

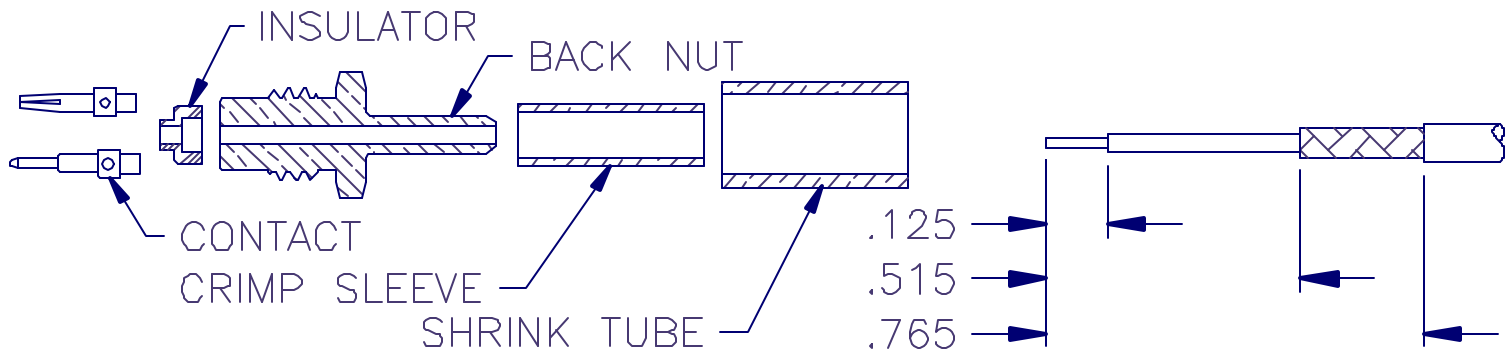


# APPLIED ENGINEERING PRODUCTS

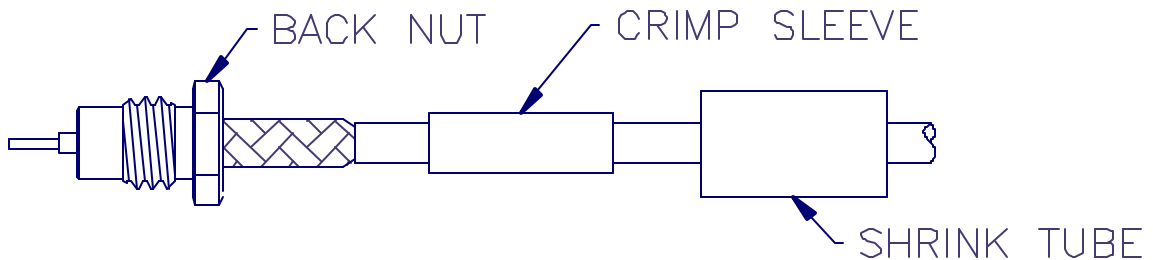
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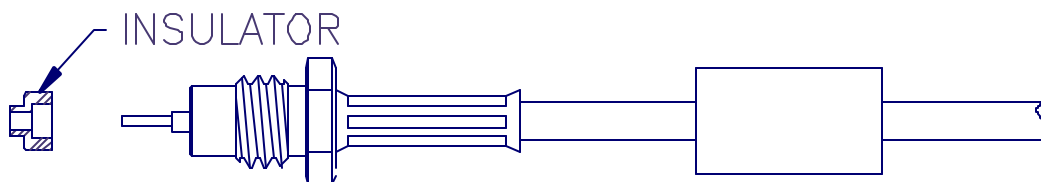
## Assembly Instructions



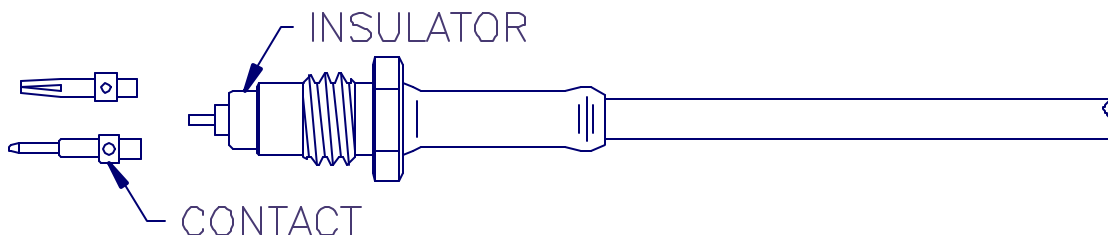
1. TRIM CABLE AS SHOWN. TIN END OF CENTER CONDUCTOR.
2. SLIDE CRIMP SLEEVE AND SHRINK TUBE OVER CABLE JACKET.
3. FLARE CABLE BRAID OUT SLIGHTLY BY ROTATING DIELECTRIC.



4. INSERT CABLE INTO TAIL-END OF BACK NUT, MAKING SURE TAIL GOES OVER DIELECTRIC AND UNDER BRAID. SLIDE IN UNTIL BRAID TOUCHES REAR SURFACE OF NUT.
5. SLIDE CRIMP SLEEVE FORWARD AND USE .128 HEX DIE TO CRIMP.



6. POSITION INSULATOR OVER CABLE DIELECTRIC AND CENTER CONDUCTOR.



7. SOLDER CONTACT TO CENTER CONDUCTOR.
8. INSERT CABLE ASSEMBLY INTO BODY AND TIGHTEN NUT WITH A TORQUE WRENCH WITH A TORQUE OF 140-150 INCH OUNCES.
9. SLIDE SHRINK TUBE OVER CRIMP SLEEVE AND SHRINK FIT.

AIS-244-4B20-2 REV. -