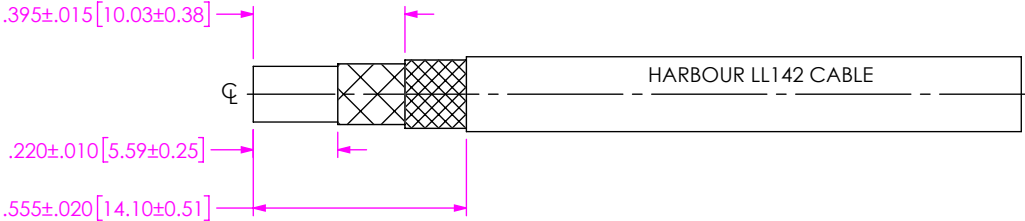


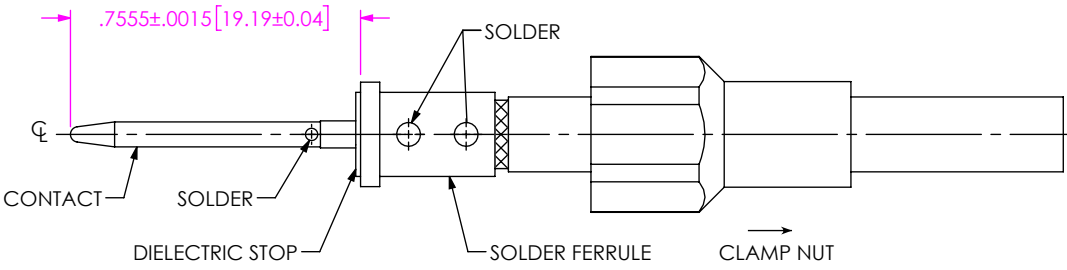
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IN-PROCESS 1



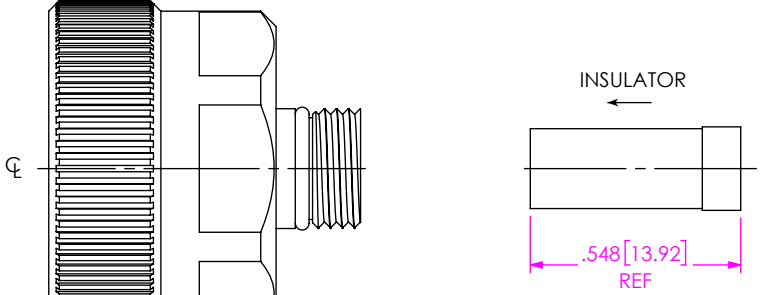
1. TRIM CABLE AS SHOWN.

IN-PROCESS 2



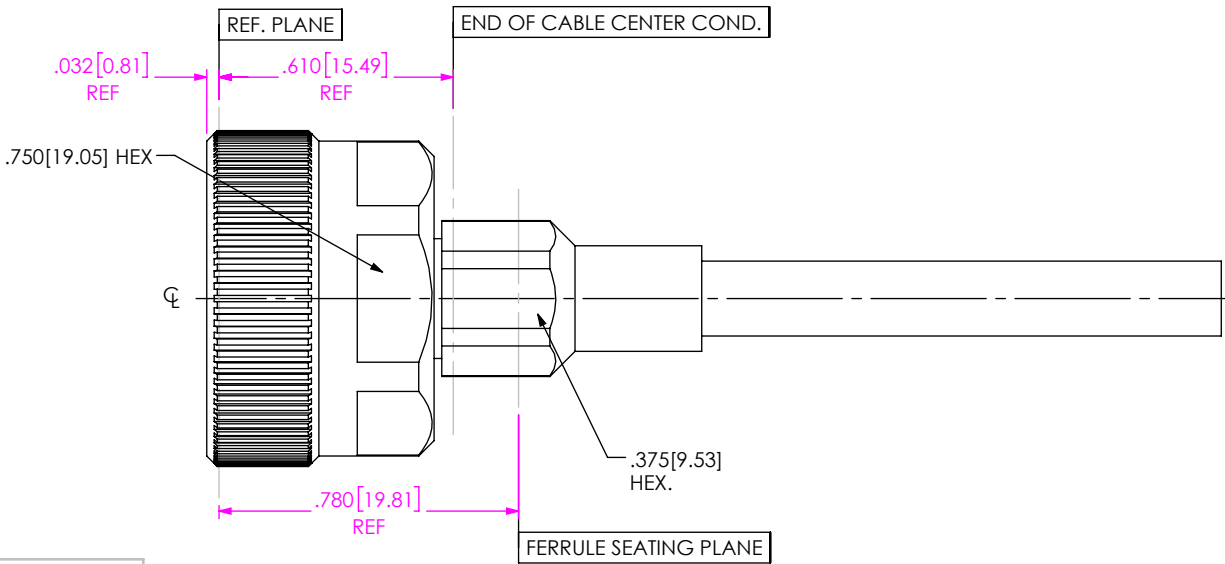
2A. SLIDE CLAMP NUT OVER CABLE AS SHOWN.
2B. INSERT CABLE INTO SOLDER FERRULE AS SHOWN THEN SOLDER BRAIDS TO FERRULE WHERE INDICATED.
2C. TRIM EXPOSED CABLE DIELECTRIC FLUSH WITH SOLDER FERRULE FACE.
2D. SLIDE DIELECTRIC STOP OVER CABLE CENTER CONDUCTOR AGAINST FERRULE FACE AND SOLDER CONTACT FLUSH AGAINST STOP TO DIMENSION SHOWN.

IN-PROCESS 3



3. INSTALL INSULATOR INTO SUB ASSEMBLY.

IN-PROCESS 4



4A. INSERT CABLE/ CONTACT SUB-ASSEMBLY INTO CONNECTOR UNTIL SEATED.
4B. TIGHTEN CONNECTOR COUPLING NUT TO MATING TYPE N JACK.
4C. TIGHTEN REAR CLAMP NUT TO 30-40 IN-LBS AND DISENGAGE MAIN INTERGACE FROM JACK.

PROPRIETARY NOTE

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DO NOT SCALE DRAWING

SHEET SCALE: 2:1

DESCRIPTION: N PLUG (18 GHZ), SOLDER CLAMP FOR HARBOUR LL142 CABLE, KNURL/HEX NUT

DWG. NO. PRF06-P-C-EP-142-SS-1

BY: WILLY Y 7/11/2022 SHEET 2 OF 2

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