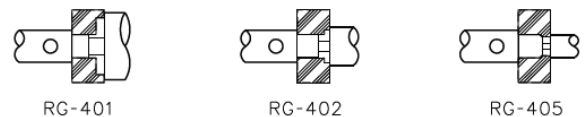
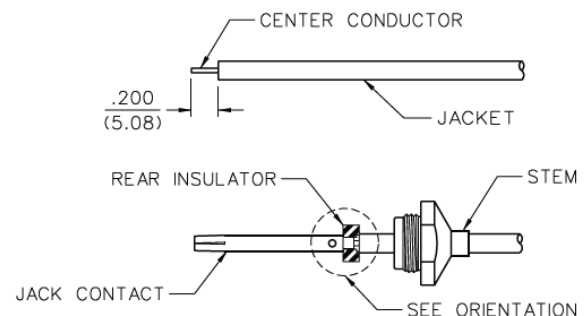
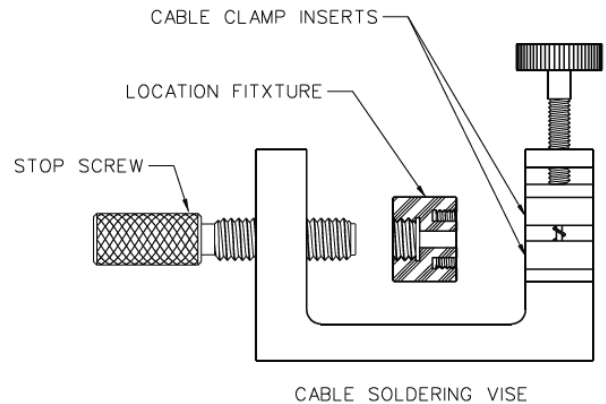
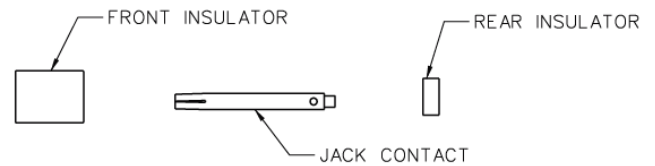
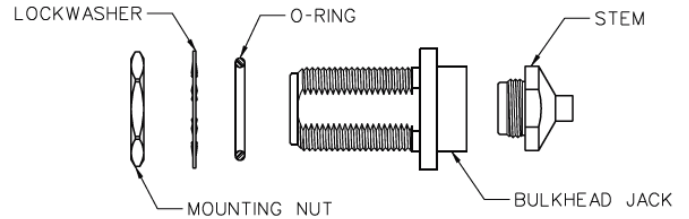
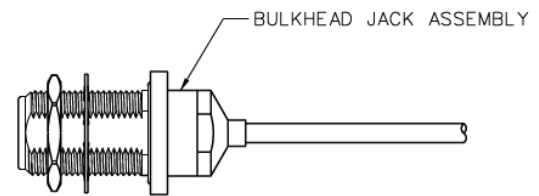
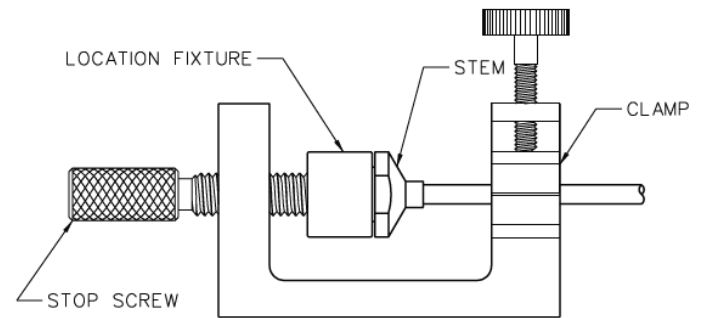
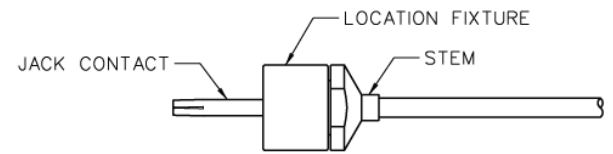
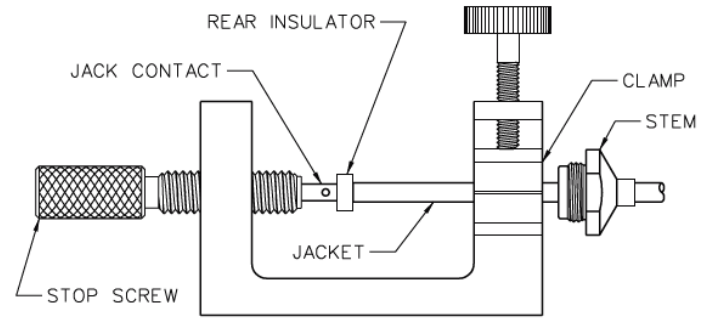


Type N Bulkhead Jack Solder Style for Semi-Rigid Cable

1. Identify connector parts (8 piece parts) and tools (4 piece parts).
2. Strip cable jacket and dielectric to dimension shown. Do not nick center conductor. Clean all debris from cable.
3. Slide stem over cable jacket, keeping stem correctly oriented to end of cable.
4. Insert jack contact into rear insulator. Make sure insulator is correctly oriented to contact. Place jack contact and rear insulator onto center conductor, keeping insulator correctly oriented between cable jacket and contact.
5. Slide stem away from jack contact. Insert contact into stop screw and clamp cable in vise. Tighten stop screw until light pressure is applied between jack contact, rear insulator and cable jacket.
6. Solder jack contact to center conductor through solder hole using .020 (.051) diameter flux core solder wire. Use a minimum amount of solder for a good joint.
7. After solder joint has cooled, remove cable from vise and remove any excess solder from jack contact with a sharp blade and clean all debris from contact and rear insulator.
8. Slide stem over rear insulator and tighten stem into location fixture until stem bottoms out.
9. Insert cable into vise, but do not clamp. Insert jack contact into stop screw and tighten location fixture until stop screw bottoms out. Clamp cable in vise.
10. Solder stem to cable jacket, using a minimum amount of solder for a full fillet joint. Allow assembly to cool before removing from vise.
11. After solder joint has cooled, un-clamp cable and remove location fixture from stop screw and cable assembly. Insert front insulator into bulkhead jack body. Insert cable assembly into body and tighten to 25-30 in-lbs.
12. Add gasket, lock washer and mounting nut when installing connector to panel.



Type N Bulkhead Jack Solder Style for Semi-Rigid Cable (cont'd from last page)



Cable Group	Part No.
RG-405, .086 Semi-Rigid	138-4593-401
RG-402, .141 Semi-Rigid	138-4594-401
RG-401, .250 Semi-Rigid	138-4596-401

Assembly			
Tool	138-4593-401	138-4594-401	138-4596-401
Stop Screw	140-0000-972	140-0000-972	140-0000-972
Cable Vise	140-0000-962	140-0000-962	140-0000-962
Clamp Inserts	140-0000-964	140-0000-965	140-0000-986
Location Fixture	140-0000-987	140-0000-988	140-0000-989