

### NOTES:

#### 1.0 Materials

- 1.1 Body, Coupling, and Clamp Nuts: Steel. Corrosion Resistant per ASTM-A582. UNS No. S30300.
- 1.2 Center Conductor: Beryllium Copper per ASTM-B196. UNS C17300.
- 1.3 Solder Ferrule: Brass per ASTM-B16. UNS C36000.
- 1.4 Lock Ring: Beryllium Copper per ASTM-B197. UNS C17200.
- 1.5 Gasket and O-Ring: Silicone Rubber per A-A-59588.
- 1.6 Dielectric Bead: Polyphenylene Oxide (NORYL) per ASTM-D4349.
- 1.7 Cable Stop: Polyetherimide Thermoplastic (ULTEM 1000) per ASTM-D5205.

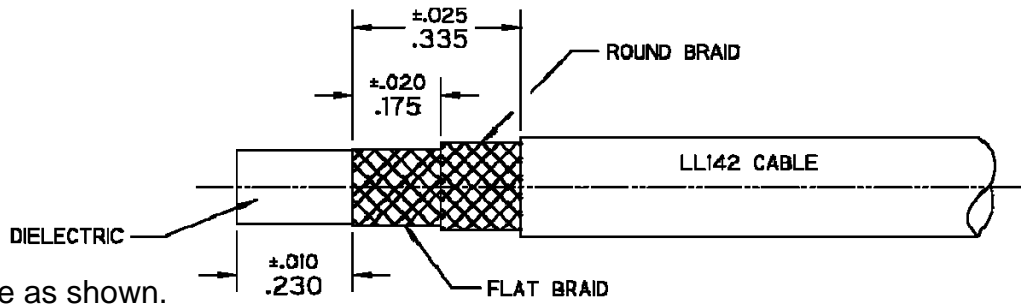
#### 2.0 Finishes

- 2.1 Center Contact and Solder Ferrule: Gold Plate per ASTM-B488 50 Microinches Min. thickness over Electrolytic Nickel Plate per ASTM-B689 50 Microinches Min. thickness.
- 2.2 Body, Coupling, and Clamp Nuts: Passivated per SAE-AMS-2700.
- 2.3 Gasket, O-Ring, Lock Ring, and Dielectrics: None.

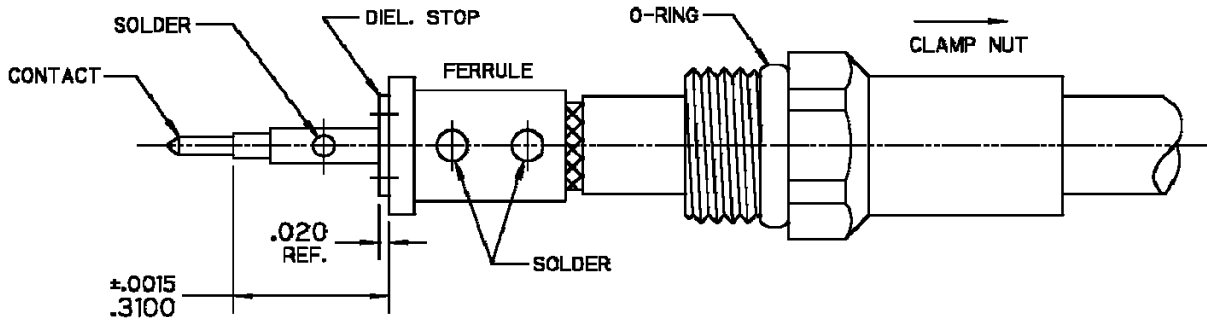
#### 3.0 Interface per CC-2.92mm-Pin.



# 2.92mm Plug to Solder Clamp for Harbour LL142 Cable

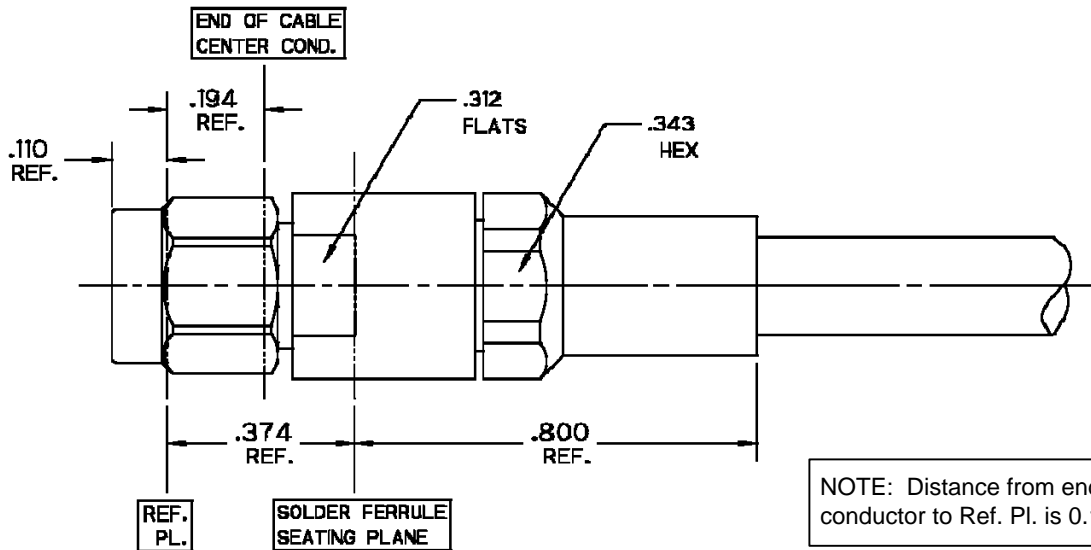


**Step 1** 1.1 Trim Cable as shown.



- 2.1 Slide clamp nut over cable in orientation shown.
- 2.2 Insert cable into solder ferrule until inner braid seats and solder to braids where shown.
- 2.3 Trim cable dielectric flush with face of ferrule.
- 2.4 Slide dielectric stop over cable center conductor and solder contact flush to stop to dimension shown.

**Step 2**



NOTE: Distance from end of cable center conductor to Ref. Pl. is 0.194 (Ref)

**Step 3** 3.1 Insert cable/contact sub-assembly into connector until seated and tighten clamp nut to 25-35 in-lbs.

<b>Product Control:</b>			
Crystek Part Number:	CS-FM-MHA	Release Date:	04-Jan-11
Revision Level:	A	Responsible:	K. Piotrowicz