

Procedures Manual

Section No : **WI 200**

Title : **Procedure to terminate MINL-1 coax 6#22-ccp cable/moulded**

Page 1 of 3

1.0 SCOPE

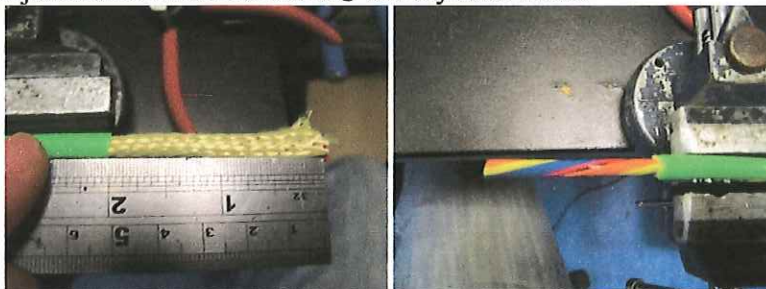
- 1.1 This procedure sets out the method for termination and assembly of MINL-1C/6#22-ccp over-moulded connectors. This procedure should be used in conjunction with drawing number 3809-1-B

2.0 PREPARATION

- 2.1 De-grease metal work with a suitable de-greaser.
- 2.2 Assemble the metal work in accordance with the manufacturers drawing.
- 2.3 Grit blast the areas to be moulded and prime with etch-primer. Allow to dry
- 2.4 Place the internal o ring (13) inside the metal work and the external o ring (12) on the face.
- 2.5 Slide the metalwork onto the cable with the engaging nut outermost.

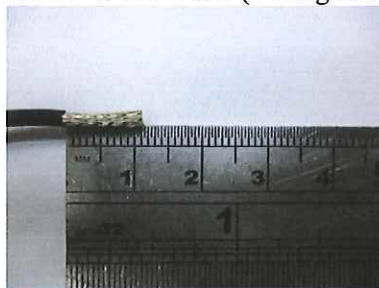
3.0 TERMINATION

- 3.1 Strip 2" of jacket and remove the Kevlar® and any cable fillers.



- 3.2 Thread the cable boot over the coax cable.

- 3.3 Strip 11mm of the outer jacket off the coax cable (making sure none of the screen is damaged)



Notes	Initials	Rev	Date	Comment
© This document contains company sensitive information and should not be copied, distributed or held in an information retrieval system without the express permission of SEACON (europa) Ltd.		0	25 / 04 / 2013	Initial Issue
		1	28 / 10 / 2013	Modified termination to include 'dog-leg'
OWNER OF PROCEDURE:	PRODUCTION			

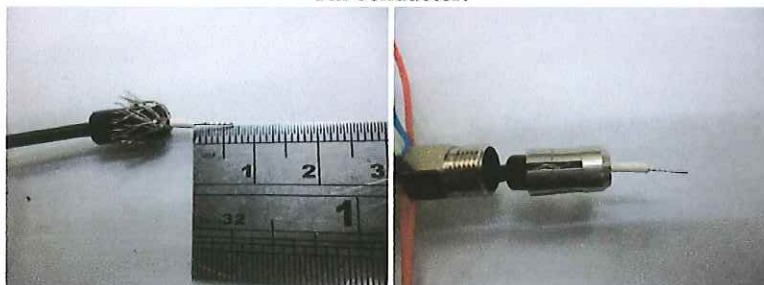
Procedures Manual

Section No : **WI 200**

Title : **Procedure to terminate MINL-1 coax 6#22-ccp cable/moulded**

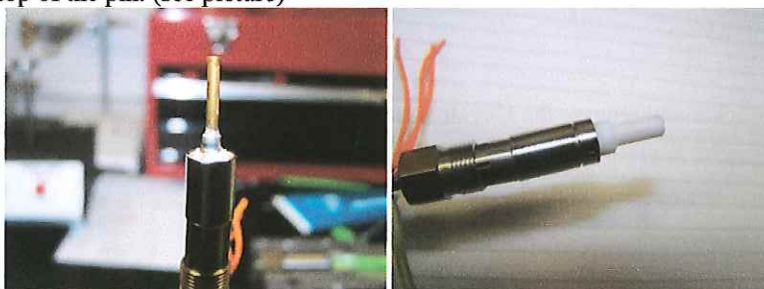
Page 2 of 3

- 3.4 Pick the screen open and bend back over the rubber boot then remove 6mm of dielectric from conductor.
Tin conductor.

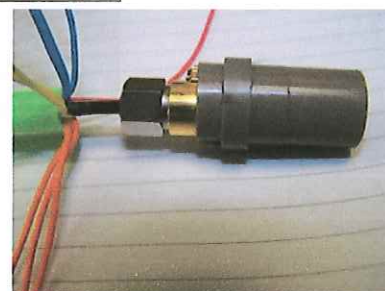


- 3.5 Slide the nut over the screen and boot. The clamp should then be put over the screen; this should sit on top of the boot. Make sure all the screen is held under the clamp.

- 3.6 Place the pin assembly over the core and secure in two vices. Ensure the core can be seen in the hole in the pin and solder. Make sure there is a good flow of solder through the hole in the pin. Fit the plastic shroud onto the top of the pin. (see picture)



- 3.8 Bring the nut and screw into the connector (see picture), tighten with a spanner. (do NOT over tighten)



- 3.9 Place assembly between 2 vices putting a slight "dogleg" in the coax. Solder the remaining six wires in accordance with the customer's requirements keeping all of the wires the same length.



Notes	Initials	Rev	Date	Comment
© This document contains company sensitive information and should not be copied, distributed or held in an information retrieval system without the express permission of SEACON (europe) Ltd. OWNER OF PROCEDURE: PRODUCTION		0	25 / 04 / 2013	Initial Issue
		1	28 / 10 / 2013	Modified termination to include 'dog-leg'

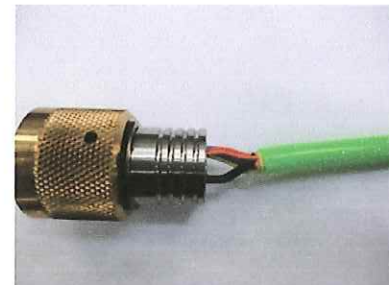
Procedures Manual

Section No : **WI 200**

Title : **Procedure to terminate MINL-1 coax 6#22-ccp cable/moulded**

Page 3 of 3

- 3.10 Locate the insert into the CCP shell, fit the spacer and spiral ring
Ensure that all wires have some slack and are not strained.



4.0 TESTING

- 4.1 Test in accordance with WI50.

5.0 MOULDING

- 5.1 Mould in accordance with WI5

Notes	Initials	Rev	Date	Comment
© This document contains company sensitive information and should not be copied, distributed or held in an information retrieval system without the express permission of SEACON (europa) Ltd. OWNER OF PROCEDURE: PRODUCTION		0	25 / 04 / 2013	Initial Issue
		1	28 / 10 / 2013	Modified termination to include 'dog-leg'