



Plug Assembly Instructions: Series 1205 (non-shielded)

P/N167-9504 5 pin plug (non-shielded)



Note: These instructions apply only to assemblies using .090 Dia. silicone coated FEP cable P/N 178-8315. Reynolds does not recommend customer assembly of the shielded version of the Series 1205 plug due to the complexity of the shielded version.

Step 1

Cut cable to length, clean and square. Strip cable to dimension shown. Make sure there are no severed strands and not more than two strands nicked. Hot tin dip the exposed conductor. Remove all flux using isopropyl alcohol.

Step 2

Flux conductor and solder contact to conductor through the feed hole in contact using SN60 solder. Completed solder joint must have a continuous fillet of solder between the cable conductor and the contact. Solder in the feedhole must be free of pin holes and flush or below flush. Rear of contact shoulder must be as flush as possible with insulation of cable as shown. Make sure the clamp nut, washer and cable retainer are in place as shown. Mask contact in area shown. Lightly abrade the contact area as shown using either clean abrasive cloth or air blast with clean sand. Do not abrade the cable. Brush a thin film of General Electric SS4004 primer over contact in area shown. Do not allow primer to get inside the contact and do not prime the cable. Allow primer to dry for 1 hour at room temperature.

Step 3

Brush a light film of General Electric RTV 162 adhesive over the primed surface of the contact and about 1 inch of the cable. Immediately insert the contact into the connector insulator. Rotation of the contact is okay during insertion. Apply enough forward pressure to displace residual air at the interface. Make sure the contact shoulder butts against the internal flange of the insulator and that the 'control dimension' is maintained. Repeat steps 1 through 3 for each cable that is to be installed into the connector. Place assembly in a humidity oven with a relative humidity of at least 60% for 24 hours @ 100°F. Do not disturb the assembly during the curing cycle.

Step 4

Slide cable retainer into back of connector. Make sure retainer is properly aligned according to identification numbers (1-5) Slide washer and clamp nut in place. Tighten clamp nut up in place. Before mating the connector for the first time, verify that the *Control Dimension has been maintained for each cable installed.

