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MINI COAXIAL RECEIVER CONTACT ASSEMBLY

PART # 610 104 114 FOR RG316



TOOLS REQUIRED

*Center Conductor Enlarging Tool, Part # 910 121 143
*Center Conductor Forming Tool, Part # 910 121 119
Hex Crimp Tool, Part # 910 101 115
Inspection Depth Gauge, Part # 910 121 156
Calibration Plug, Part # 414 854 104 (Included in Part # 910 121 156)
*Weight Gauge Kit, Part # 910 121 131
4.0 oz. Weight, Part # 432 026 000 (included in Part # 910 121 131)
0.5 oz. Weight, Part # 432 025 000 (included in Part # 910 121 131)

Dimensions shown: [millimeters]
inches

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 center conductor wire into center conductor contact and clean (**Figure D**). VPC solders per IPC'S J-STD-001.
NOTE: Center conductor contact and dielectric must touch.
5. Slide shield conductor over center conductor until the center conductor stops in the Teflon® shield (**Figure E**).
NOTE: Shield conductor and Teflon insulator are supplied as an assembly.

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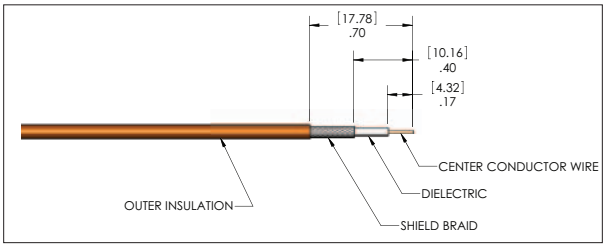


Figure A. Strip wire.

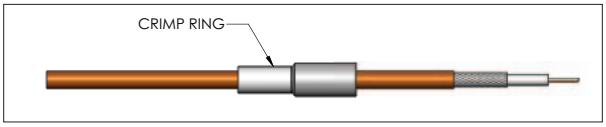


Figure B. Crimp ring.

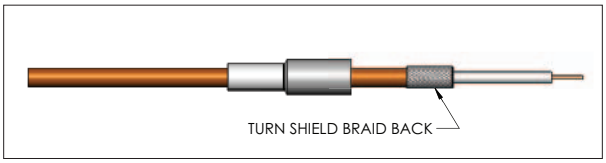


Figure C. Turn braid back.

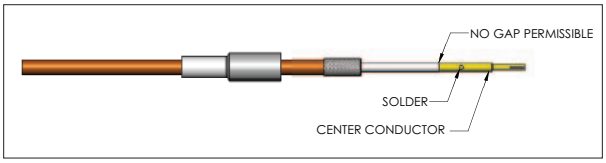


Figure D. Solder center conductor.

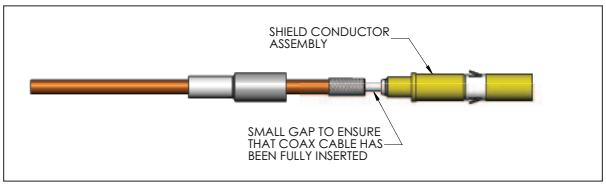


Figure E. Slide shield conductor over center conductor.

*When soldering, care must be taken so as to not deform the center conductor tip. If soldered properly, steps 8 and 9 can be skipped.

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MINI COAXIAL RECEIVER CONTACT ASSEMBLY

PART # 610 104 114 FOR RG316

ASSEMBLY INSTRUCTIONS, CONTINUED

6. Calibrate the Inspection Depth Gauge, Part # 910 121 156 (**Figure F**), by loosening the dial face retaining screw until the dial face allows itself to be turned. Insert the Calibration Plug, Part # 414 854 104, into the base of the gauge. While keeping constant pressure on the plug, adjust the dial by rotating it such that the pointer points to "0." Re-tighten the retaining screw. Adjust locating markers to "40" and "80."

7. Check the .06" [1.52 mm] dimensions with the inspection depth gauge (**Figure F**). 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 "40" and "80," go to step 8. If the pointer is out of range, repeat steps 1-6.

*8. Check the minimum extraction force of 0.5 ounce with Part # 432 025 000. Slide female center conductor over approximately $^{3}/_{4}$ of the length of the tip in the weight gauge (**Figure G**). The weight gauge should remain mated with the center conductor as the center conductor is slowly lifted and suspended in the air. If the weight gauge remains mated, move to step 9.

   If the weight gauge falls off, the extraction force is too low and the center conductor needs to be closed with the Center Conductor Forming Tool, Part # 910 121 119 (**Figure H**). Recheck the 0.5 ounce retention force.

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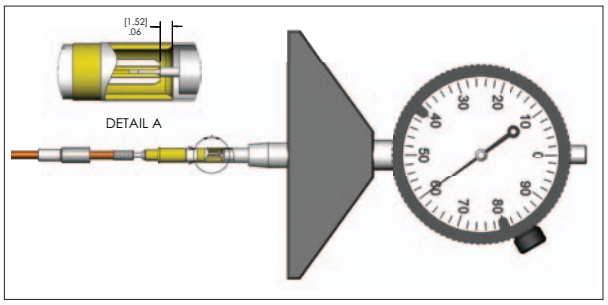


Figure F. Inspection Depth Gauge, Part # 910 121 156.

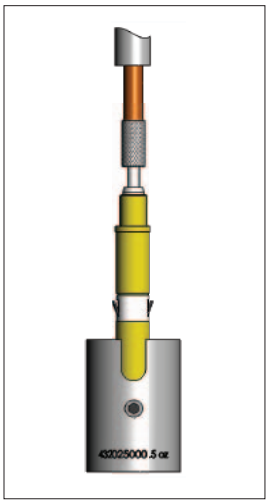


Figure G. Check minimum weight with Part # 432 025 000.



Figure H. Center Conductor Forming Tool, Part # 910 121 119.

*When soldering, care must be taken so as to not deform the center conductor tip. If soldered properly, steps 8 and 9 can be skipped.

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MINI COAXIAL RECEIVER CONTACT ASSEMBLY

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ASSEMBLY INSTRUCTIONS, CONTINUED

*9. Check the maximum extraction force of 4 ounces with Part # 432 026 000. Slide the female center conductor over approximately $^{3}/_{4}$ of the length of the tip in the weight gauge (**Figure J**). 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 10. If weight gauge remains mated with the contact, the extraction force is too high and the center conductor needs to be opened with the Center Conductor Enlarging Tool, Part # 910 121 143 (**Figure K**).

EXERCISE CAUTION WHEN USING THIS TOOL. INSERT AND REMOVE TOOL IN-LINE WITH CONTACT TO AVOID BREAKING TIP OF TOOL OR CONTACT.

To enlarge the center conductor, gently insert the enlarging tool into the center conductor. Pivot the enlarging tool to increase the diameter. Recheck 0.5 and 4 ounce retention force as in step 8.

10. Turn the braid back toward the front of the shield conductor (**Figure L**). If the braid extends beyond the shoulder, trim the braid back to the face of the shoulder.

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

12. Use the inspection depth gauge to verify the .06" [1.52 mm] dimension. See step 7.

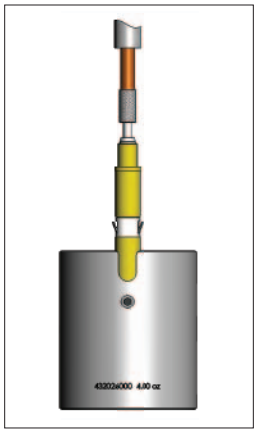


Figure J. Check maximum weight with Part # 432 026 000.



Figure K. Center Conductor Enlarging Tool, Part # 910 121 143.

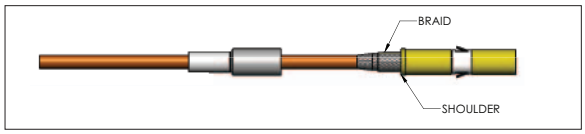


Figure L. Braid turned over shield conductor.

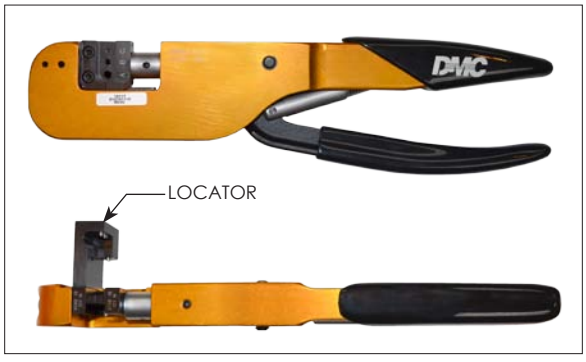


Figure M. Hex Crimp Tool, Part # 910 101 115.

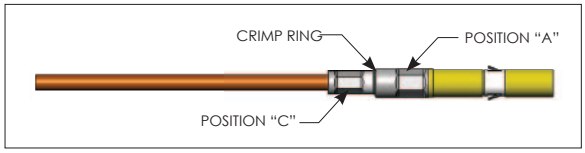


Figure N. Crimp positions.

*When soldering, care must be taken so as to not deform the center conductor tip. If soldered properly, steps 8 and 9 can be skipped.

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