

Contact Assembly Instructions — Section 9

Twinaxial Terminal (ITA)  
P/N 610 113 145 - Male

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" 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 taugt. Check referenced dimension to make sure backshell is seated properly. Solder backshell 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.

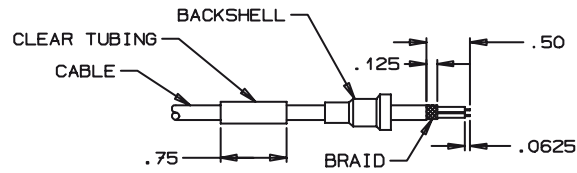


FIGURE A

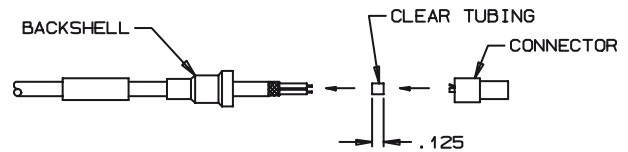


FIGURE B

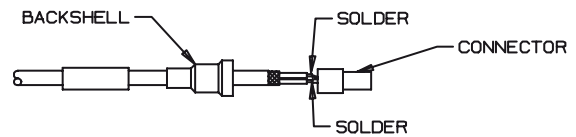


FIGURE C

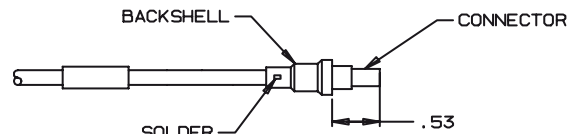


FIGURE D

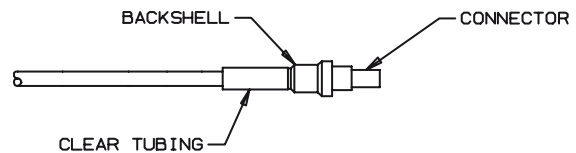


FIGURE E