

I. MATERIALS AND FINISHES (PLATING THICKNESS IN MICROINCHES):

OUTER & INNER FERRULE	- COPPER, BRIGHT ACID TIN (200 MIN THICK)
OUTER & INNER BODY	- BeCu, GOLD PLATING (50 MIN THICK)
CONTACT	- BeCu, GOLD PLATING (50 MIN THICK)
WASHER	- PTFE
INSULATOR	- PTFE

2. PACKAGING:
A. QUANTITY: SINGLE PACK
B. MARKING: BAG TO BE MARKED
"AMPHENOL, 902-5020-2, AND DATE CODE"

3. SHOWS CABLE ENTRY DIMENSIONS.

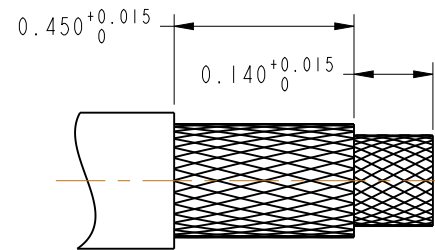
CONNECTOR ASSEMBLY PROCEDURE:

1. STRIP CABLE AS SHOWN.SLIDE OUTER FERRULE (ITEM 1) WELL UP OVER OUTER JACKET PRIOR TO FOLDING BACK CABLE SHIELD.
2. A. SLIDE TEFLON WASHER OVER INNER CONDUCTOR OF CABLE,FLUSH WITH INNER DIELECTRIC.
B. CRIMP INNER CONTACT TO CENTER CONDUCTOR OF CABLE,USING AMPHENOL TOOL FRAME 227-944 WITH 227-954 DIE SET 'C' GROOVE (0.034 DIAMOND).
3. SLIDE INNER FERRULE OVER OUTER CONDUCTOR AND 'INTERLAYER'.
4. FLARE OUTER CONDUCTOR SLIGHTLY AND INSERT INNER CONTACT INTO INNER BODY TO A FIRM BUTT.OUTER CONDUCTOR MUST GO OUTSIDE BACK END OF INNER BODY .SLIDE INNER FERRULE FORWARD OVER BRAID AND BUTT SHOULDER OF INNER BODY.CRIMP FERRULE USING AMPHENOL TOOL FRAME 227-944 WITH 227-954 DIE SET 'B' GROOVE (0.178 HEX).
5. ASSEMBLE INNER BODY INTO OUTER BODY TO A FIRM BUTT,FOLD CABLE SHIELD FORWARD OVER BODY.SLIDE OUTER FERRULE FORWARD OVER BRAID AND BUTT SHOULDER OF BODY. CRIMP FERRULE USING AMPHENOL TOOL FRAME 227-944 WITH 227-954 DIE SET 'A' GROOVE (0.263 HEX).

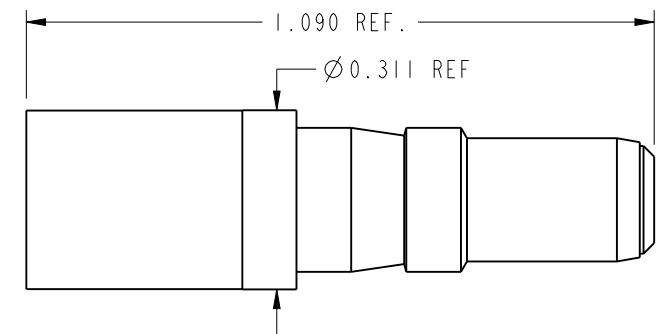
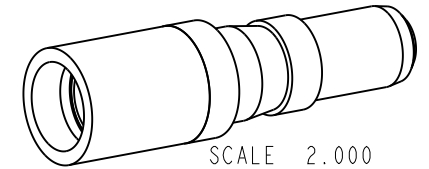
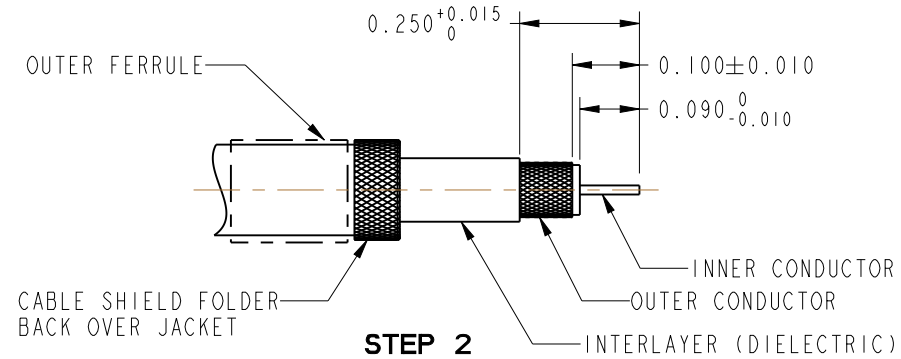
THIRD ANGLE PROJ. 

REVISIONS

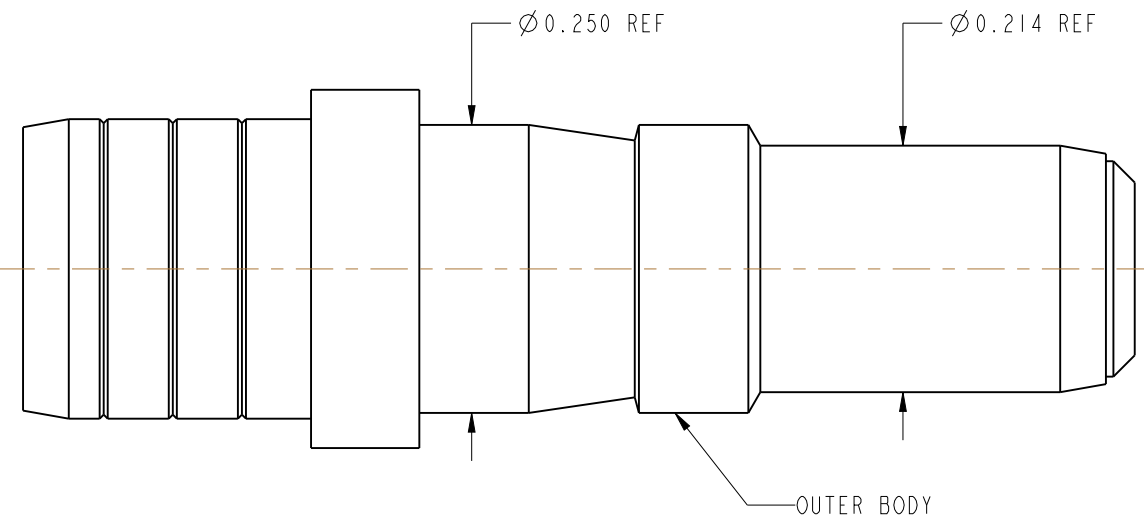
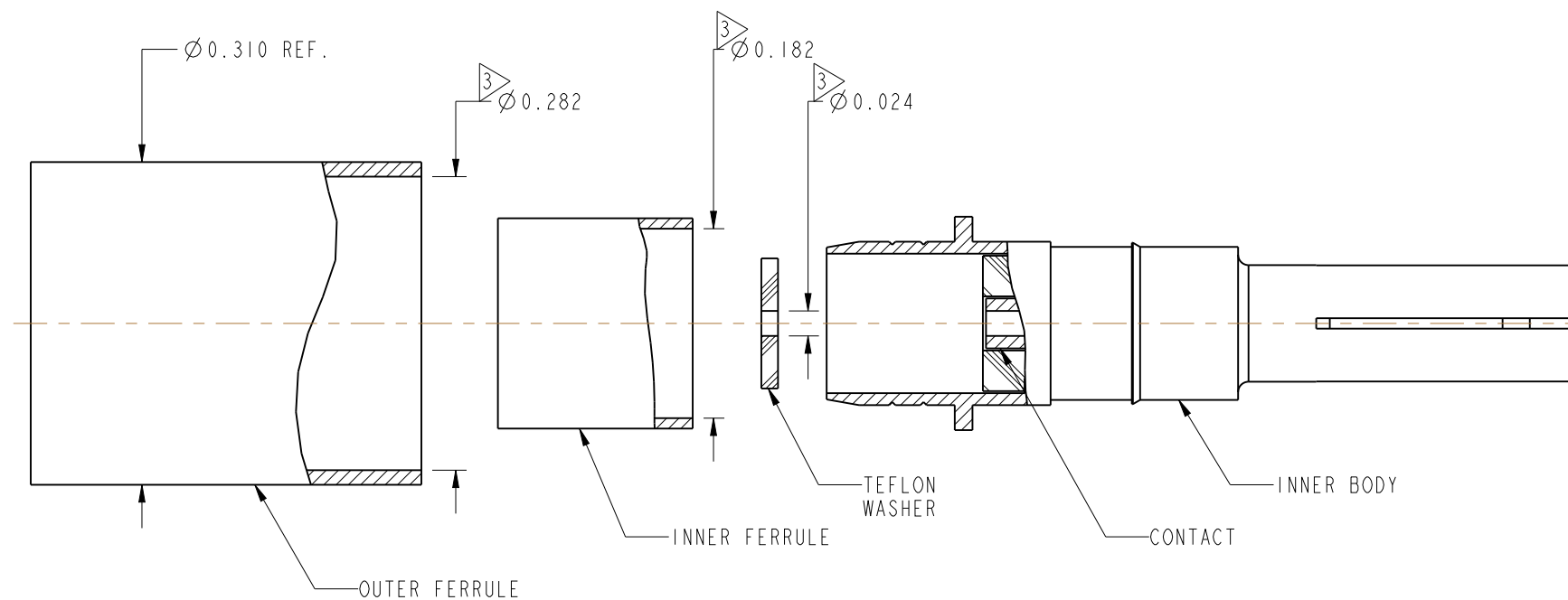
REV	DESCRIPTION	DATE	ECO	APPR
--	RELEASE TO MFG.	-----	-----	-----
J	REDRAWN IN PRO-E & ADDED COD	9/20/13	49679	MB
K	SEE SHEET I	3/20/15	50386	JN



STEP 1
CABLE PER ST5MI323
(TIMES AA2325)



AFTER ASSEMBLY DIMENSIONS
SCALE 3.000



CUSTOMER OUTLINE DRAWING

ALL OTHER SHEETS ARE FOR INTERNAL USE ONLY

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AND TOLERANCES ARE: 2 PLACE DECIMAL 3 PLACE DECIMAL ANGLES ±.015 (0,381 mm) ±.005 (0,127 mm) ± 1°	MATERIAL SEE NOTES	DRAWN MOHAN	DATE 08-Aug-13	TITLE PLUG TRIAX FOR TIMES AA2325 CABLE		Amphenol RF	
ENGINEER F. HULL		DATE 14-Nov-91	www.amphenolrf.com				
REFERENCE DOR 21-902-315567, ST5M 1289,ST5M 132 ST5M 1290-001P REV H		APPROVED K. CAPOZZI	DATE 8/28/13			DRAWING NO.902-5020-2	
FINISH		CAD FILE	DWG SIZE B		REV K	ITEM NO.902-5020-2	
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