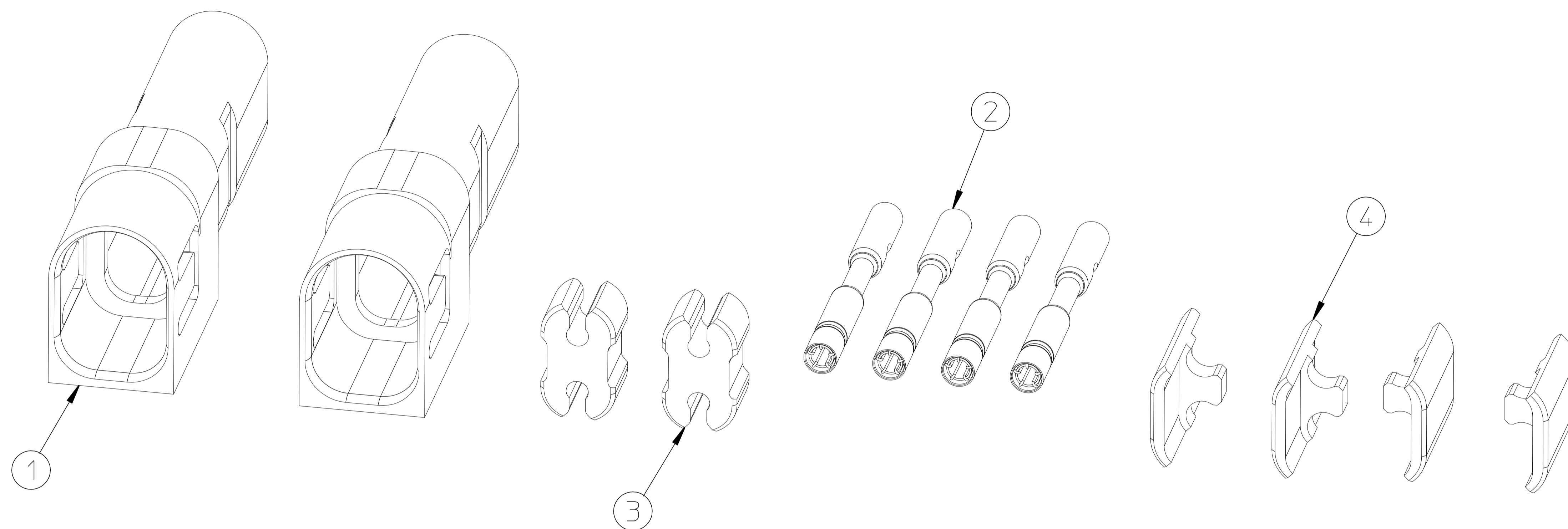


REV	ECN NUMBER	DATE
3	6254	09/03/17
2	6230	01/02/17
1	6175	13/09/16

LATEST MODIFICATION DETAIL

RELEASED



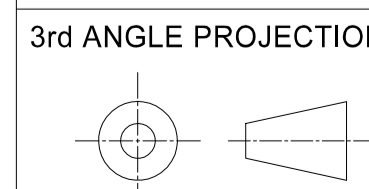
ITEM No	DESCRIPTION	MATERIAL / FINISH	QTY.	SMITH'S CODE
1	CONTACT, OUTER SHELL	BERYLLIUM COPPER C17200 FINISH: SEE BOM	2	HYP-7049-H-117
2	SOCKET, CONTACT	BRASS CZ131 FINISH: SEE BOM	4	HHSC-0156-100
3	INSULATOR, DIELECTRIC	PEEK, 150G	2	HYP-6944-M
4	SPACER	PEEK, UNFILLED	4	HXS-0065
5				

KIT OF PARTS

**smiths connectors**

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SCALE 10:1  
OR AS STATED  
DO NOT SCALE  
SIZE A3



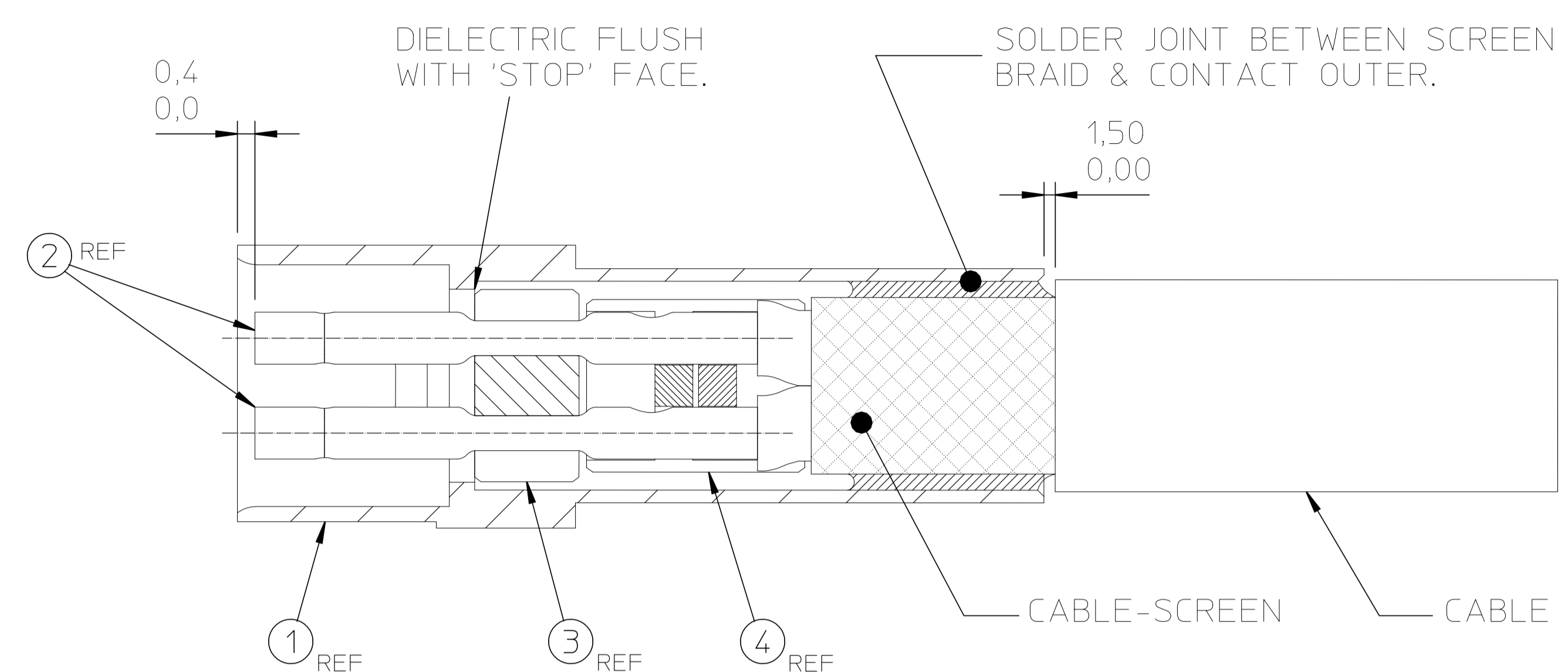
UNITS MM  
TOLERANCES UNLESS STATED OTHERWISE  
. X ± mm  
. XX ± mm  
. XXX ± mm  
ANGLES ± °

PART MUST CONFORM TO SPECIFICATIONS NOTED IN DOCUMENT SCDS-D-SHYL

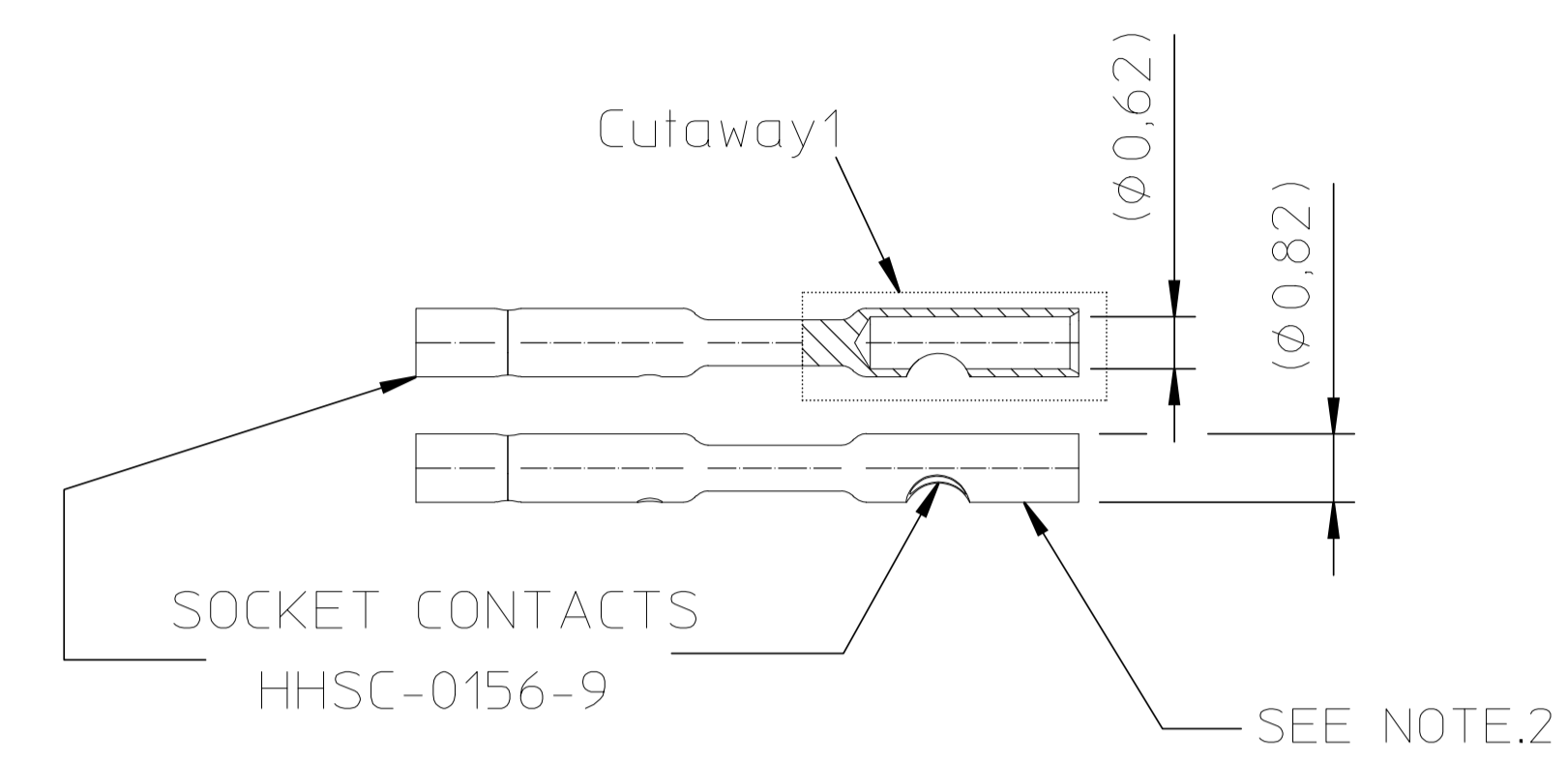
ENG.	13/09/16	SD
MOD.	09/03/17	SD
APP.	09/03/17	JA
REL.	09/03/17	JA

DRAWING No	HXS-7009	REV	3
DESCRIPTION	TERMINATION KIT TWINAX CABLE		
MATERIAL	SEE PARTS TABLE	SHEET	1 OF 3

REV	ECN NUMBER	DATE
3	6254	09/03/17
2	6230	01/02/17
1	6175	13/09/16
LATEST MODIFICATION DETAIL		
RELEASED		



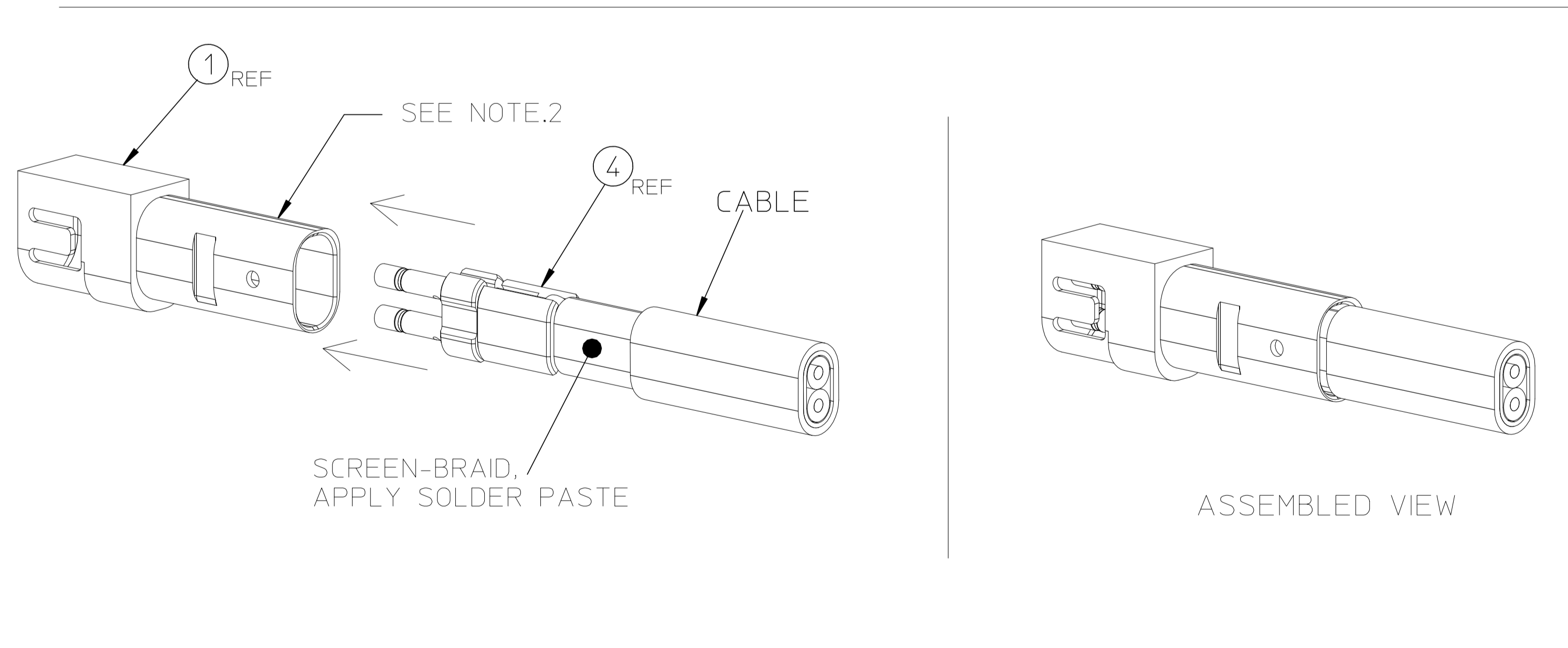
SCRAP SECTION



DETAILS: SOLDER CONTACT

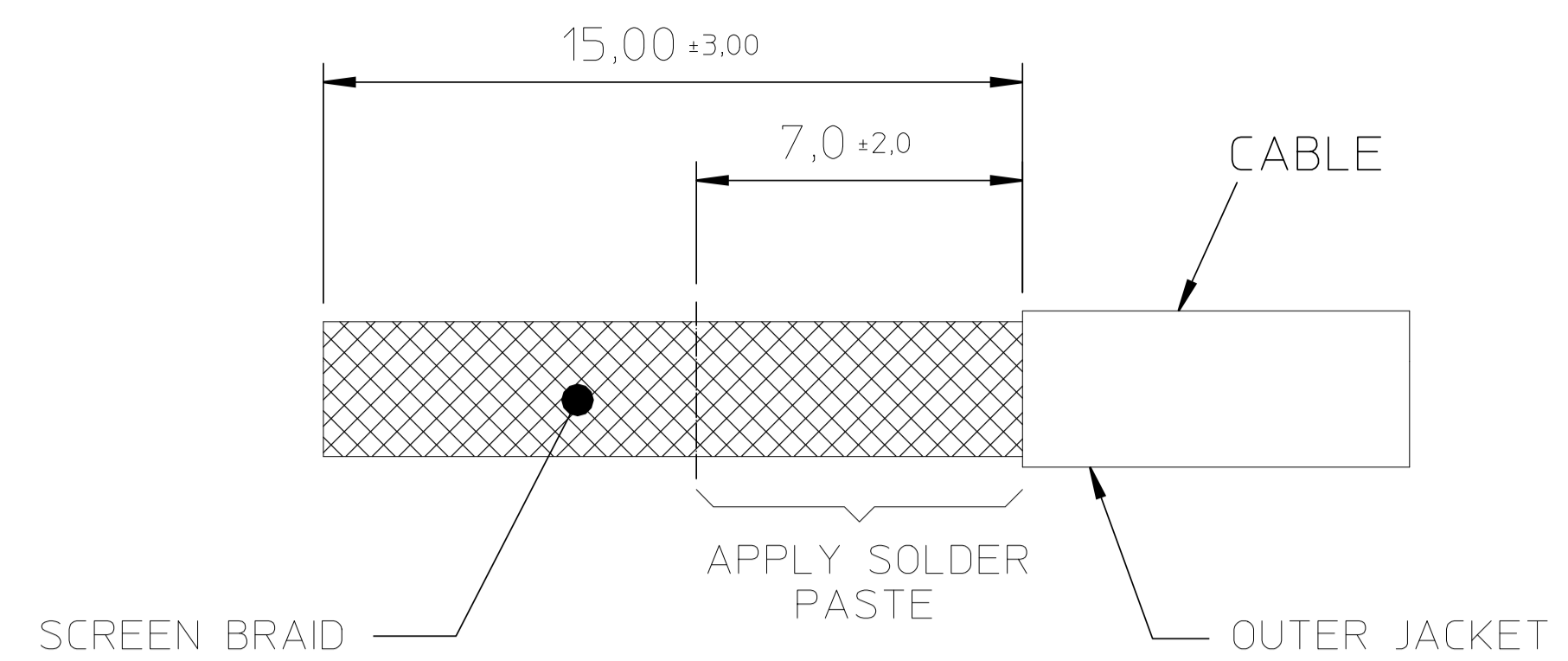
NOTES:-

- SUITABLE CABLE: W L GORE GSC-05-83111-00  
AXON AM526-A07  
TENSOLITE 540-1153-000  
- OR EQUIVELANT.
- SOLDER TERMINATION JOINTS;-  
- RECOMENDED SOLDER: Sn62 Pb36 Ag2 (NO CLEAN) SOLDER PASTE.  
- PRIOR TO TERMINATING; REMOVAL OF GOLD (VIA TINNING) WITHIN TERMINATION ZONE, OF ALL GOLD PLATED SHELLS IS RECOMMENDED.
- ASSEMBLY GUIDE:-  
- ASSEMBLE SOLDER SOCKETS, ITEM 2, TO DIELECTRIC INSULATOR, ITEM 3. THEN  
- STRIP, PREPARE & TERMINATE CABLE, AS DETAILED ON SHT.3  
- TERMINATE OUTER SHELL, ITEM 1, TO CABLE, AS DETAILED ABOVE.
- FOR ASSEMBLY GUIDELINES, REFER TO 'HXS-7009 ASSEMBLY GUIDE' DOCUMENT OR RELEVANT SECTIONS OF SMITHS PRODUCTION PROCESS: P000242
- FOR QUALITY GUIDANCE REFER TO RELEVANT SECTION OF SMITHS QUALITY WORKMANSHIP STD: WQS-0183

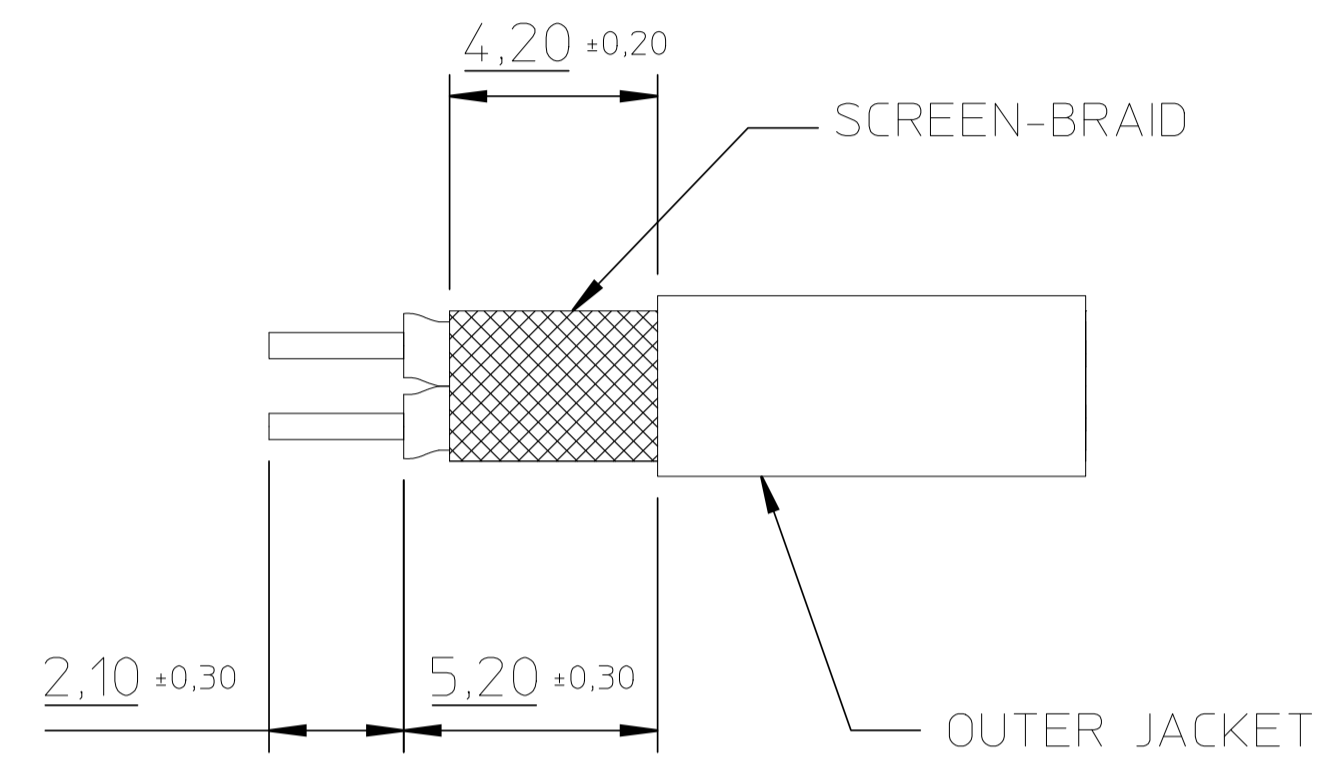


<b>smiths connectors</b> <small>THE INFORMATION CONTAINED WITHIN THIS DOCUMENT IS PROPRIETARY TO SMITHS CONNECTORS. ALL RIGHTS RESERVED. IT SHOULD NOT BE UTILISED, REUSED, EXPORTED, DISTRIBUTED OR ALTERED IN ANY SHAPE OR FORM, WITHOUT THE PRIOR WRITTEN APPROVAL OF SMITHS CONNECTORS</small>	SCALE 10:1 OR AS STATED DO NOT SCALE	UNITS MM	PART MUST CONFORM TO SPECIFICATIONS NOTED IN DOCUMENT SCDS-D-SHYL		DRAWING No	HXS-7009	REV	3
	SIZE A2	TOLERANCES UNLESS STATED OTHERWISE	ENG. 13/09/16 SD		DESCRIPTION	TERMINATION KIT TWINAX CABLE		
	3rd ANGLE PROJECTION	.X ± mm	MOD. 09/03/17 SD		MATERIAL	SEE PARTS TABLE	SHEET 2 OF 3	
		.XX ± mm	APP. 09/03/17 JA					
	.XXX ± mm	REL. 09/03/17 JA						
	ANGLES ± °							

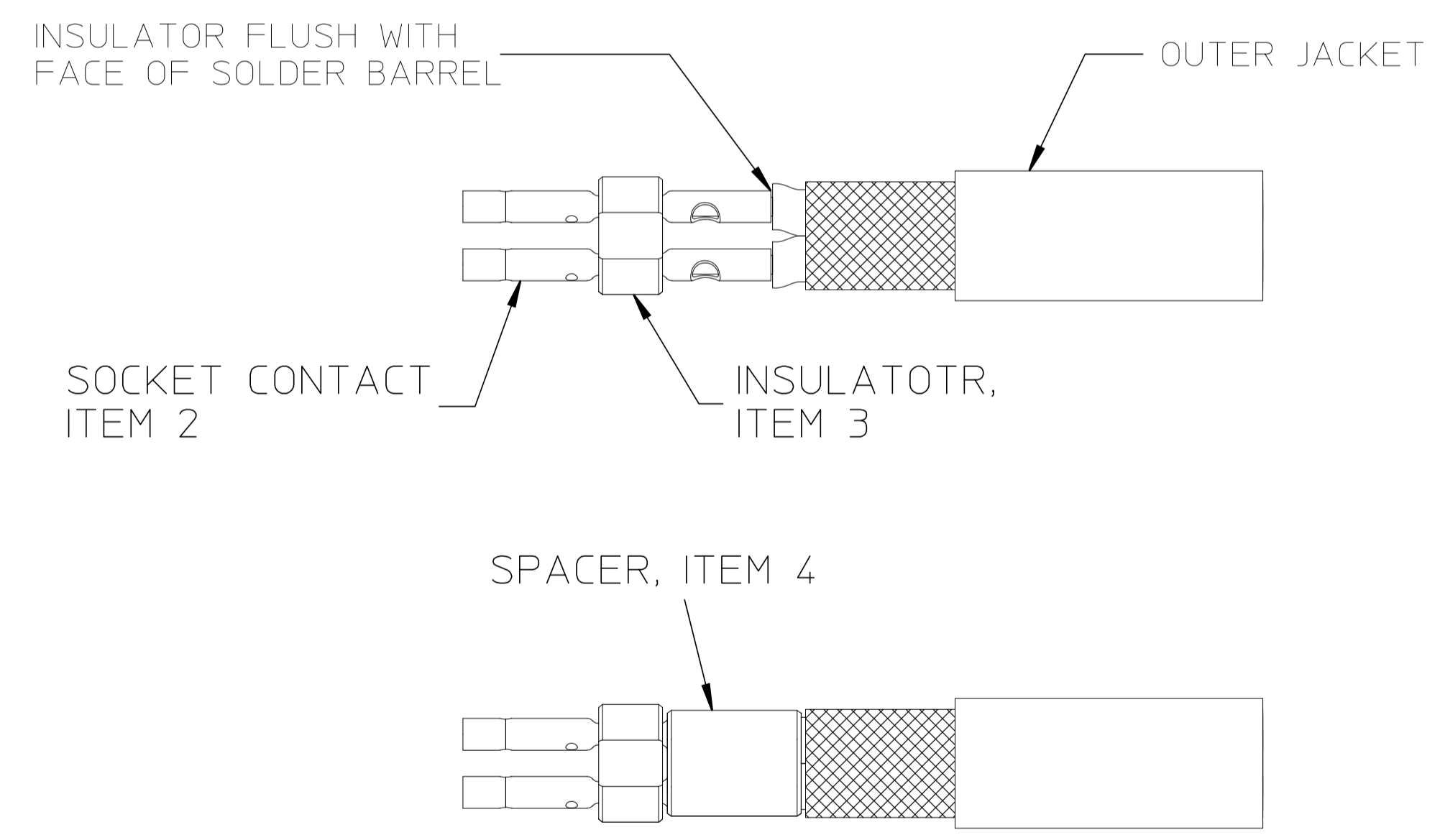
REV	ECN NUMBER	DATE
3	6254	09/03/17
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LATEST MODIFICATION DETAIL		
RELEASED		



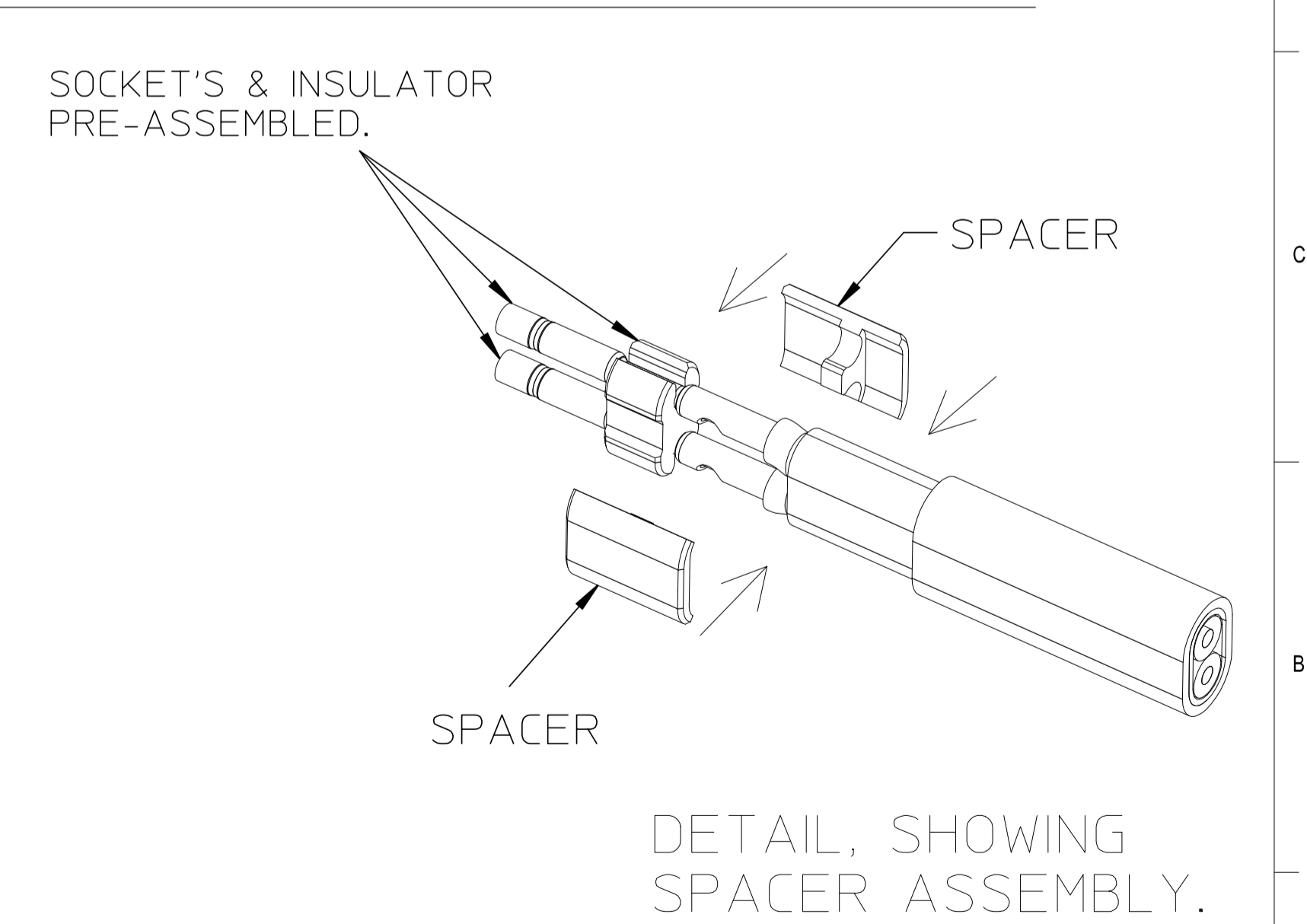
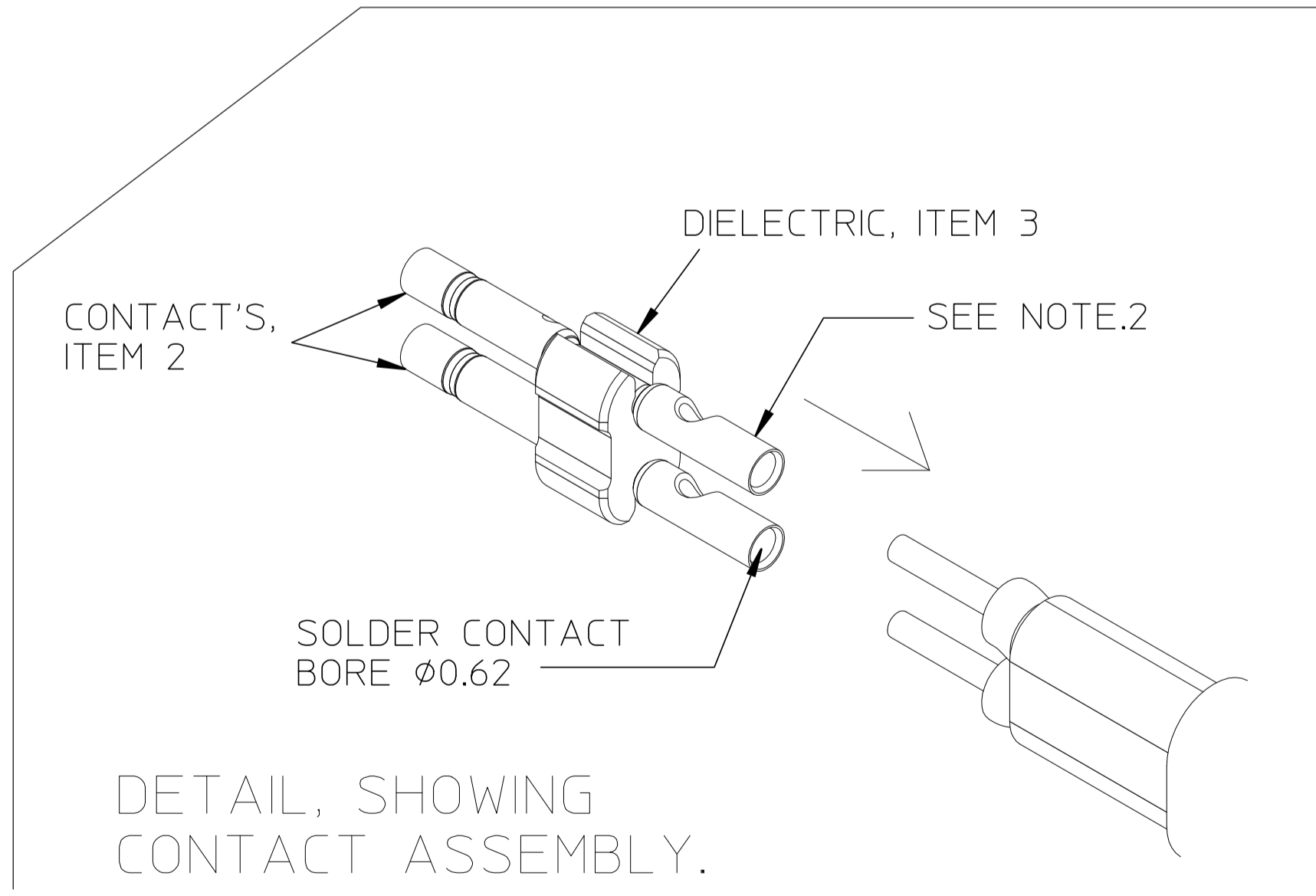
- CUT CABLE TO LENGTH: 10mm OVER REQUIRED 'FINISHED LENGTH', (TO ACCOMODATE FOLLOWING 'PRE-CONDITIONING' & SUBSEQUENT TRIMMING).
- PRE-CONDITION CABLES: ALLOW TO SOAK AT 125°C FOR 1 HOUR.
- ALLOW TO COOL.
- TRIM 5mm FROM THE EACH END OF CABLE, THEN:-
- STRIP OUTER JACKET, TO DIMENSION SHOWN, EXPOSING 'SCREEN BRAID'.
- APPLY SOLDER PASTE TO SCREEN-BRAID, AND RE-FLOW (TINNING SCREEN-BRAID).



- CAREFULLY TRIM 'TINNED SCREEN-BRAID' TO DIMENSION SHOWN. TAKING CARE TO AVIOD CUTTING INSULATION OF INNER CORES.
- CUT, STRIP & TIN, INNER CORES TO DIMENSIONS SHOWN. (ENSURE INSULATION IS STRIPPED LEVEL ON BOTH CORES).



- FIT & TERMINATE CONTACT ASSEMBLY (SOCKET + INSULATOR), ENSURE INSULATOR OF INNER CORE IS POSITIONED FLUSH WITH FACE OF SOLDER BARREL.
- FIT SPACER.



CABLE 'TERMINATION' PREPERATION:-

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	3rd ANGLE PROJECTION	TOLERANCES UNLESS STATED OTHERWISE	. X ± mm	ENG. 13/09/16 SD	DESCRIPTION	TERMINATION KIT TWINAX CABLE	SHEET 3 OF 3
		. XX ± mm	MOD. 09/03/17 SD	MATERIAL	SEE PARTS TABLE		
		. XXX ± mm	APP. 09/03/17 JA				
	ANGLES ± °	REL. 09/03/17 JA					