Assembly Instructions NMR-300 Connector

1.0 PREPARATION OF CABLE:
1.1 TRIM CABLE TO DIMENSIONS SHOWN. THE CABLES OUTER JACKET, INNER CONDUCTOR, & INNER BRAIDS SHOULD BE 90° FROM CENTERLINE. CARE SHOULD BE TAKEN NOT TO NICK CABLE DIELECTRIC, INNER CONDUCTOR, OR INNER BRAIDS DURING THIS OPERATION.
1.2 INSPECT CABLE PREPARATION TO DIMENSIONS SHOWN.

2.0 SOLDERING OF FERRULE TO CABLE OUTER CONDUCTOR:
2.1 SLIDE CLAMP NUT ONTO CABLE AS SHOWN BELOW IN STEP 5.0 (ENLARGED VIEW).
2.2 TIN INNER BRAIDS OF CABLE. HEAT SOLDER FERRULE AND SLIDE IT OVER CABLE UNTIL IT BOTTOMS COMPLETELY ON CABLE SHOULDER (CABLE JACKET).
2.3 USING A RESISTIVE SOLDERING IRON, SOLDER FERRULE AS SHOWN USING 60/40 SOLDER (BOTH SIDES).
2.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.

3.0 PREPARATION OF CABLE INNER CONDUCTOR:
3.1 TRIM DIELECTRIC FLUSH TO SURFACE "A". CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
3.2 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°/90° CONE.
3.3 INSPECT CABLE PREPARATION.

4.0 SOLDERING OF CONTACT TO INNER CABLE CONDUCTOR:
4.1 PLACE SOLDER SHIM ON CENTER CONDUCTOR RESTING FIRMLY AGAINST SOLDER FERRULE.
4.2 TIN INNER CONDUCTOR OF CABLE. HEAT CONTACT AND SLIDE IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST SHIM.
4.3 USING 60/40 SOLDER, SOLDER CONTACT AS SHOWN.
4.4 INSPECT & REMOVE EXCESS SOLDER. CLEAN WITH SOLVENT.

5.0 INSTALLATION OF CABLE/FERRULE SUB-ASSEMBLY:
5.1 PLACE CABLE / FERRULE SUB-ASSEMBLY INTO THE BACK OF CONNECTOR SUB-ASSEMBLY BODY. CARE SHOULD BE TAKEN NOT TO BEND OR DAMAGE INNER CONDUCTOR OR INSULATOR OF CONNECTOR.
5.2 SLIDE CLAMP NUT OVER CABLE TO BODY & TIGHTEN CLAMP NUT TO 15 INCH-POUNDS. INSPECT INTERFACE DIMENSIONS.

5.0 ENLARGED VIEW OF CABLE ASSEMBLY: