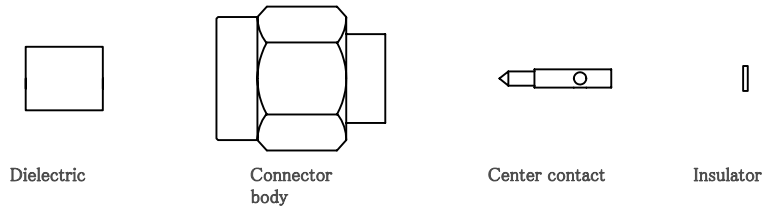




Specification No.	Connector	Cable type
SH080916-01	AX-119P	SC-119/50 series

Supplied parts



1. Strip cable

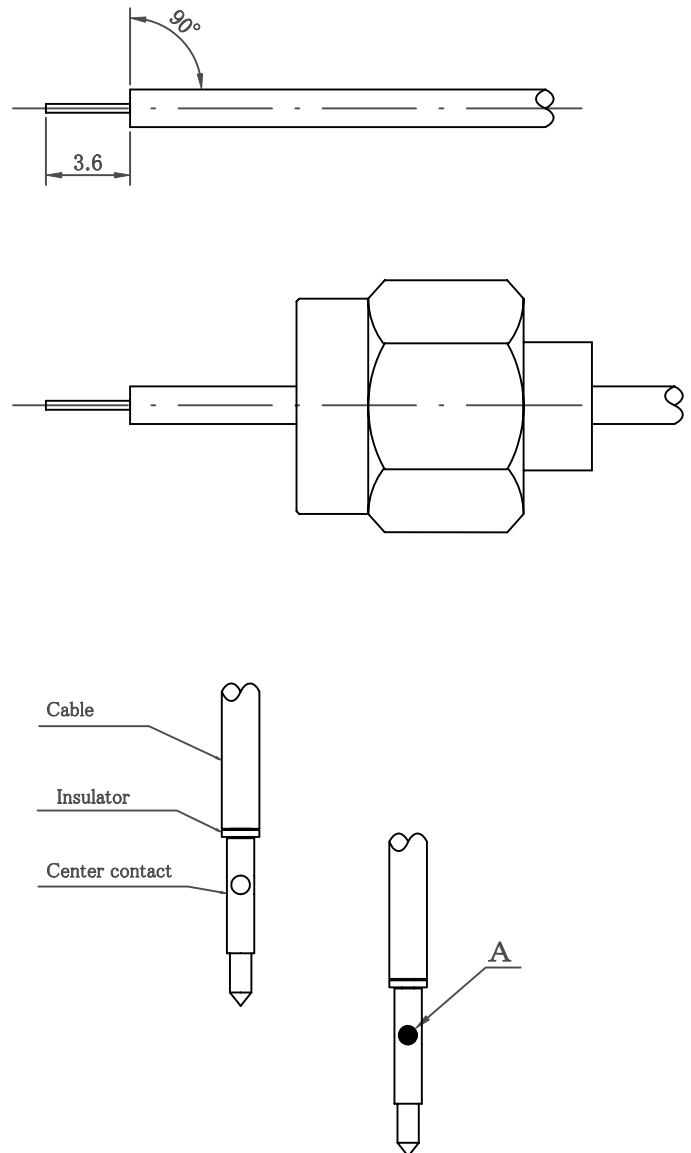
- (1) Remove cut outer conductor and dielectric from cable per diagram. Do not damage center conductor and cut cable end needs to be plain.

2. Insert stripped cable into connector body.

3. Soldering of center contact

- (1) Insert insulator onto exposed center conductor of cable, then insert center contact and fix the position.
- (2) Solder center conductor and center contact with the fixed position. Try to solder in a short time.
- (3) Check part "A" uniformly and adequately soldered.

4. Clean rosin flux



Unit : mm

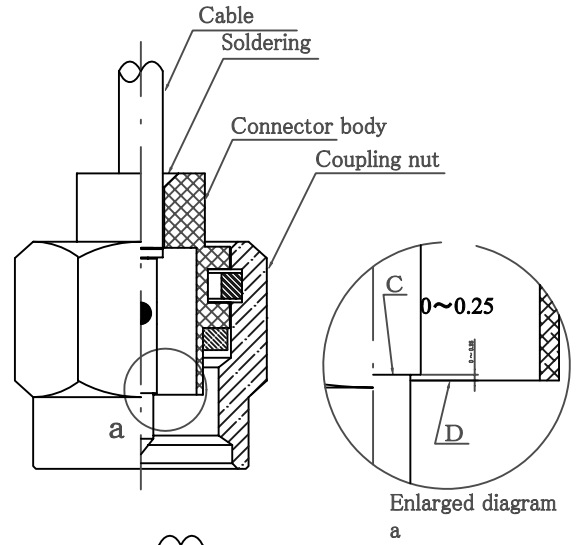
※ Please try to solder in a short time.

Date	Approved	Checked	Drawn
16.Sep.2008	Kasai	Seino	Kasai

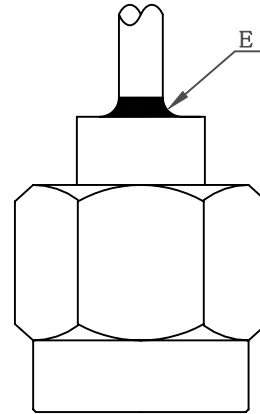
Specification No.	Connector	Cable type
SH080916-01	AX-119P	SC-119/50 series

5. Soldering connector body

- (1) Set position of center contact part "C" and connector body part "D" as shown enlarged diagram "a".



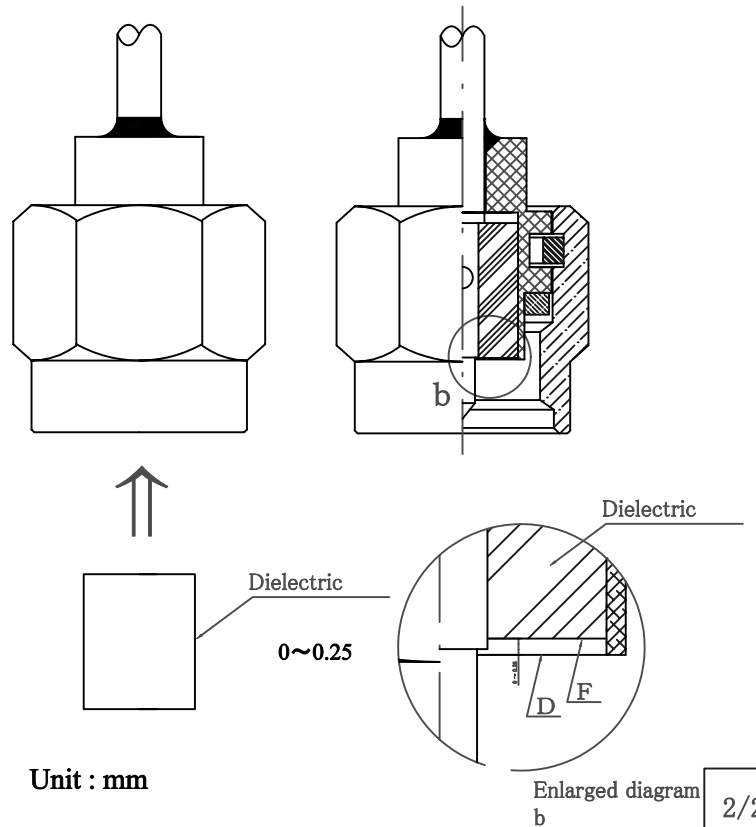
- (2) Solder connector body and cable with fixed position. Try to solder in a short time.
- (3) Inspect solder covers part "E" uniformly.



6. Clean rosin flux

7. Insertion of dielectric

- (1) Inspect inside of connector body is clean and dry before insertion.
- (2) Insert dielectric into connector body. Position of part "F" of dielectric does not extrude part "D" of connector body as enlarged diagram "b".



Unit : mm

Enlarged diagram b