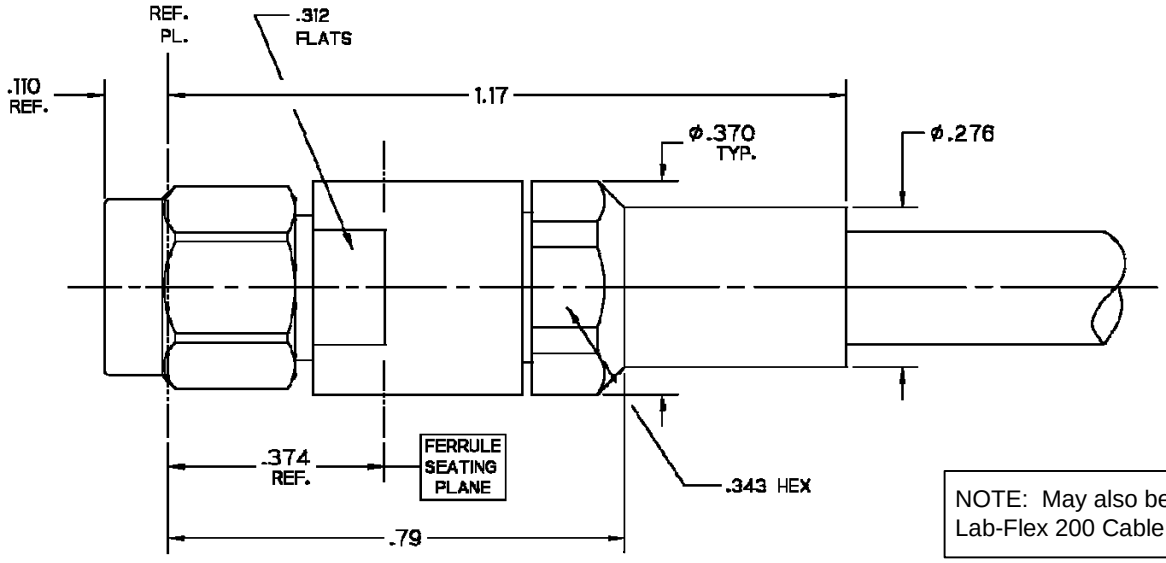
CRYSTEK MICROWAVE
A DIVISION OF CRYSTEK CORPORATION

2.92mm Plug to Solder Clamp for Harbour LL142 Cable



NOTE: May also be used with Times Lab-Flex 200 Cable.

NOTES:

1.0 Materials

1.1 Body, Coupling, and Clamp Nuts: Steel. Corrosion Resistant per ASTM-A582. UNS No. S30300.

1.2 Center Conductor: Beryllium Copper per ASTM-B196. UNS C17300.

1.3 Solder Ferrule: Brass per ASTM-B16. UNS C36000.

1.4 Lock Ring: Beryllium Copper per ASTM-B197. UNS C17200.

1.5 Gasket and O-Ring: Silicone Rubber per A-A-59588.

1.6 Dielectric Bead: Polyphenylene Oxide (NORYL) per ASTM-D4349.

1.7 Cable Stop: Polyetherimide Thermoplastic (ULTEM 1000) per ASTM-D5205.

2.0 Finishes

2.1 Center Contact and Solder Ferrule: Gold Plate per ASTM-B488 50 Microinches Min. thickness over Electrolytic Nickel Plate per ASTM-B689 50 Microinches Min. thickness.

2.2 Body, Coupling, and Clamp Nuts: Passivated per SAE-AMS-2700.

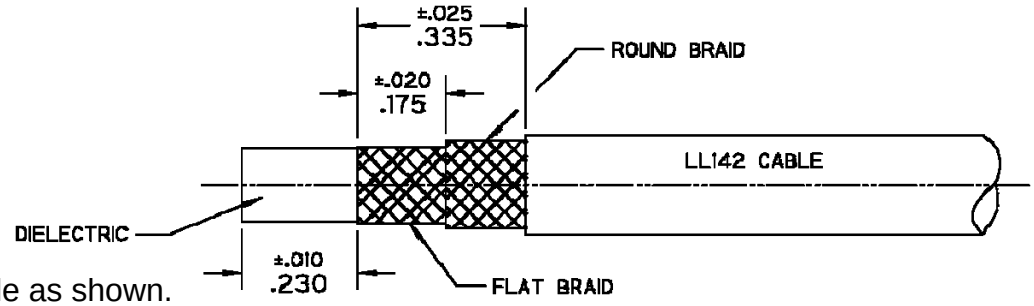
2.3 Gasket, O-Ring, Lock Ring, and Dielectrics: None.

3.0 Interface per CC-2.92mm-Pin.

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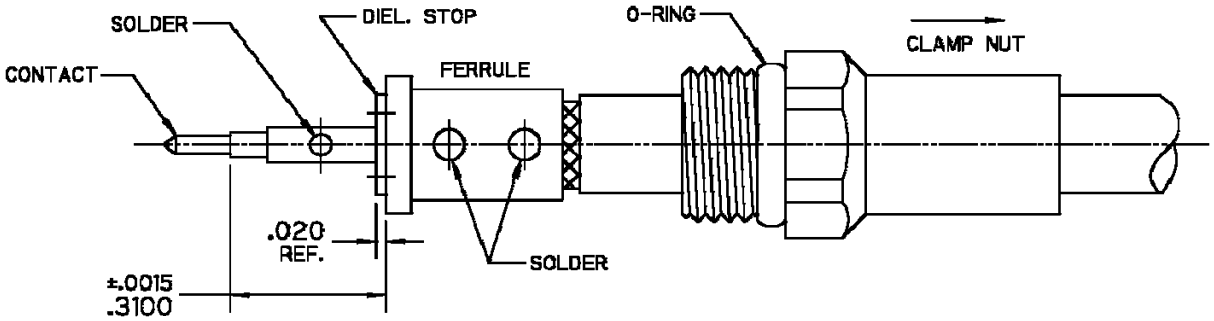
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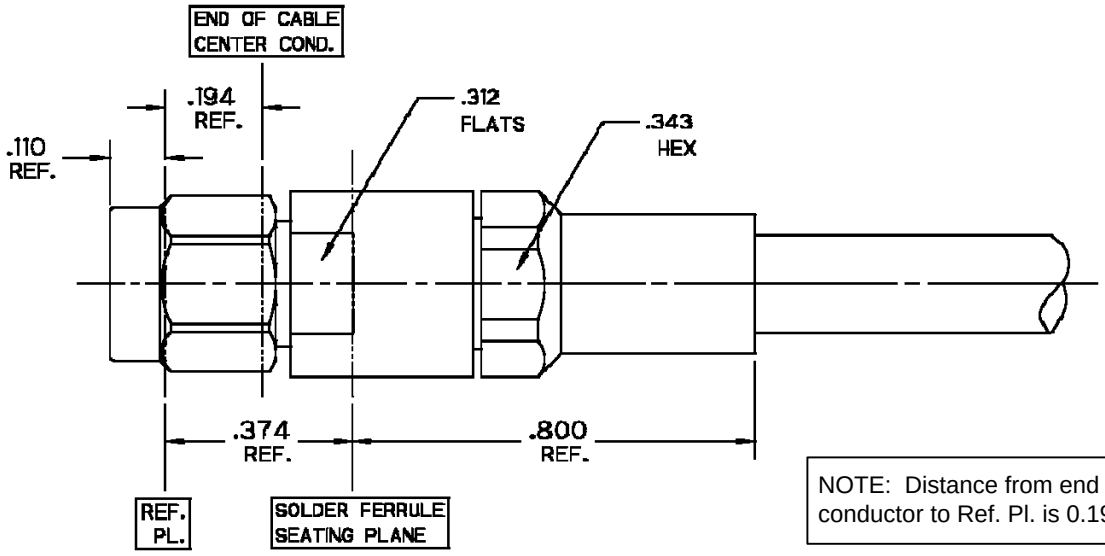
Step 1

1.1 Trim Cable as shown.



Step 2

2.1 Slide clamp nut over cable in orientation shown.
2.2 Insert cable into solder ferrule until inner braid seats and solder to braids where shown.
2.3 Trim cable dielectric flush with face of ferrule.
2.4 Slide dielectric stop over cable center conductor and solder contact flush to stop to dimension shown.



NOTE: Distance from end of cable center conductor to Ref. Pl. is 0.194 (Ref)

Step 3

3.1 Insert cable/contact sub-assembly into connector until seated and tighten clamp nut to 25-35 in-lbs.

Product Control:

Crystek Part Number:	CS-FM-MHA	Release Date:	04-Jan-11
Revision Level:	A	Responsible:	K. Piotrowicz

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