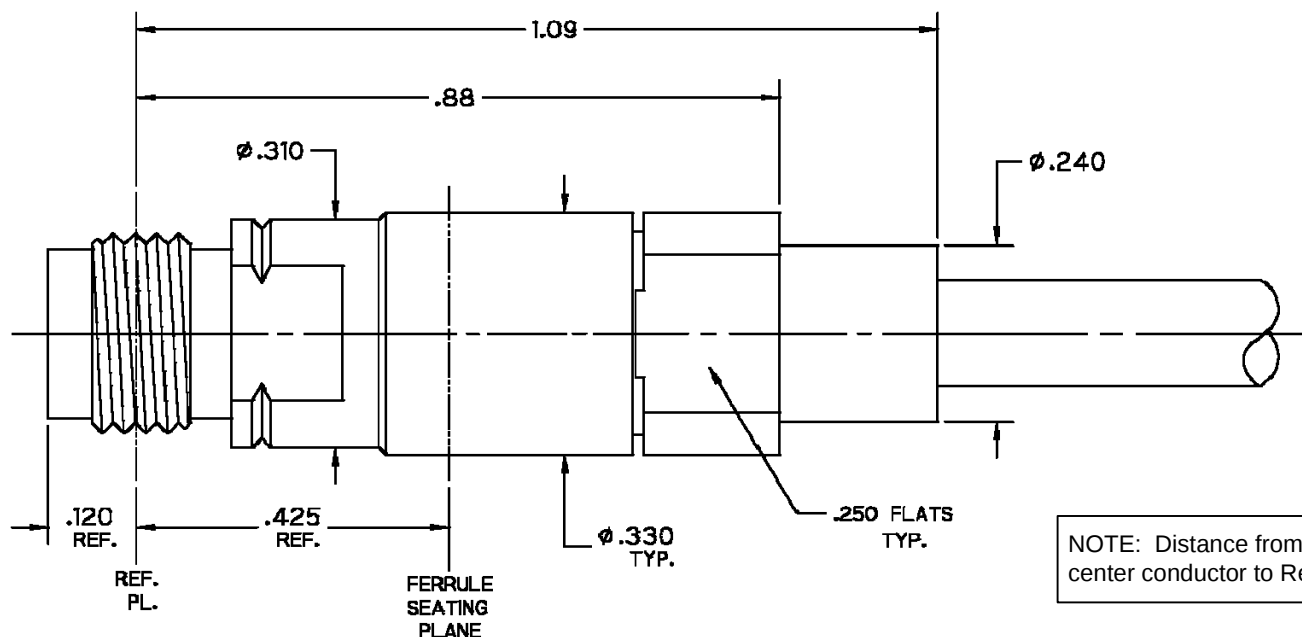




2.4mm Jack, Solder Clamp for IW1501 Cable



NOTES:

1.0 Materials

- 1.1 Body, Bushing, 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 O-Ring: Silicone Rubber per A-A-59588.
- 1.5 Dielectric Beads: Polyetherimide Thermoplastic (ULTEM 1000) per ASTM-D5205.

2.0 Finishes

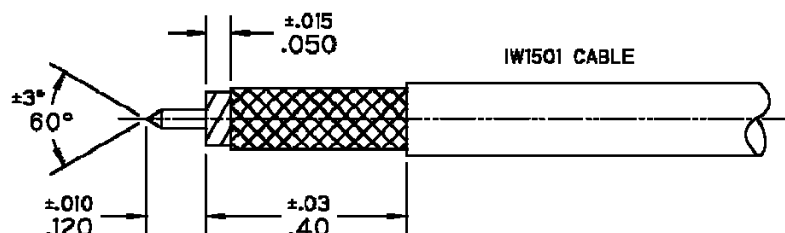
- 2.1 Center Contact and Solder Ferrule: Gold Plate per ASTM-B488 50 Microinches Min. thickness over Electrolytic Nickel Plate per ASTM-B689 50 Microinches Min. thickness.
- 2.2 Body, Bushing, and Clamp Nuts: Passivated per SAE-AMS-2700.
- 2.3 O-Ring, and Dielectric Bead(s): None.

- 3.0 Interface: 2.4mm Socket per CC-2.4mm-Soc. (Meets IEEE-STD-P287. Figure H.4 Except conductor tolerances and contact recession).

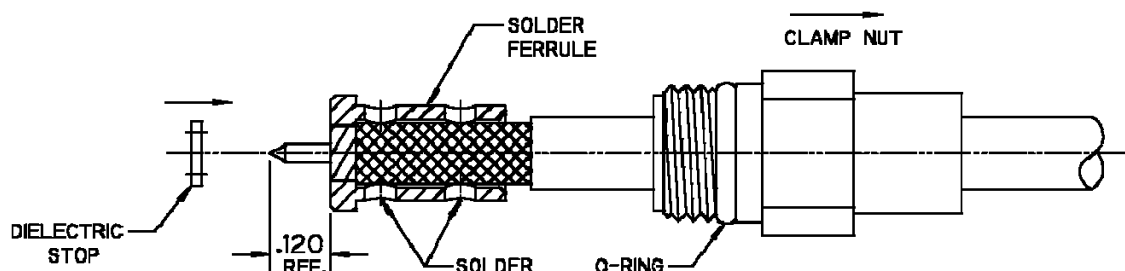




2.4mm Jack, Solder Clamp for IW1501 Cable

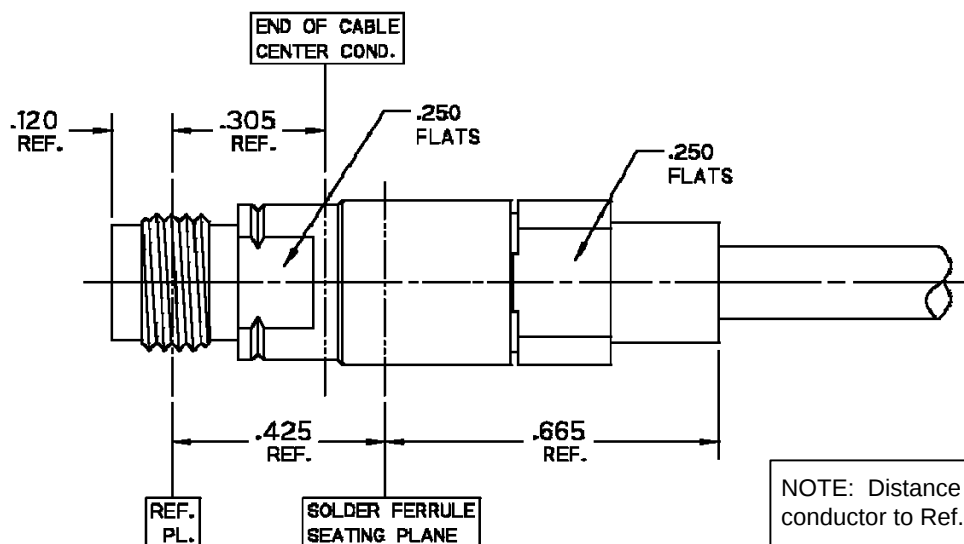


Step 1 1.1 Trim Cable and point center conductor as shown.



- 2.1 Install O-ring onto clamp nut where shown and slide clamp nut over cable in orientation shown.
- 2.2 Insert cable into solder ferrule until dielectric and foil are flush with solder ferrule face and solder braids where shown.
- 2.3 Slide dielectric stop over cable center conductor flush with solder ferrule face.

Step 2



NOTE: Distance from end of cable center conductor to Ref. Pl. is 0.305 (Ref)

- 3.1 Insert cable/ferrule subassembly into connector until seated and tighten clamp nut to 25-35 in-lbs.
- 3.2 Gage interface using appropriate gage. (contact range 000/0.003 sub-flush)

Step 3

Product Control:

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

