

Assembly Procedure

Procedure Number: AP-00097

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Revision: A

Assembly: Clamp Connectors

Description: General Cable Assembly Instructions

- 1.0– Flush cut the cable squarely.
- 2.0–Slide connector nut over cable.
- 3.0–Next, slide connector washer over cable.
- 4.0–Slide colored rubber gasket over cable.
- 5.0–Use a knife, razor, or Altelicon Coaxial Cable Stripper to remove outer cable jacket. Expose braid to the length suggested in wire/connector specification.
- 6.0–Carefully move braid away from center conductor. Use a knife, razor, or Altelicon Coaxial Cable Stripper to remove center conductor insulation to the length suggested in wire/connector specification.
- 7.0–Debur the center conductor using the Altelicon deburring tool.
- 8.0–Slide connector pin over center conductor. Solder or crimp using Altelicon coaxial crimper.
- 9.0–Straighten out braid back to its original position. Slip connector clamp over braid all the way up to and stopping at the cable jacket.
- 10.0 –Evenly fold back the braid around the connector nut.
- 11.0 –Slide the connector pin attached to the cable all the way into the connector.
- 12.0 –Slide colored rubber gasket snug against clamp.
- 13.0 –Slide connector washer snug against colored rubber gasket.
- 14.0 –Slide connector nut snug against connector washer. Tighten nut turning in a clockwise direction using Altelicon connector wrench.

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