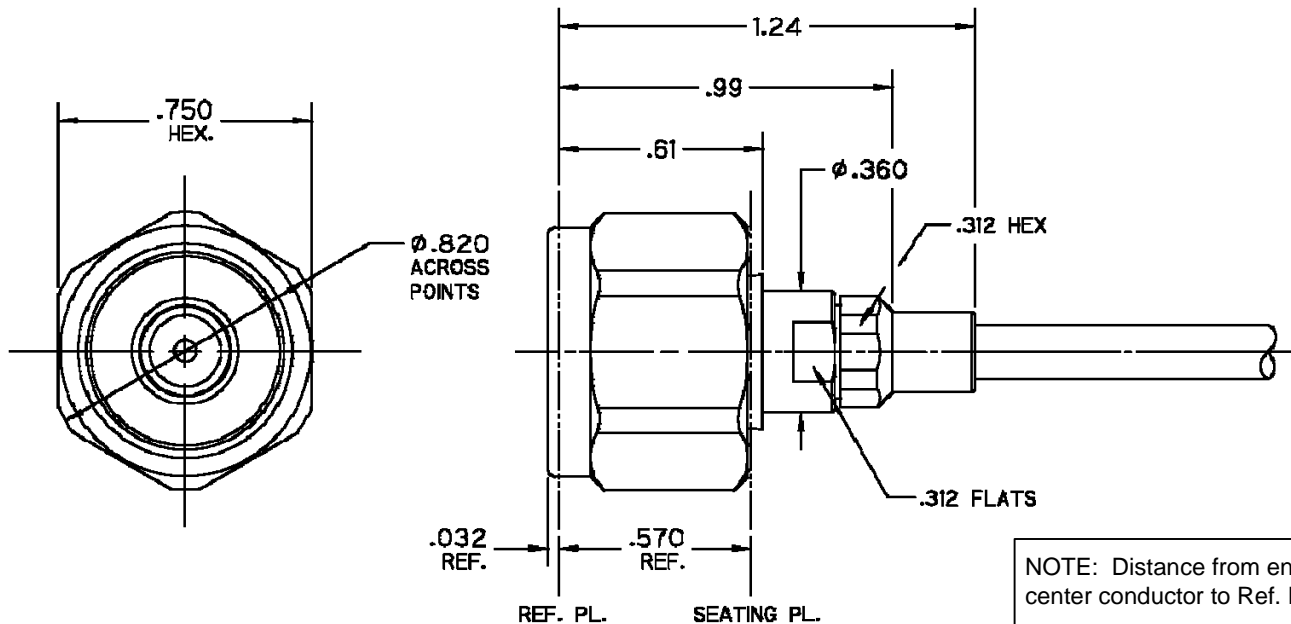


# N Plug Solder Clamp for Crystek SS402 Cable



## NOTES:

### 1.0 Materials

- 1.1 Body, Coupling, and Clamp Nut: 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 Gasket and O-Ring: Silicone Rubber per A-A-59588.
- 1.5 Insulator: PTFE Fluorocarbon per ASTM-D1710.
- 1.6 Cable Stop: Polyetherimide Thermoplastic (ULTEM 1000) per ASTM-D5205.

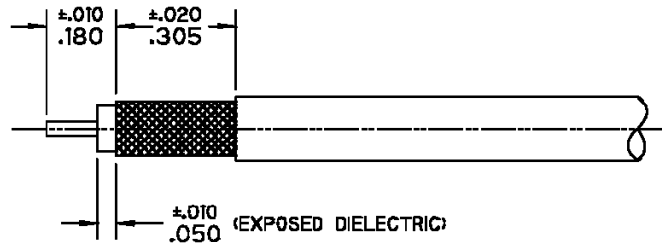
### 2.0 Finishes

- 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, and Dielectrics: None.

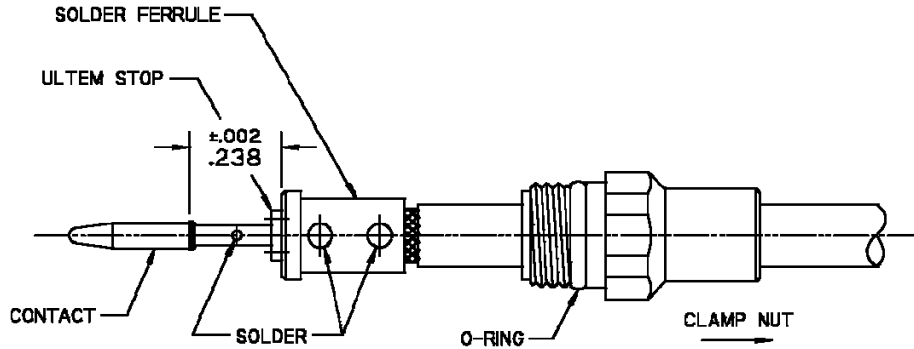
### 3.0 Interface: Type N plug per Crystek Interface Specification CC-PNP-TL.



# N Plug Solder Clamp for Crystek SS402 Cable

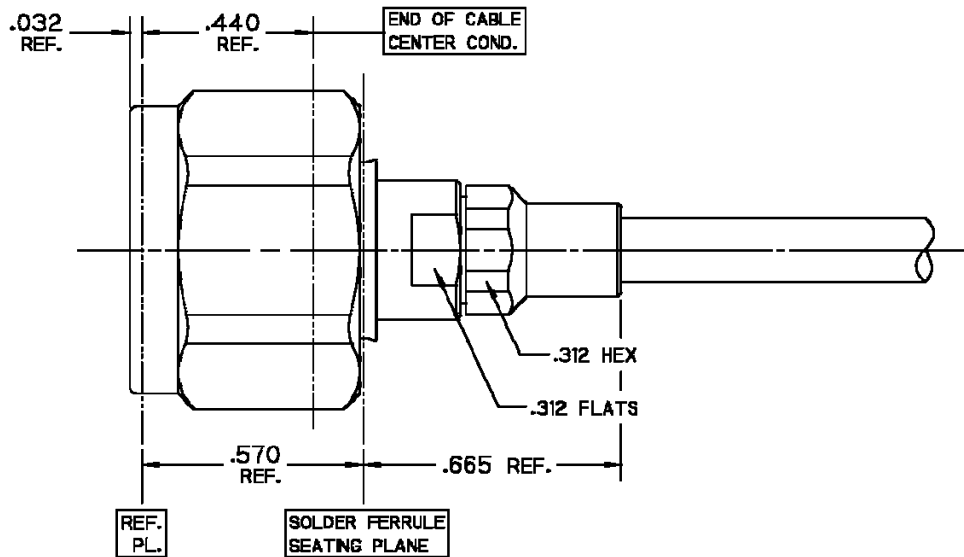


**Step 1** 1.1 Trim Cable as shown.



- 2.1 Slide clamp nut over cable as shown.
- 2.2 Insert cable into solder ferrule until cable dielectric is flush with face of ferrule, then solder both cable braids where indicated.
- 2.3 Slide dielectric stop over cable center conductor and solder contact flush against stop to dimension shown.

**Step 2**



- 3.1 Insert cable/contact sub-assembly into connector until seated and tighten clamp nut to 35-45 in-lbs.

**Step 3**

<b>Product Control:</b>			
Crystek Part Number:	CS-NM-MCA	Release Date:	24-Feb-11
Revision Level:	A	Responsible:	K. Piotrowicz