Type N Straight Plug Solder Style for Semi-Rigid Cable
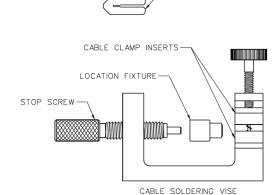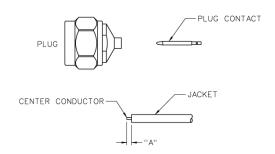
1. Identify connector parts (2 piece parts) and tools (5 piece parts).

2. Strip cable jacket and dielectric to dimension shown. Do not nick center conductor. Clean all debris from cable.

3. Place plug contact onto center conductor, insert appropriate sized solder shim between cable jacket and contact.

4. Insert contact into location fixture and clamp cable in vise. Tighten stop screw until light pressure is applied between contact, solder shim and cable jacket.

5. Solder 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.

6. After solder joint has cooled, loosen stop screw and remove solder shim. Remove cable from vise and remove any excess solder from contact with a sharp blade and clean all debris from contact and cable.

7. Insert contact and cable into plug connector assembly, making sure cable jacket bottoms out against internal shoulder of connector assembly. Insert location fixture into connector assembly and clamp cable in vise. Tighten stop screw until light pressure is applied between connector assembly and cable jacket.

8. Solder connector body to cable jacket, using a minimum amount of solder for a full fillet joint. Allow assembly to cool before removing connector from vise.
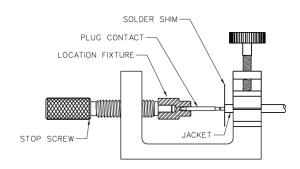
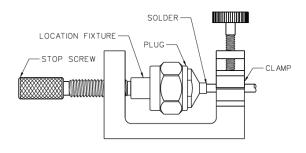| Cable Group	Part No.	"A"
RG-405, .086 Semi-Rigid	138-4693-001	.085 (2.16)
RG-402, .141 Semi-Rigid	138-4694-001	.085 (2.16)
RG-401, .250 Semi-Rigid	138-4696-001	.100 (2.54)

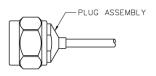| Assembly			
Tool	138-4693-001	138-4694-001	138-4696-001
Solder Shim	140-0000-984	140-0000-984	140-0000-985
Location Fixture	140-0000-983	140-0000-983	140-0000-983
Cable Vise	140-0000-962	140-0000-962	140-0000-962
Clamp Inserts	140-0000-964	140-0000-965	140-0000-986