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MINI COAXIAL ITA CONTACT ASSEMBLY

PART # 610 103 115 FOR RG316



TOOLS REQUIRED

Outer Shield Conductor Expanding Tool, Part # 910 121 142
Outer Shield Conductor Forming Tool, Part # 910 121 126
Hex Crimp Tool, Part # 910 101 115
Inspection Depth Gauge, Part # 910 121 157
Calibration Plug, Part # 414 855 103 (included in Part # 910 121 157)
Weight Gauge Kit, Part # 910 121 155
3 oz. weight, Part # 414 852 000 (included in kit Part # 910 121 155)
20 oz. weight, Part # 414 853 000 (included in kit Part # 910 121 155)

ASSEMBLY INSTRUCTIONS

1. Strip wire (**Figure A**).
2. Slide the crimp ring onto the wire (**Figure B**).
3. Turn braid back over outer insulation (**Figure C**).
4. Solder wire into center conductor and clean (**Figure D**). VPC solders per IPC'S J-STD-001.
   NOTE: Center conductor and dielectric must touch.
5. Slide the shield conductor over the center conductor until the center conductor stops in the Teflon® shield (**Figure E**).
   NOTE: Shield conductor and teflon insulator are supplied as an assembly.
6. Turn the braid back toward the front of the shield conductor (**Figure F**). If braid extends beyond shoulder, trim back to face of shoulder.

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Dimensions shown: [millimeters]
inches

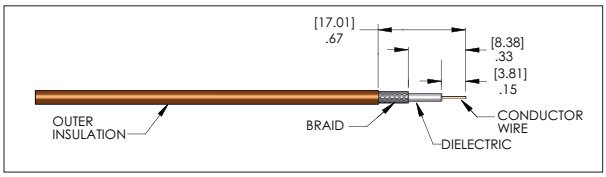


Figure A. Strip wire.

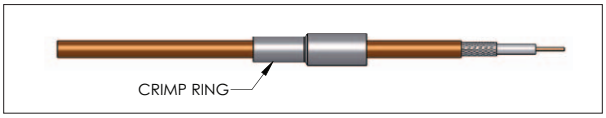


Figure B. Crimp ring.

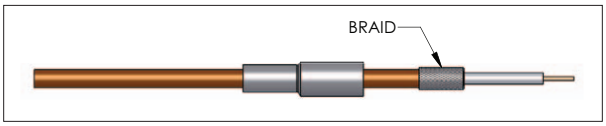


Figure C. Fold braid back.

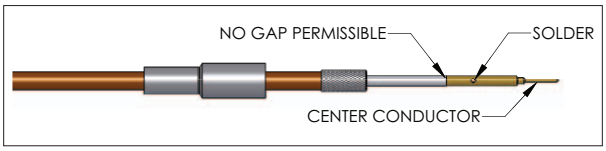


Figure D. Solder center conductor wire.

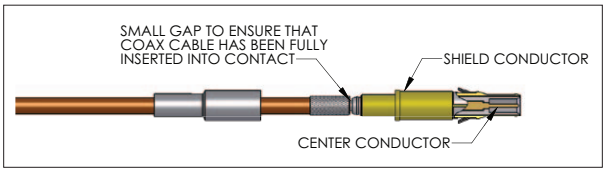


Figure E. Slide shield conductor on.

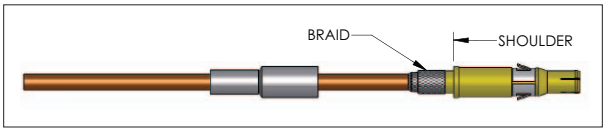


Figure F. Fold braid over.

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ASSEMBLY INSTRUCTIONS, CONTINUED

7. Slide crimp ring into position over the braid (**Figure G**). Do not crimp.

8. Calibrate the Inspection Depth Gauge, Part # 910 121 157 (**Figure H**) by loosening the dial face retaining screw until the dial face allows itself to be turned. Insert the Calibration Plug, Part # 414 855 103 into base of gauge. While keeping constant pressure on the plug, adjust the dial by rotating it such that the pointer points to "0." Re-tighten retaining screw. Adjust locating markers to "20" and "90."

9. Check the .01 [.25 mm] dimension (**Figure J**) with the inspection depth gauge (**Figure H**). Push the contact onto the pressure plunger of the gauge. After attaining a positive stop and while holding firm pressure, push the plunger on top of the dial (to push collar over Teflon), read the dial on the gauge. If the pointer measures between "20" and "90," go to step 10. If the pointer is out of the range, repeat steps 1-9.

10. To ensure proper crimp position, slide shield conductor over the locator pin (**Figure K**). Crimp using the Hex Crimp Tool, Part # 910 101 115 (**Figure L**) in hex position "A" for the larger end first, and in hex position "B" for the smaller section of the crimp ring. Wire must not be allowed to pull on the center conductor during crimping (for example, long wire hanging down to floor).

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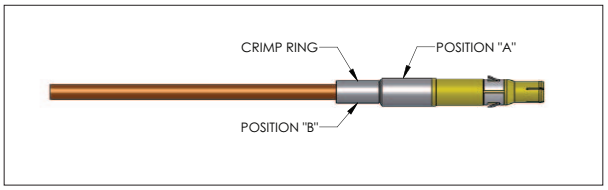


Figure G. Slide crimp ring over braid.

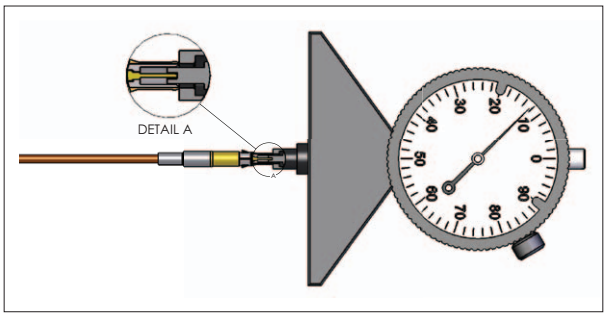


Figure H. Inspection Depth Gauge, Part # 910 121 157.

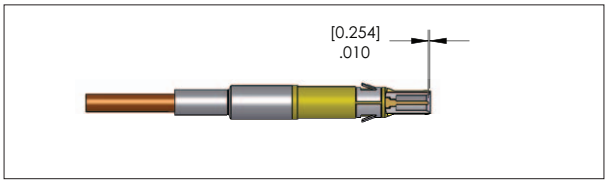


Figure J. Check dimensions.

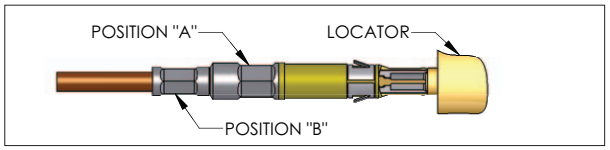


Figure K. Slide shield conductor over pin on locator.



Figure L. Hex Crimp Tool, Part # 910 102 115

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ASSEMBLY INSTRUCTIONS, CONTINUED

11. Check the minimum extraction force of 3 ounces with Part # 414 852 000. Slide contact the weight gauge tip. Insert approximately 0.15" [3.81 mm] into tip. Take care not to insert chamfer of contact the weight gauge tip (**Figure M**). The weight gauge should remain mated with the contact as the contact is slowly lifted and suspended in the air. If weight gauge remains mated move to step 12. If weight gauge falls off, the extraction force is too low and the shield conductor needs to be opened up with the Outer Shield Conductor Expanding Tool, Part # 910 121 142 (**Figure N**). To enlarge the shield conductor, gently insert the enlarging tool into the contact. Be careful not to bend the contact center conductor. Once inserted into the contact, pivot the enlarging tool to increase the shield diameter. Repeat until 3 ounce weight gauge can be held by contact.

12. Check the maximum extraction force of 20 ounces with Part # 414 853 000. Slide contact the weight gauge tip. Insert approximately 0.15" [3.81 mm] into tip. Take care not to insert chamfer of contact the weight gauge tip (**Figure O**). The weight gauge should fall off the contact as the contact is slowly lifted and suspended in the air. If the weight gauge falls off move to step 13. If weight gauge remains mated with contact, the extraction force is too high and the shield conductor needs to be closed with the Outer Shield Conductor Forming Tool, Part # 910 121 126 (**Figure P**). Squeezing the tool handles will reposition the contact legs. This procedure should be done in three different locations (approximately 120° apart) on the same shield to obtain proper sizing. Repeat steps 11 and 12. Do not pass slotted end of contact.

13. Use the inspection depth gauge to verify the .01" [.25 mm] dimension. See step 9.

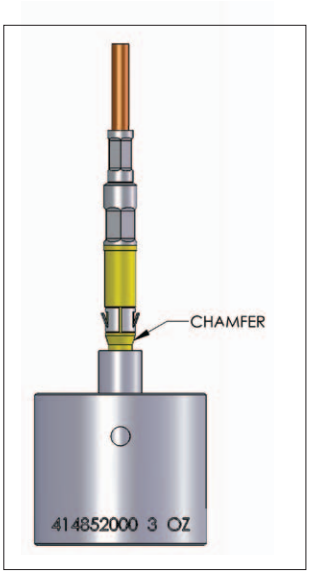


Figure M. Check minimum extraction force with Part # 414 852 000.



Figure N. Outer Shield Conductor Expanding Tool, Part # 910 121 142.

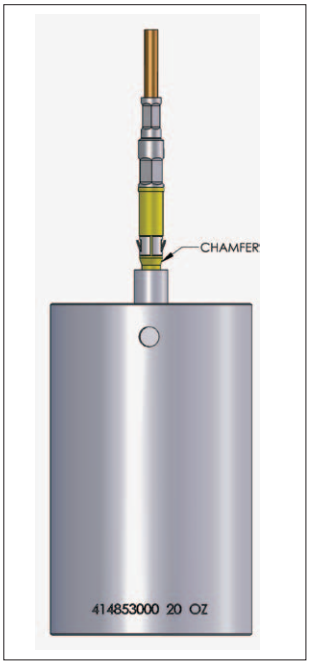


Figure O. Check maximum extraction force with Part # 414 853 000.

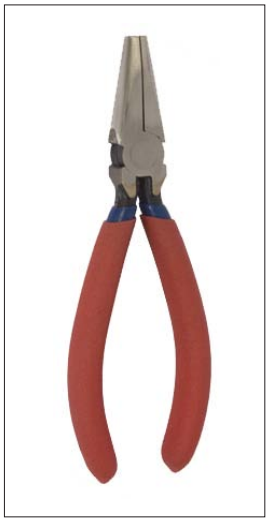


Figure P. Outer Shield Conductor Forming Tool, Part # 910 121 126.

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