TERMINATION FOR KS-20864, L3, L4 AND SIMILAR COMMERCIAL TYPE 90 DEGREE COAXIAL CONNECTORS

CONTENTS

1. GENERAL

1.1 This section covers the general requirements for the preparation of coaxial cable used with the 90 degree KS-20864L3, L4 and similar commercial type connectors.

1.2 The requirements covered in this section shall be followed except as modified by applicable specifications and drawings.

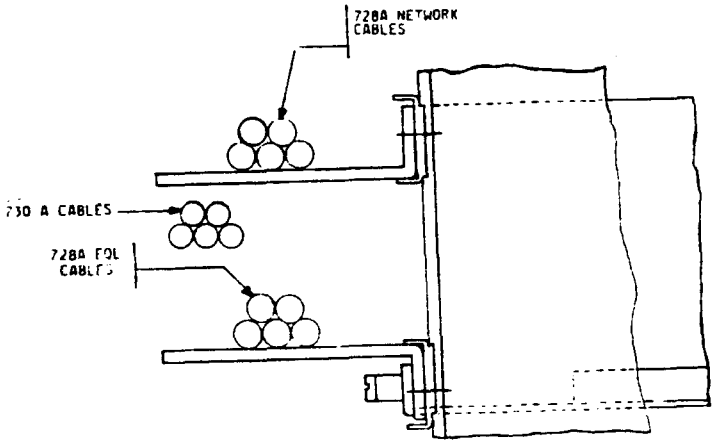
2. INSTALLING EQUIPMENT

2.1 In addition to the tools and supplies ordinarily required for the preparation of coaxial cable the following is required.

AMT	CODE	DESCRIPTION
1	R-4877	Coaxial Cable Stripper
1	KS-22386,L1	Cap Inserter
1	R-4121	Soldering Station or Equivalent
-	RM-728226	Solder - 60% Tin/40% Lead or Equivalent
1	R-4081	Crimping Tool
Copy	-	Handbook 9 Section 730A

3. CONNECTOR ASSEMBLY

3.1 As specified on job order, all cables should be run into bay, at panel position and cut to length.



3.2 Prepare cable ends for termination per Figure 1 using R-4877 Coaxial Cable Stripper - refer to Handbook 9 Section 730A for stripper setting. Refer to step 1 figure.

3.3 When cable end is prepared bring the cable end to the termination point and take unterminated right angle connector in your hand. Position the connector on the cable end so that it lines up pointed at its termination location on the panel free of strain (TWIST).

3.4 Crimp connector using R-4081 Detail 3 position -16. Refer to step 2 figure.

NOTE: To minimize cable strain and/or cable tension it is important that the connector is facing into panel and mating connector before crimping.

This requirement must be followed or memory of the cable will cause excessive strain on right angle connector and its center conductor. Quality auditors will demerit terminations not following this requirement.

3.5 Solder center conductor in connector per step 3 figure. Place connector cap using Tool Cap Inserter KS-22386,L-1 per step 4 figure.

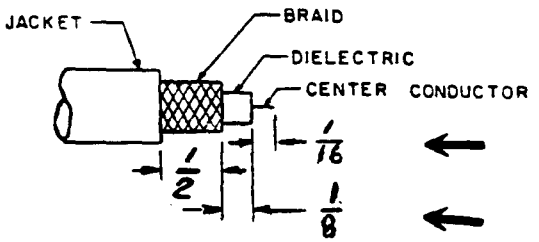
4. VERIFICATION ITEMS

4.1 Installer should verify the following items as in progress quality checks of his work:

(a) Center conductor of coaxial cable should be pretined before cable is terminated to right angle connector.
(b) Tool KS-22386L1 Cap Inserter should be used to place circular caps onto right angle connector.
(c) Right angle connector and coaxial cable should be terminated to each other per paragraph 3.4 so that there is no strain on this connection. If this requirement is not met, the connection should be reterminated.

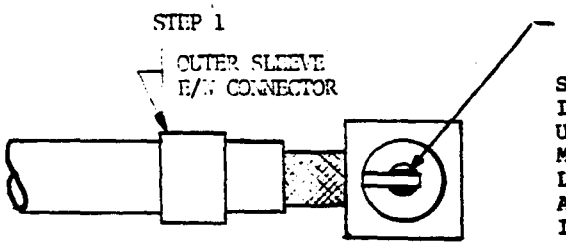
Printed in U.S.A.

(d) Coaxial cables should be secured to the bay shelf as shown in Figure 2 of this section.



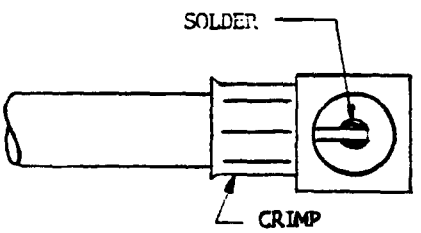
TRIM CABLE TO DIMENSIONS SHOWN. DO NOT NICK, BRAID OR CENTER CONDUCTOR TIN CENTER CONDUCTOR

STEP 1



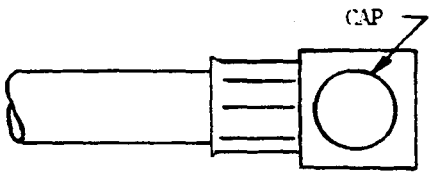
SLIDE OUTER SLEEVE OVER CABLE. INSERT CABLE ONTO BODY INNER UNTIL BRAID BUTTS TO BODY MAKING SURE CENTER CONDUCTOR LOCATES IN CENTER PIN SLOT AND ALL BRAID IS OUTBOARD OF BODY INNER.

STEP 2



CRIMP OUTER SLEEVE USING R-4081 DET 3-16 CRIMPING TOOL AND THEN SOLDER CENTER CONDUCTOR - DO NOT USE EXCESSIVE SOLDER

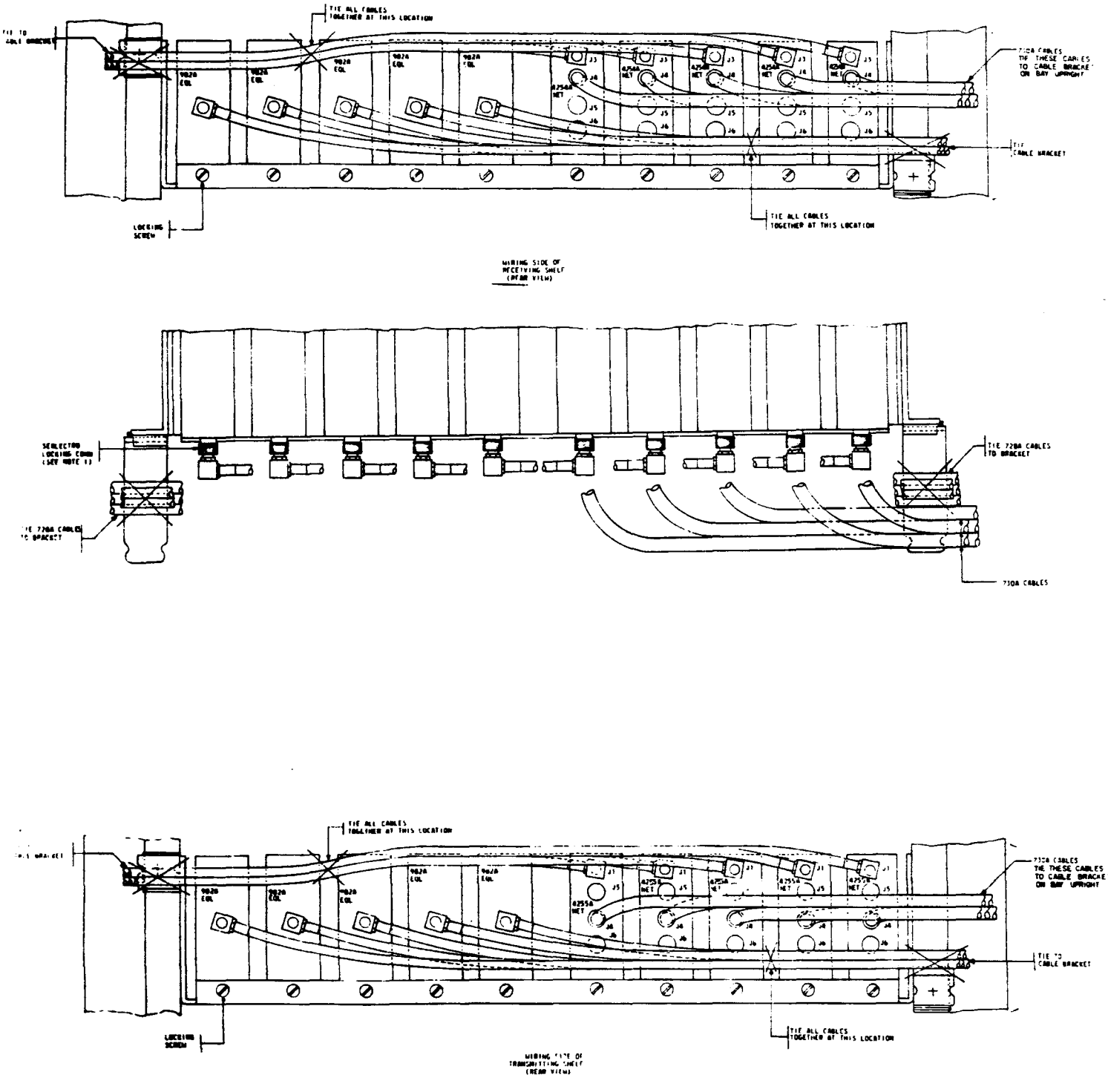
STEP 3



ADD CAP TO SEALECTRO CONNECTOR AND SET USING KS-22386, L-1 CAP INSERTER. INSERT CONNECTOR INTO KS TOOL SO THAT THE CAP END OF CONNECTOR IS FACING THE SOLID JAW OF THE TOOL. SQUEEZE TOOL, CAP IS SET.

STEP 4

FIGURE 1 ←



REASON FOR REISSUE:
To change cable preparation dimensions of Figure 1.

FIGURE 2

Mananger, Engineering Transmission Products