



# APPLIED ENGINEERING PRODUCTS

(203) 776-2813 FAX (203) 776-8294

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## Assembly Instructions

INS/FERRULE SUBASSY

BACK NUT

O-RING

CONTACT

COMPRESSION WASHER

.100

.230

1. TRIM CABLE AS SHOWN. TIN END OF CENTER CONDUCTOR.
2. SLIDE BACK NUT ONTO CABLE.

INS/FERRULE SUBASSY

COMPRESSION WASHER

BACK NUT

3. SLIDE COMPRESSION WASHER OVER THE BRAID UNTIL IT BOTTOMS OUT ON THE CABLE JACKET.
4. FAN OUT BRAID RADIALLY AGAINST THE COMPRESSION WASHER BY ROTATING THE CABLE DIELECTRIC.

INS/FERRULE SUBASSY

5. SLIDE INS/FERRULE SUBASSY ONTO CABLE, OVER DIELECTRIC AND UNDER BRAID. PUSH INTO WASHER UNTIL IT STOPS. IF NECESSARY TRIM EXCESS BRAID FLUSH WITH SURFACE OF COMPRESSION WASHER AND FLANGE OF FERRULE.

O-RING

CONTACT

6. PRESS KNURLED END OF CONTACT INTO INSULATOR OF SUBASSY UNTIL IT SEATS FLUSH AGAINST INSULATOR, THEN SOLDER CONTACT TO CENTER CONDUCTOR.
7. INSTALL O-RING ONTO CONTACT. APPLY THIN FILM OF DOW CORNING FS3452 LUBRICANT TO O-RING PRIOR TO INSERTION OF CONTACT INTO BODY. KEEP CONTACT FINGERS FREE OF LUBRICANT.
8. INSERT CABLE ASSEMBLY INTO BODY AND TORQUE NUT TO 140-150 IN-OZ. CAUTION: TAKE CARE NOT TO DAMAGE CONTACT SEALING O-RING. THIS COULD EFFECT SEAL INTEGRITY.

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