



Cable Preparation and Assembly Instructions

Series: 31 310 311

Series 31 (P/N 167-0669)

Step 1

Cut cable to length, clean and square. Slip boot over cable. Strip outer jacket to dimension shown. Trim exposed braid to dimension. Trim inner insulation to dimension. No nicked or severed strands allowed.

Step 2

Insert sleeve under braid as shown. Rosin-flux and pot tin dip both the inner core and exposed braid using SN60 solder in accordance with J-STD-006. Remove all flux.

Step 3

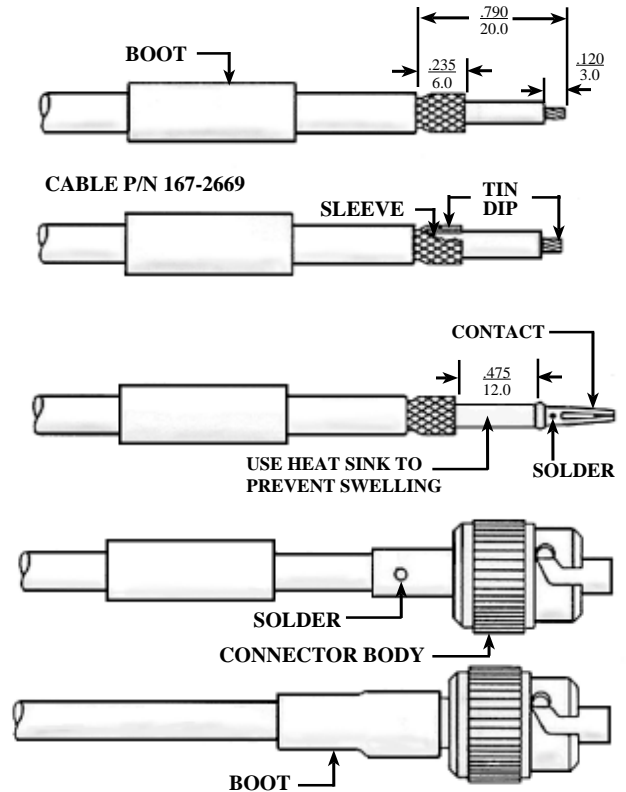
Solder contact in place through hole using SN60 solder in accordance with J-STD-006. Completed solder joint must have a continuous fillet of solder between the conductor and the contact. The solder in the feed hole must be free of pinholes and flush or below flush. Rear of contact shoulder shall be as flush as possible with insulation of cable core, but not to exceed .030".

Step 4

Slip prepared cable into the connector body until the flange inside the connector butts against braid cut off. Solder connector body to braid through 4 holes using SN60 solder in accordance with J-STD-006. Clean thoroughly.

Step 5

Slide boot into position as shown.



Series 310 (P/N 167-4356)

Series 311 (P/N 167-7624-1, -2, -3)

Step 1

Cut cable to length, clean and square. Slip boot and crimp sleeve over cable. Strip outer jacket to dimension shown. Trim exposed braid to dimension. Trim inner insulation to dimension. No nicked or severed strands allowed. Pot tin dip inner conductor using SN60 solder in accordance with J-STD-006. Remove all flux.

Step 2

Solder contact in place through hole using SN60 solder in accordance with J-STD-006. No solder buildup allowed on contact outer diameter. Completed solder joint must have a continuous fillet of solder between the inner conductor and the contact. The solder in the feed hole must be free of pinholes and flush or below flush. Rear of contact shoulder shall be as flush as possible with insulation of cable core, but not to exceed .030". Flair braid by moving cable core in a circular motion.

Step 3

Insert prepared cable into connector assembly. When contact shoulder butts against flange of insulator, slide crimp sleeve over braid and connector. Trim excess braid and crimp using Thomas & Betts crimping tool No. WT308 or WT408 or an equivalent crimp tool. Slide boot in place

