

Assembly Procedure

Procedure Number: AP-00096

Approval Date: 06/24/05

Revision: A

Assembly: Crimp Connectors

Description: General Cable Assembly Instructions

- 1.0– Flush cut the cable squarely.
- 2.0–Slide the heatshrink or strain relief boot over the cable.
- 3.0–Slide ferrule over the cable.
- 4.0–Use a knife, razor, or Altelicon Coaxial Cable Stripper to remove outer cable jacket, braid, and internal insulation per wire/connector specification.
- 5.0–Slide connector pin over center conductor. Solder or crimp using Altelicon coaxial crimper.
- 6.0–Slide the connector pin attached to the cable into the connector. Push it up to the end of the cable jacket and under the braid, rotating back and forth in a clockwise-counter clockwise motion if necessary.
- 7.0–Slide ferrule over braid all the way up to the back of the connector.
- 8.0–Position the Altelicon crimp tool, with the appropriate die, directly behind and adjacent to the connector body over the ferrule, and crimp the connector. The crimp tool will automatically release when the crimp is complete.
- 9.0–Position the heat shrink or strain relief boot as far forward on the connector body as possible without interfering with the coupling nut. Use a heat gun to form a weather-tight seal if using heatshrink.