

Connector Installation instructions for a
QDS-MALE Clamp-on for T-COM 600

Connector part number:

3190-846

TC-600-QDSM

ADDS : 0.950"

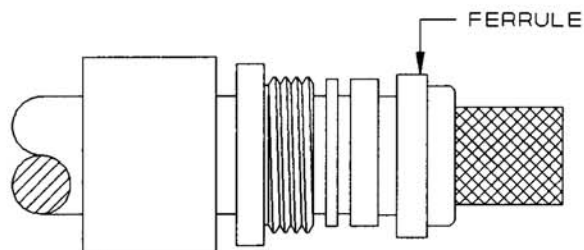
REV. A DATE: 02-10-00

Eng: MS App: RA

CDC CHANGES: 21168, _____, _____

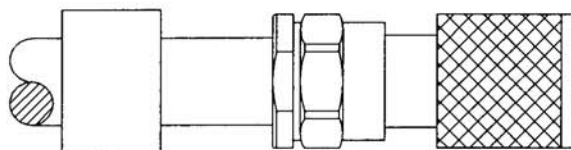
STEP 3. Slide on the Ferrule.

Make sure all braids come up thru the Ferrule as shown on the drawing.

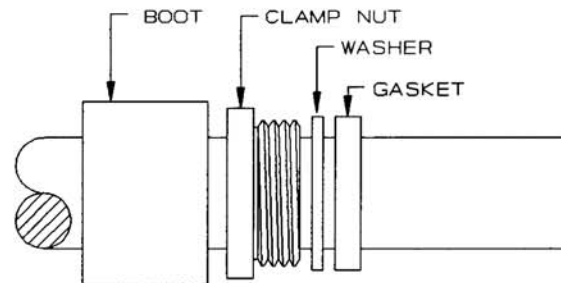


STEP 6. Install connector body onto cable.

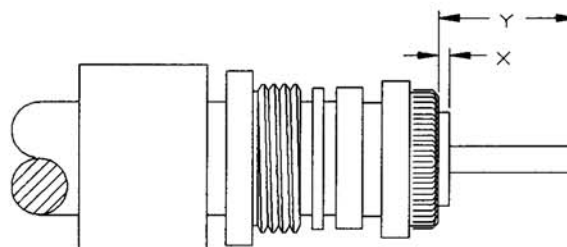
Check for proper pin height. Apply Loctite 242 (blue) to Clamp nut threads. Thread Clamp nut into conn body. Torque to 50 in-lbs. Check pin height.



STEP 1. Flush cut end of cable using a fine saw blade. Cut cable so that end remains round and face of cable is perpendicular to its length. Slide on: Shrink boot, Clamp nut, and Gasket.

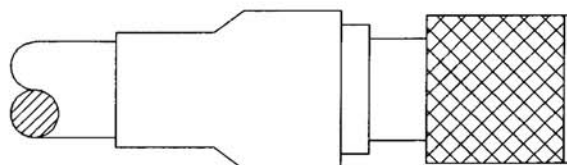


STEP 4. Flare out outer braid & fold them back onto Ferrule. Remove inner tape & fold inner braid back over outer braid. Trim braids to shoulder as shown. Trim core X = 0.070" Trim conductor back to this dimension: Y = 0.320"



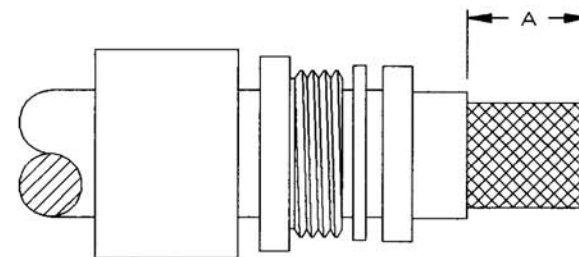
STEP 7. Install strain relief boot.

Position boot onto connector body. Apply hot air until boot is smoothly seated onto both cable and connector. Use only adhesive lined shrink boot.



STEP 2. Expose Braids. A = 0.500"

Cut thru cable jacket. Do not nick the cable braids.



STEP 5. Install contact. C = 0.020"

Solder on the contact using 63/37 solder. Feed solder thru solder hole while heating the contact.

