

Connector Installation instructions for a
716-DIN FEMALE Clamp-on for LMR-600

Connector part number:

3190-375

TC-600-716FC

ADDS : 0.400"

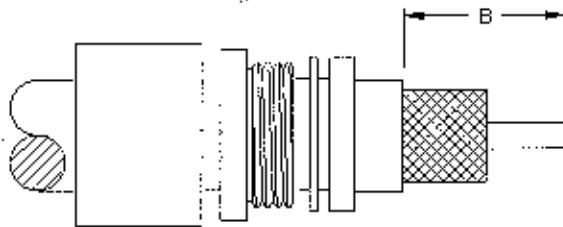
REV. B DATE: 11-11-96

Eng: JP App: JP

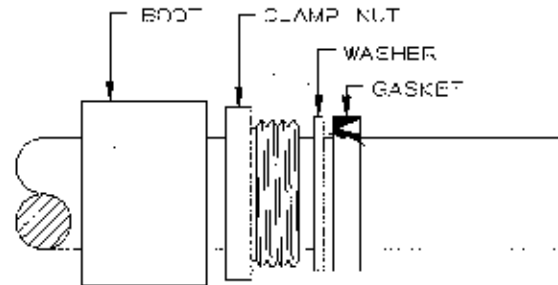
CDC CHANGES: 18800

STEP 3. Expose outer braid. $B = 0.500''$

Do not to nick the braids when removing the cable jacket.

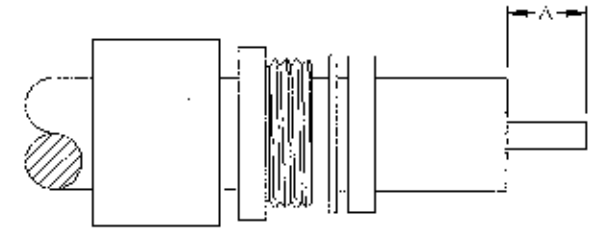


STEP 1. Flush cut end of cable using a fine saw blade. Cut cable so that end remains round and face of cable is perpendicular to its length. Slide on: Shrink boot, Clamp nut, Washer, Gasket.



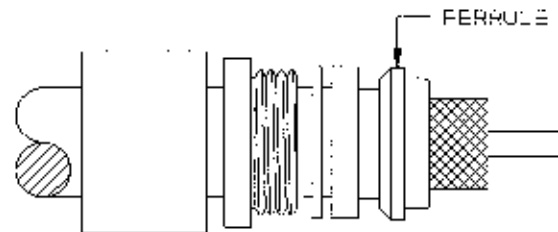
STEP 2. Expose conductor. $A = 0.250''$

Cut thru cable jacket, braids, and dielectric core Do not nick the cable conductor.



STEP 4. Slide on the Ferrule.

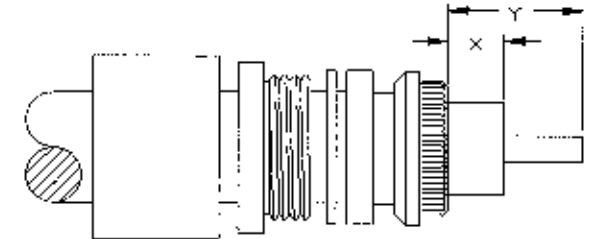
Make sure all braids come up thru the Ferrule as shown on the drawing. Use tape at end to hold braids if necessary.



STEP 5. Flare out braids but do not comb them out. Trim braids to shoulder of ferrule.

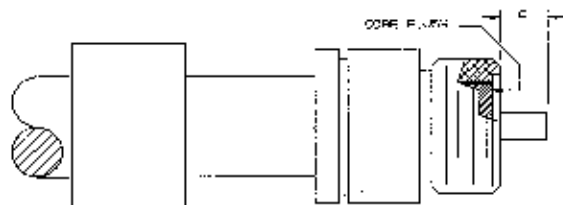
Trim core back to this dimension: $X = 0.115''$

Trim conductor back to this dimension: $Y = 0.350''$



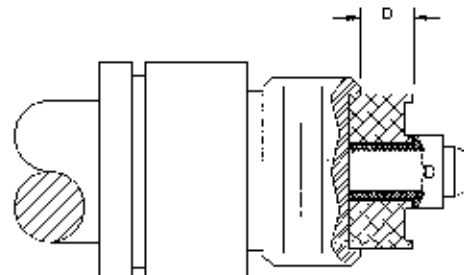
STEP 6. Install Conn Body. $C = 0.200''$ MAX.

Check for proper pin height. Apply Loctite 242 (blue) to Clamp nut threads. Thread Clamp nut into conn body. Torque to 130 in-lbs.



STEP 7. Solder on Contact. $D = 0.161''$

Solder on the contact using 60/40 solder. Feed solder thru solder hole while heating the contact. Spacer to be oriented as shown.



STEP 8. Install Body & Strain relief boot.

Thread on front body. Torque to 130 in-lbs. Position boot onto connector body. Apply hot air until boot is smoothly seated onto both cable and connector. Use only adhesive lined shrink boot.

