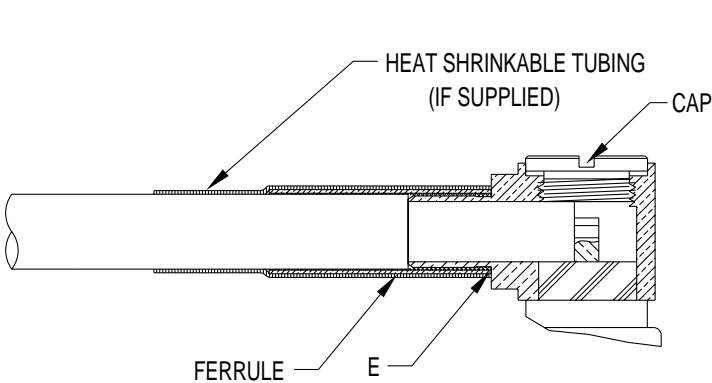
TRIM CODE	A	B	C
01	25/64	21/32	5/32
02	59/64	11/32	11/64
03	3/8	5/16	9/64
04	25/64	27/64	5/32
05	11/32	9/64	1/16

### STEP 1



Cut cable to dimensions shown. Slide ferrule and heat shrinkable tubing onto cable as shown.

### STEP 2



Slide tapered portion of the connector body over the dielectric and under the braid until the braid touches the connector body and the cable conductor is positioned in the connector contact slot. Slide the ferrule over the braid, butting against the body at point E. Crimp ferrule over braid using proper crimp

tool. See page 84 for recommended die cavity sizes. Slide heat shrinkable tubing over ferrule butting it against body and shrink with heat source. Soft solder cable center conductor into contact slot, assembly cap into body.

All dimensions in inches

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# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE K

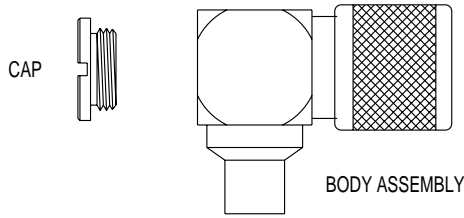


FIGURE 1

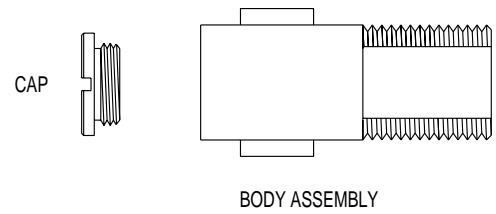
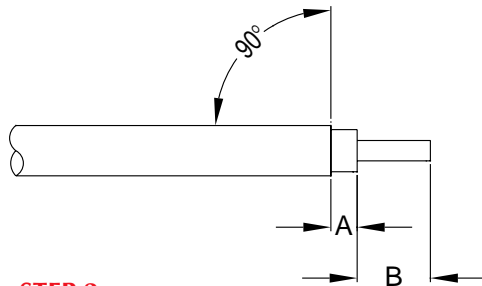


FIGURE 2

### TRIM DIMENSIONS

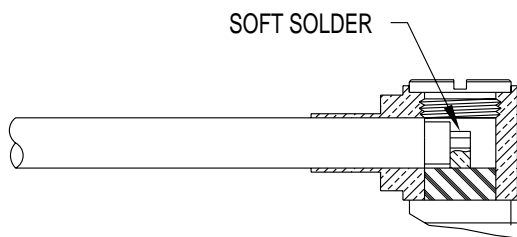
TRIM CODE	FIG.	A	B
01	1	3/16	3/32
02	2	11/64	3/16

### STEP 1



Trim cable jacket and dielectric to dimensions shown. Remove all burrs.

### STEP 2

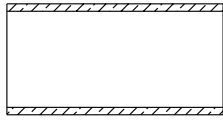


Seat cable jacket firmly against step in body and be sure center conductor is positioned in the center contact slot. Soft solder cable jacket to body and center conductor into slot of contact. Assemble cap into body.

All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

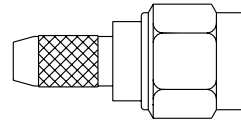
## FIGURE



FERRULE

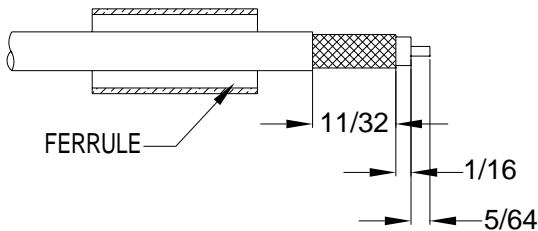


CONTACT



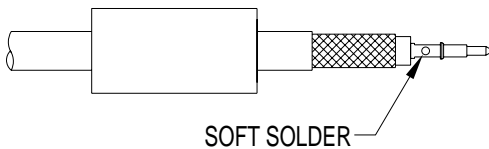
BODY

### STEP 1



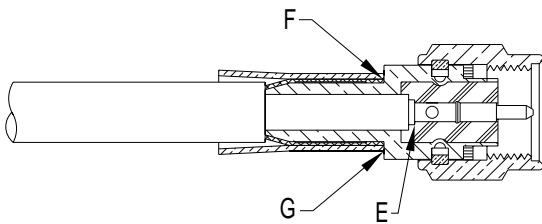
Cut cable to dimensions shown.  
Slide ferrule onto cable as shown.

### STEP 2



Seat center contact firmly against cable dielectric and soft solder to cable conductor. Remove excess solder from outside of contact. If crimp contact, crimp with proper crimp tool. See page 84 for recommended die cavity sizes.

### STEP 3

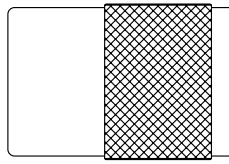


Slide the tapered portion of the connector body over the dielectric and under the braid until the cable dielectric butts against the insulator at point E. When contact is undercut captive type insert the cable until it snaps into place. Trim excess braid wire even with the body shoulder at point F. Slide ferrule over braid, butting it against body at point G. Crimp ferrule over braid using proper crimping tool. See page 84 for recommended die cavity sizes.

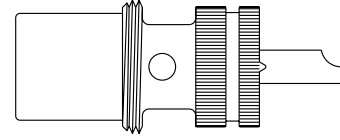
All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

**FIGURE**  
**M**

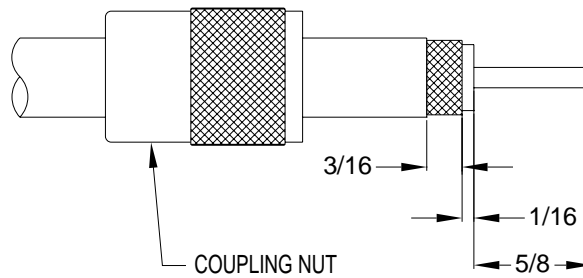


COUPLING NUT



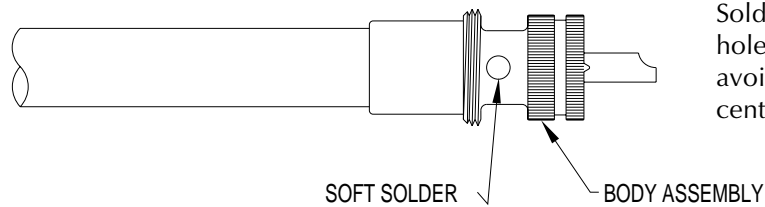
BODY ASSEMBLY

## STEP 1



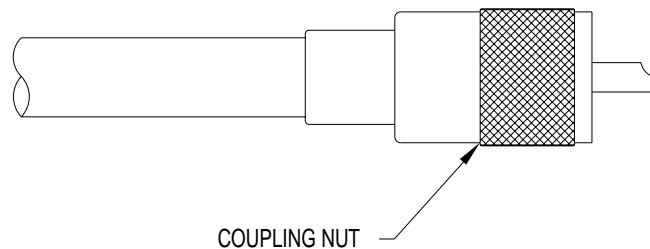
Slide coupling nut on cable. Trim cable to dimensions shown. Tin cable braid and center conductor.

## STEP 2



Screw body onto cable. Solder braid through solder holes. Use minimal heat to avoid damaging cable. Solder center conductor to contact.

## STEP 3

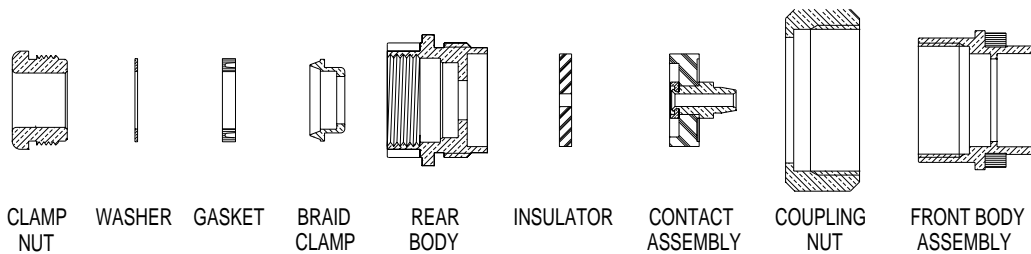


Screw coupling nut over body threads.

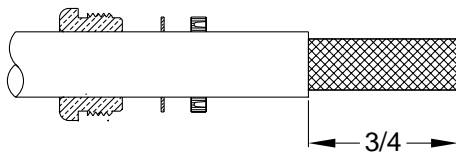
All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE N

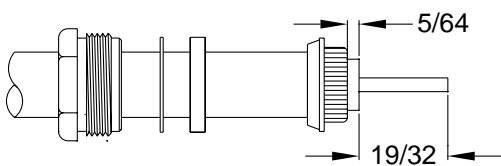


### STEP 1



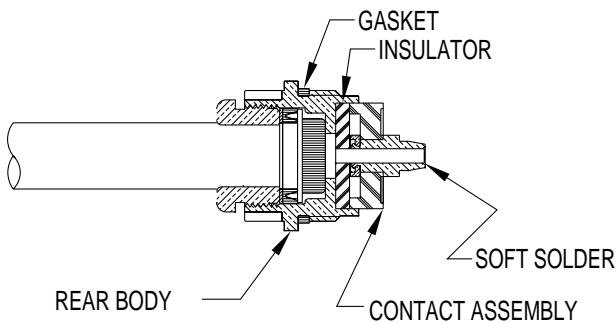
Slide clamp nut, washer and gasket onto cable as shown. Cut off jacket to dimension A. Be sure gasket v-groove faces away from nut as shown.

### STEP 2



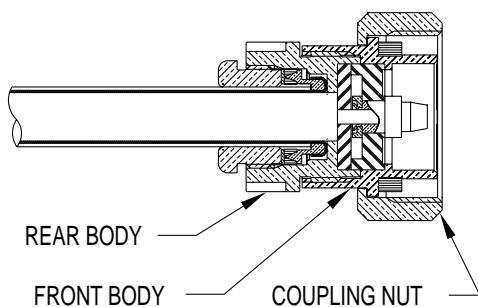
Comb out braid wires. Slide braid clamp over braid, being certain that clamp seats squarely against cut end of jacket. Form braid wires smoothly over clamp as shown and trim off excess lengths of braid wires. Cut dielectric to dimension B and conductor to dimension C.

### STEP 3



Insert assembly into rear body, being certain that braid clamp is seated. Tighten clamp nut with a wrench. Place insulator and contact assembly over cable conductor. Seat firmly against body shoulder and soft solder cable conductor to contact. Assemble gasket onto rear body when supplied.

### STEP 4

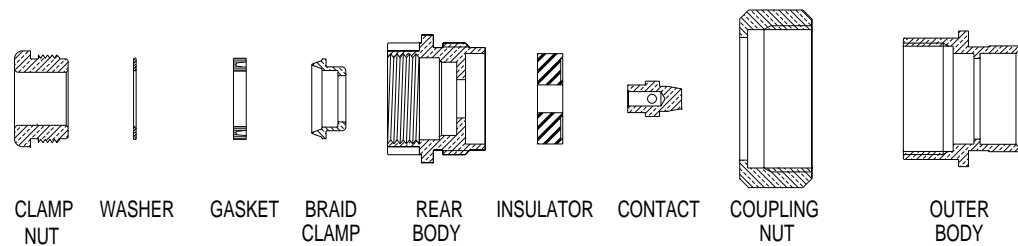


Slide coupling nut onto front body assembly. Carefully insert rear body assembly into front body assembly and tighten securely.

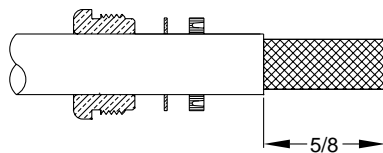
All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE P

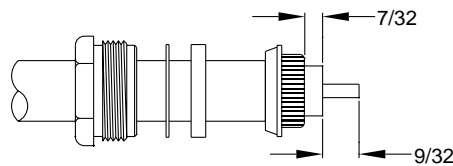


### STEP 1



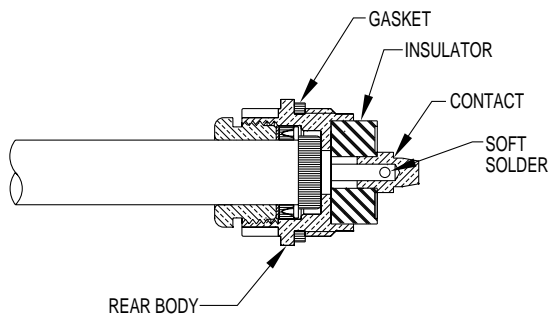
Slide clamp nut, washer and gasket onto cable as shown. Cut off jacket to dimension A. Be sure gasket v-groove faces away from nut as shown if v-groove gasket is used.

### STEP 2



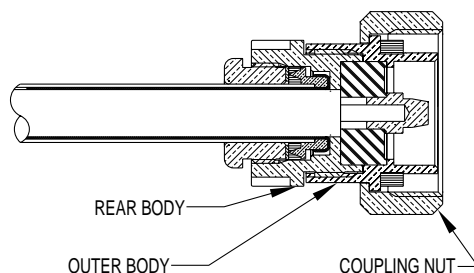
Comb out braid wires. Slide braid clamp over braid, being certain that clamp seats squarely against cut end of jacket. Form braid wires smoothly over clamp as shown and trim off excess lengths of braid wires. Cut dielectric to dimension B and conductor to dimension C.

### STEP 3



Insert assembly into rear body, being certain that braid clamp is seated. Tighten clamp nut with a wrench. Place insulator and contact over cable conductor. Seat firmly against body shoulder and soft solder cable conductor to contact. Assemble gasket onto rear body when supplied.

### STEP 4

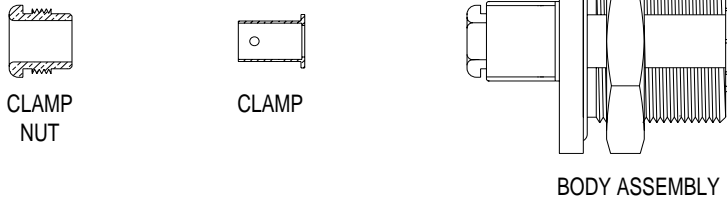


If a plug slide coupling nut onto front body assembly. Carefully insert rear body assembly into front body assembly and tighten securely.

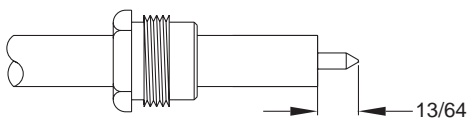
All dimensions in inches

# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE Q

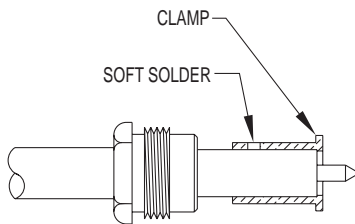


### STEP 1



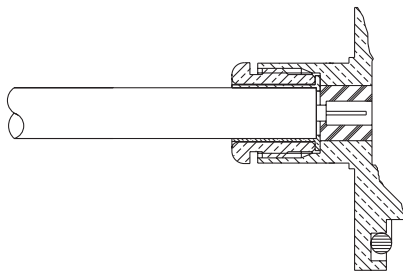
Trim cable jacket to dimension shown. Remove burrs and point the center conductor.

### STEP 2



Insert cable into clamp and seat firmly against the shoulder. Soft solder through cross hole using minimal heat.

### STEP 3



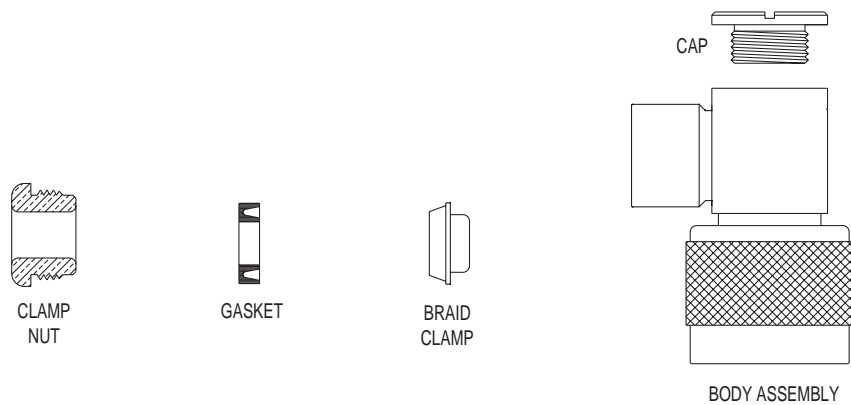
Slide clamp nut over clamp and screw into body. Be certain center conductor enters female contact. Tighten nut securely.

All dimensions in inches

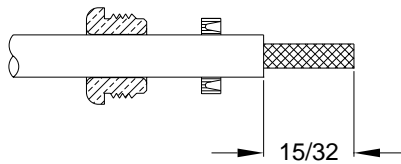
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# RECOMMENDED CABLE ASSEMBLY INSTRUCTIONS

## FIGURE R

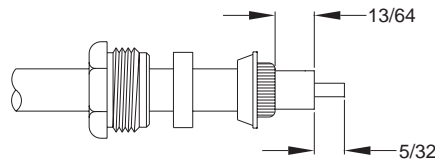


### STEP 1



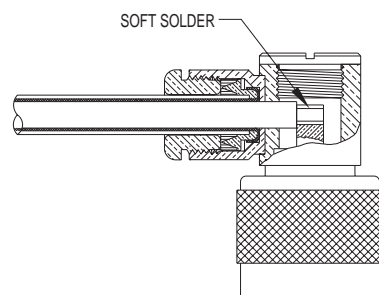
Slide clamp nut and gasket onto cable as shown. Cut off jacket to dimension shown.

### STEP 2



Comb out braid wires. Slide braid clamp over braid, being certain that clamp seats squarely against cut end of jacket. Form braid wires smoothly over clamp as shown and trim off excess lengths of braid wires. Cut dielectric and conductor to dimensions shown.

### STEP 3



Insert assembly into connector being sure center conductor is positioned in the center contact slot. Be sure the braid clamp is seated, then tighten the clamp nut with a wrench. Soft solder conductor into contact slot, then assemble cap into body.