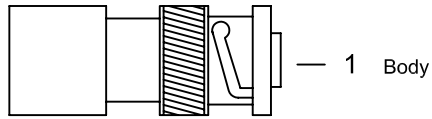
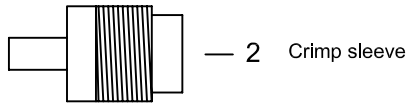


### Parts list

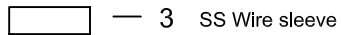
P.N. 111024



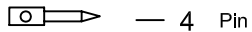
1 Body



2 Crimp sleeve

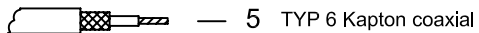


3 SS Wire sleeve



4 Pin

P.N. 100720



5 TYP 6 Kapton coaxial

### Tools list

Available at [www.accuglassproducts.com](http://www.accuglassproducts.com)

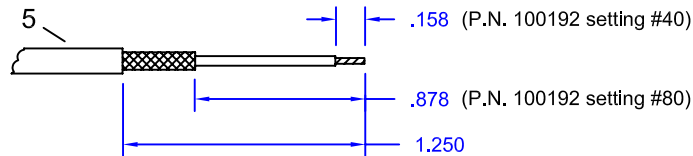
- P.N. 110797 Flux
- P.N. 110796 Solder UHV
- P.N. 110800 High temperature soldering iron
- P.N. 111029 Hex crimp tool
- P.N. 100192 Wire Stripper

### Optional

- P.N. 110804 Butane refill

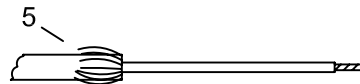
### Assembly Instructions

#### Cable prep.



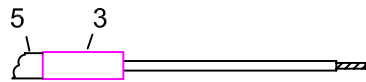
#### Connector Installation

1. Unbraid shielding and fold back over kapton.



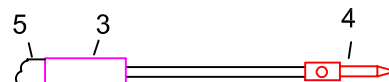
\* Make sure no conductor wires have been cut.

2. Slide SS Wire sleeve (#3) onto wire and cover shielding.



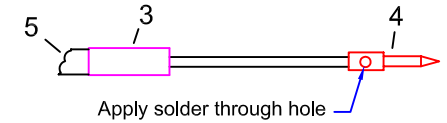
\* SS sleeve should cover 100% of shielding for best results

3. Dip exposed conductor into flux P.N. 110797.  
Slide pin onto conductor



\* Pin must be flush with kapton for best results.  
This helps to stabilize the pin from side to side movement.

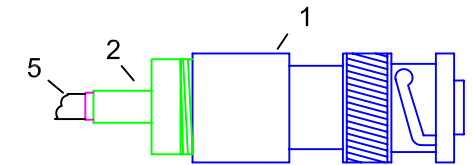
4. Solder using UHV compatible solder P.N. 110796 and Butane soldering iron P.N. 110800.



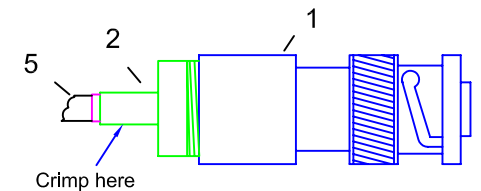
Apply solder through hole

\* Caution: If solder overfills hole, connector installation can not continue. Re-heat and scrape off excess solder with razor blade.

5. Screw Body (#1) and Crimp sleeve (#2) together first, then insert cable into connector assembly. Check pin position.



6. Use hexagon crimp tool P.N. 111029 size.128 to crimp the Crimp sleeve (#2) and SS Wire sleeve (#3) to the wire.



Crimp here

7. Test cable for continuity.

8. Clean with ultrasonic bath of Isopropyl Alcohol for 5 minutes min.

### Notes



Accu-Glass Products Inc.  
700 Arroyo Ave.  
San Fernando, CA. 91340  
TEL. 818-365-4215  
FAX. 818-365-7074

Material

Title

MHV-P

Tolerances unless otherwise specified  
Decimal      Angular  
.xx= +/- .005      +/- 1°  
.xxx= +/- .002

Drawn By

M.Wilson

DWG NO.

A111024

Date  
2-21-07

Approved

SHEET