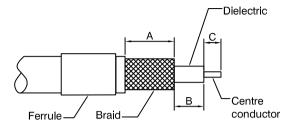
Assembly Instructions

1) Slide the ferrule onto the cable. Strip the cable to the dimensions shown. Take care not to nick the centre conductor or braid.

A = 7.5 mm

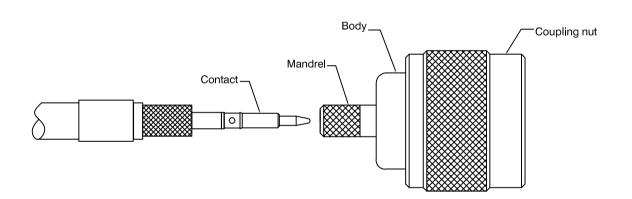
B = 4.5 mm

C = 4mm

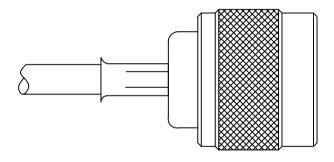


Connector	Stripping Tool	Crimp Tool	Hex Size	
Part Number	Part Number	Part Number	Contact	Ferrule
VN10-2019	N/A	CCC2561	Solder	10.9
VN10-2020	N/A	CCC2561	Solder	10.9
VN10-2020-1602	N/A	CCC2561	Solder	10.9
VN10-2021	N/A	CCC2561/1	Solder	10.9
VN10-2031	N/A	DCC1113	Solder	6.48
VN10-2031-1602	N/A	DCC1113	Solder	6.48
VN10-2050	N/A	DCC1113	Solder	5.41
VN10-2050-1603	N/A	DCC1113	Solder	5.41
VN10-2050/1	N/A	DCC1113	Solder	5.41
VN10-2051	N/A	DCC1113	Solder	5.41

2) Solder the contact onto the centre conductor.



3) Insert the contact into the body and ensure that the contact captivates. Make sure the braid is on the outside of the mandrel. Slide the ferrule over the braid until the ferrule butts up against the body. Crimp the ferrule using the correct tool for the connector.



Deleted VN10-2142	мѕ	6	21 Jan 13
Added VN10-2142	KA	5	27 May 08
Changed assembly instruction	AT	4	23 Feb 05
Crimp tool and hex changed for VN10-2021	SN	3	02 Jan 01
CAD Issue	SN	2	26 Sept 01
First Issue	AT	1	02 Nov 98
DESCRIPTION OF REVISION	APPVD	ISS	DATE



Cinch Connectivity Solutions, Ltd 11 Bilton Road Chelmsford Essex CM1 2UP, England T: +44 (0) 1245 342060 F: +44 124 535 8938

SCALE: Not To Scale	DRAWN BY:	S Nash	
DIMENSIONS: mm	CHECKED BY:	M Nielsen	
TOLERANCES:	APPROVED BY:	S Nash	
	DATE:	02 Jan 02	

DESCRIPTION:

Stripping and Assembly Instructions for N Crimp Plug DRAWING NUMBER:

VAIN1101

PAGE: