COAXIAL CABLE: RG213/U

 Parts Nomenclature
Note do not interchange the cable seal Ø.09 hole by .10 thick with the interface seal Ø.13 hole by .06 thick.

FIG 1

CABLE SEAL
CONTACT
SHELL
INTERFACE SEAL
GRIP SLEEVE

FIG 2

.188 [4.76]
1.75 [44.5]
CUT CABLE END SQUARE
SLIDE THE GRIP SLEEVE OVER THE CABLE
AND MAKE CUTS IN JACKET AS SHOWN

FIG 3

REMOVE JACKET TO FIRST CUT
FLARE OUT BRAID AND TRIM WITH SCISSORS
AT EDGE OF JACKET

FIG 4

REMOVE JACKET TO SECOND CUT

FIG 5

.31 [7.9]
TRIM INNER DIELECTRIC AS SHOWN
THE INNER CONDUCTOR MUST NOT HAVE ANY
SEVERED STRANDS AND NO MORE THAN TWO
STRANDS NICKED DURING STRIPPING
60-40 TIN LEAD SOLDER THE EXPOSED CONDUCTOR

INSTRUCTION SHEET
20KV SHV PLUG ASSEMBLY

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SHEET 1 OF 2
FIG 6

SLIDE CABLE SEAL AND CONTACT OVER CONDUCTOR.
PUSH AGAINST CABLE SEAL WHILE SOLDERING CONTACT IN PLACE THROUGH SOLDER HOLE -DO NOT OVERHEAT-

FIG 7

FLARE OUT BRAID

FLARE OUT BRAID -DO NOT FRAY- SLIDE CABLE ASSEMBLY INTO SHELL, DO NOT PINCH OR OTHERWISE DAMAGE THE CABLE SEAL.
GUIDE BRAID OVER SPLINED COLLAR ON SHELL UNTIL CONTACT SHOULDER BUTTS AGAINST SHELL INSULATOR.

FIG 8

CRIMP

SLIDE GRIP SLEEVE INTO POSITION AND CRIMP.
USE THOMAS & BETTS CRIMPING TOOL WT-540 AND DIE NUMBER 5452 OR KINGS CRIMPING TOOL #KTH-1000 AND CRIMP DIE #KTH-1078.
ENSURE THAT BRAID DOES NOT EXTEND BEYOND GRIP SLEEVE.
INSERT INTERFACE SEAL INTO THE SHELL UNTIL IT BOTTOMS EVENLY AROUND THE CONTACT.