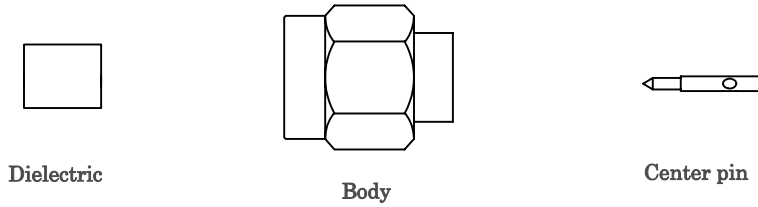




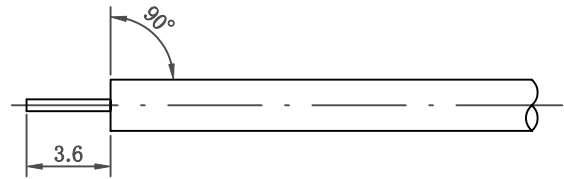
Specificatin No.	Connector	Cable type
SH991020-01	AX-219P , AX-219P-NM	SC-219/50 series

Supplied parts



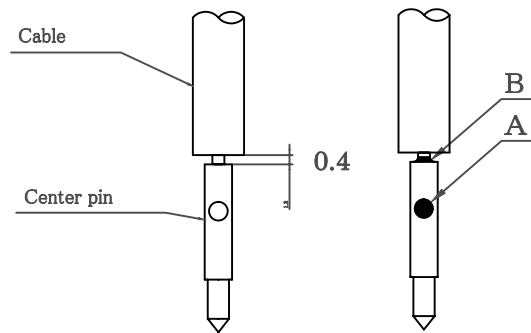
1. Strip cable

- (1) Strip center conductor 3.6mm per diagram.
Do not damage center conductor.
Cut cable end needs to be plain.



2. Soldering center pin

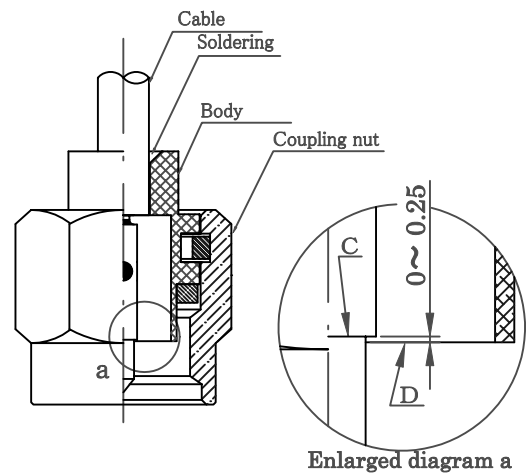
- (1) Insert center conductor of the cable into center pin until firmly fixed.
- (2) Solder center conductor of the cable and center pin. Try to solder in a short time.
- (3) Check at part A & B, uniformly and adequately soldered.



3. Clean rosin flux

4. Soldering connector body

- (1) Fix position of face C of center pin and face D of connector body as enlarged diagram "a".

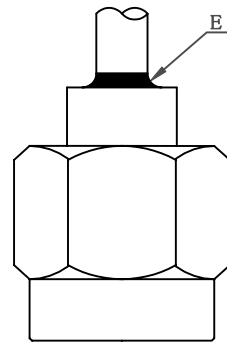


* Please try to solder in a short time.

Date	Drawn	Checked	Approved
'99. 10. 20	Kasai	Seino	Kasai

Specification No.	Connector	Cable type
SH991020-01	AX-219P , AX-219P-NM	SC-219/50 series

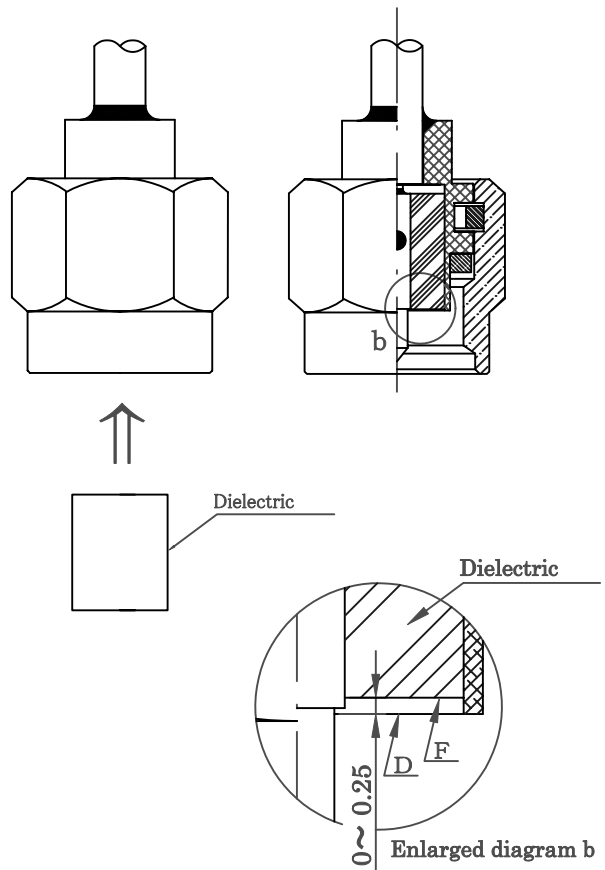
- (2) Solder connector body and cable as diagram. Soldering needs to be short time and avoid excessive heat.
- (3) Inspect solder covers part E uniformly.



5. Clean rosin flux

6. Insertion of dielectric

- (1) Inspect inside of connector body is clean and dry before insertion.
- (2) Insert dielectric into connector body. Do not extrude face F of dielectric from face D of connector per enlarged diagram "b".



* Please try to solder in a short time.