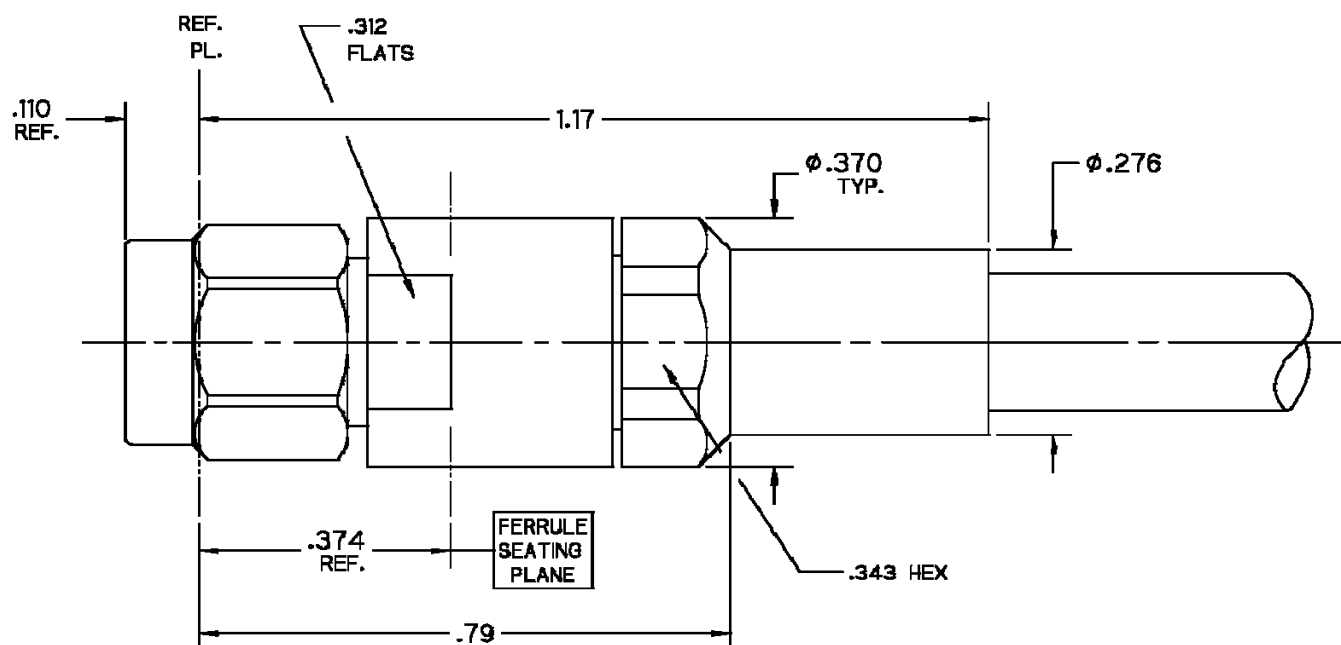




2.92mm Plug, Solder Clamp for Semflex HP190 Cable



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: Polyethylene 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.



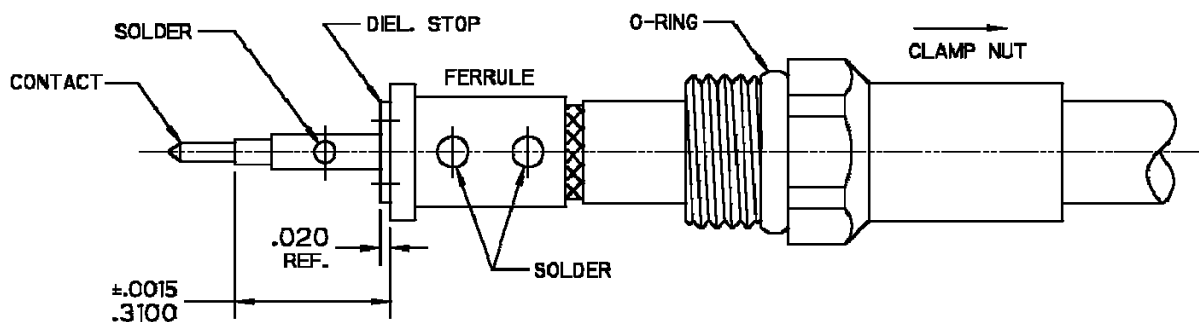


Diagram illustrating the cross-sectional view of a cable assembly. The assembly consists of a central HP190 CABLE surrounded by a DIELECTRIC layer. The dimensions are specified as follows:

- Overall diameter: $\pm .025$
- Inner diameter (cable): $\pm .020$
- Outer diameter (dielectric): $\pm .335$
- Inner diameter (dielectric): $\pm .175$
- Outer diameter (dielectric): $\pm .230$
- Inner diameter (dielectric): $\pm .010$

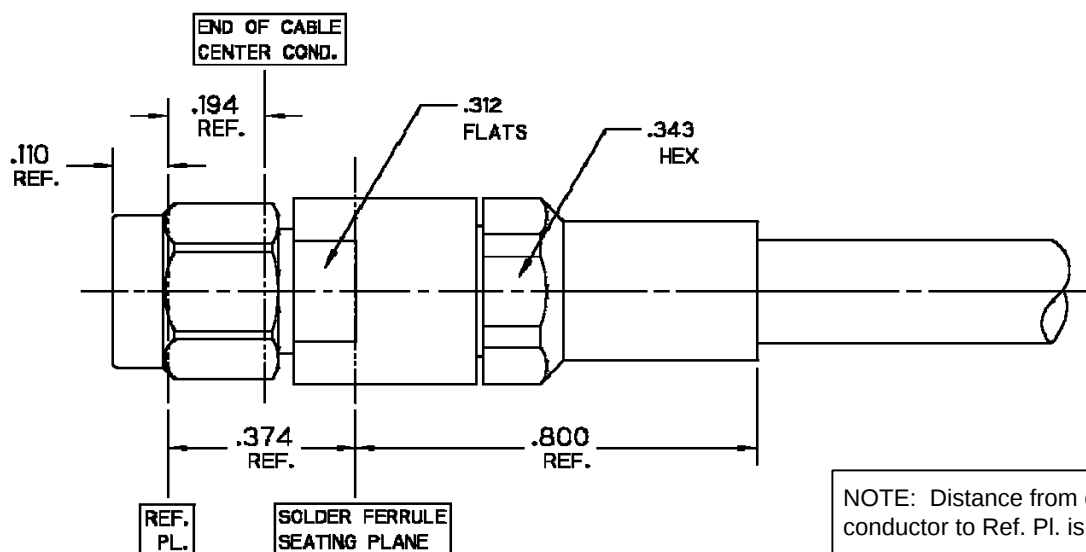
The assembly is labeled with "ROUND BRAID" and "HP190 CABLE".

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)

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

Step 3

Crystek Part Number:	CS-FM-MS	Release Date:	04-Jan-11
Revision Level:	A	Responsible:	K. Piotrowicz

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