

## Contact Assembly Instructions — Section 9

Twinaxial Terminal (Receiver)  
P/N 610 113 144 - Female

## INSTRUCTIONS:

1. Install 0.250" diameter clear tubing 0.750" long on wire. Install back shell on wire. (**Fig. A**)
2. Strip outer insulation 0.50". Trim braid back to 0.125". (**Fig. B**)
3. Strip wires 0.062".
4. Install one piece of 0.062" diameter clear tubing 0.125" long on blue wire and one on white wire.
5. Solder white wire on center conductor. (**Fig. C**)
6. Solder blue wire on inner shield contact. Check for shorts at this time.
7. Clean terminals and push both pieces of shrink tubing and shrink. Screw backshell onto connector until tight. Check referenced dimension to make sure backshell is seated properly. Solder backshell to braid through hole on backshell and clean. (**Fig. D**)
8. Push clear tubing over backshell inspection hole and shrink. (**Fig. E**)
9. Check for shorts and continuity.

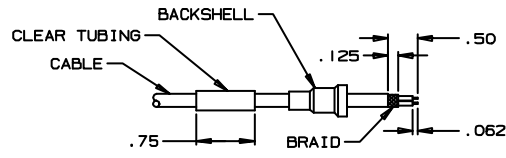


FIGURE A

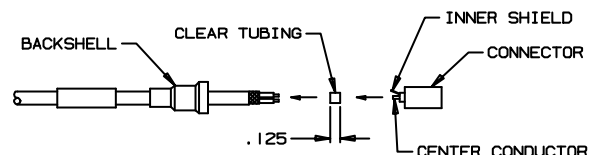


FIGURE B

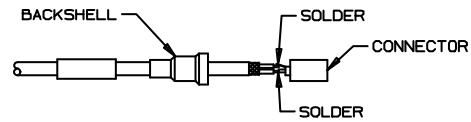


FIGURE C

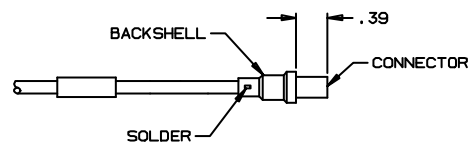


FIGURE D

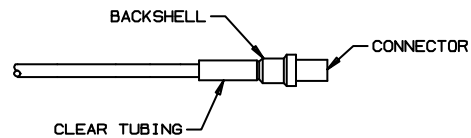


FIGURE E