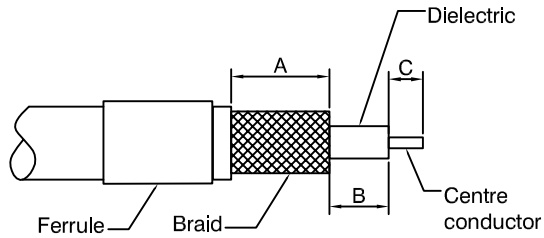


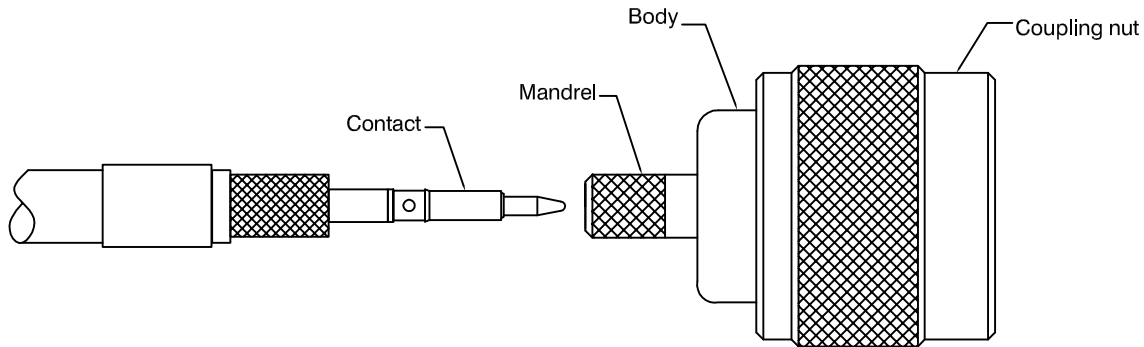
Assembly Instructions

1) Slide the ferrule onto the cable. Strip the cable to the dimensions shown. Take care not to nick the centre conductor or braid.

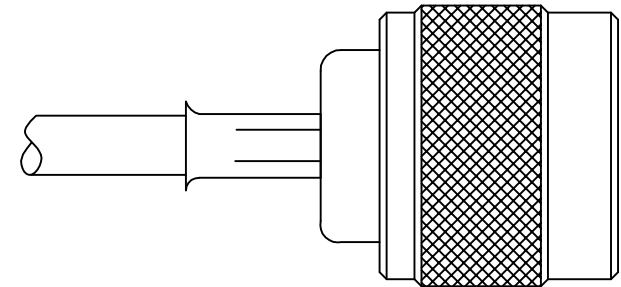
A = 7.5mm
B = 4.5mm
C = 4mm



2) Solder the contact onto the centre conductor.



3) Insert the contact into the body and ensure that the contact captivates. Make sure the braid is on the outside of the mandrel. Slide the ferrule over the braid until the ferrule butts up against the body. Crimp the ferrule using the correct tool for the connector.



Connector Part Number	Stripping Tool Part Number	Crimp Tool Part Number	Hex Size	
			Contact	Ferrule
VN10-2019	N/A	CCC2561	Solder	10.9
VN10-2020	N/A	CCC2561	Solder	10.9
VN10-2020-1602	N/A	CCC2561	Solder	10.9
VN10-2021	N/A	CCC2561/1	Solder	10.9
VN10-2031	N/A	DCC1113	Solder	6.48
VN10-2031-1602	N/A	DCC1113	Solder	6.48
VN10-2050	N/A	DCC1113	Solder	5.41
VN10-2050-1603	N/A	DCC1113	Solder	5.41
VN10-2050/1	N/A	DCC1113	Solder	5.41
VN10-2051	N/A	DCC1113	Solder	5.41

Deleted VN10-2142	MS	6	21 Jan 13
Added VN10-2142	KA	5	27 May 08
Changed assembly instruction	AT	4	23 Feb 05
Crimp tool and hex changed for VN10-2021	SN	3	02 Jan 01
CAD Issue	SN	2	26 Sept 01
First Issue	AT	1	02 Nov 98
DESCRIPTION OF REVISION	APPVD	ISS	DATE



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F: +44 124 535 8938

SCALE: Not To Scale

DIMENSIONS: mm

TOLERANCES:

DRAWN BY:

S Nash

CHECKED BY:

M Nielsen

APPROVED BY:

S Nash

DATE:

02 Jan 02

DESCRIPTION:

Stripping and Assembly
Instructions for N Crimp Plug

DRAWING NUMBER:

VAIN1101

PAGE: