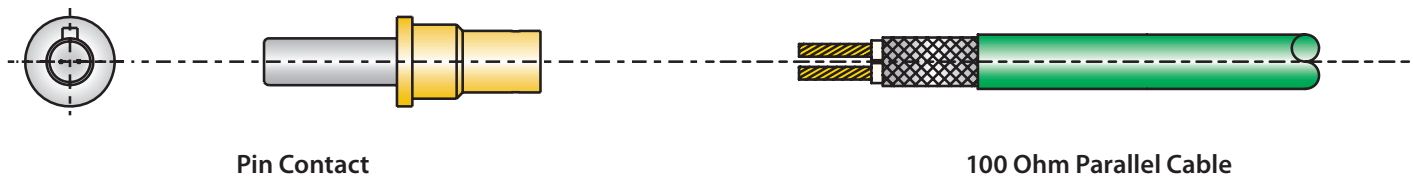


AI85015
Twinax Pin Contact
Assembly Instructions



STEP 1	
<ol style="list-style-type: none"> Strip cable to dimensions shown. Be careful not to flare braid open. Pre-tin conductor and braid shield. Clean the solder joint with alcohol. 	
STEP 2	
<ol style="list-style-type: none"> Insert cable into pin contact. Make sure center conductor lines up to the center pin. 	
STEP 3	
<ol style="list-style-type: none"> Install center conductors until they bottom-out in the contact cavity. Inspect to ensure cable shield is visible through the inspection hole. Apply flux and solder through the inspection hole; remove residues and contamination with alcohol after soldering. 	
STEP 4	
<ol style="list-style-type: none"> Install M23053/5-204 or M23053/6-204 shrink tubing; cover solder area and extend insulation by minimum of one wire diameter. 	
STEP 5	
<ol style="list-style-type: none"> Illustrates final assembly. 	

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