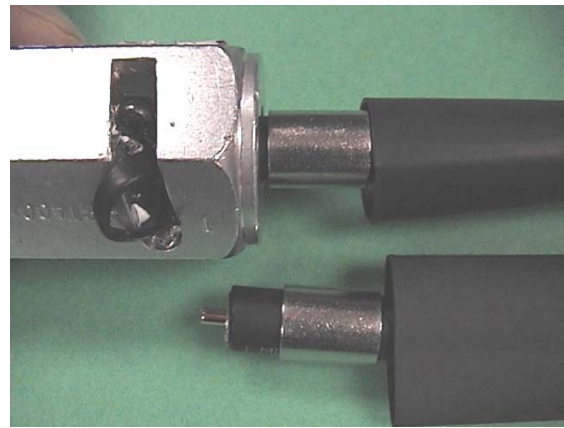


TC-400-NM Connector Installation Procedure on LMR-400

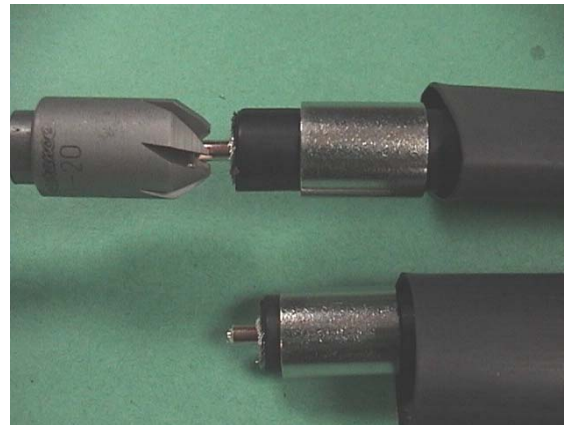
1. Flush cut the cable squarely.



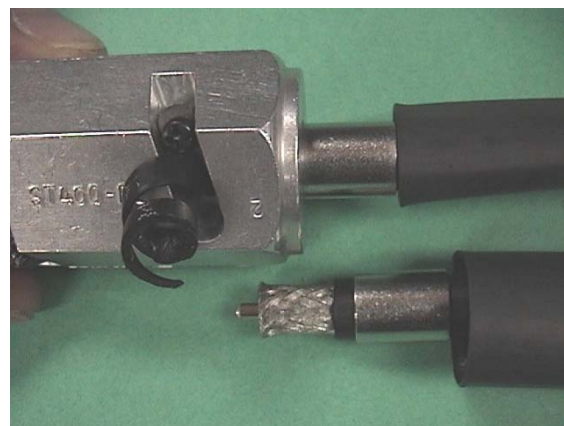
2. Slide the heat shrink boot over the end of the cable, followed by the ferrule. Slide End 1 of the ST-400-EZ prep/strip tool over the end of the cable and rotate it in a clockwise motion. Spin the tool till it spins freely (let the tool do the work). Remove the tool and remove any residual plastic from the center conductor by rotating a knife around the circumference of the center conductor at the face of the core.



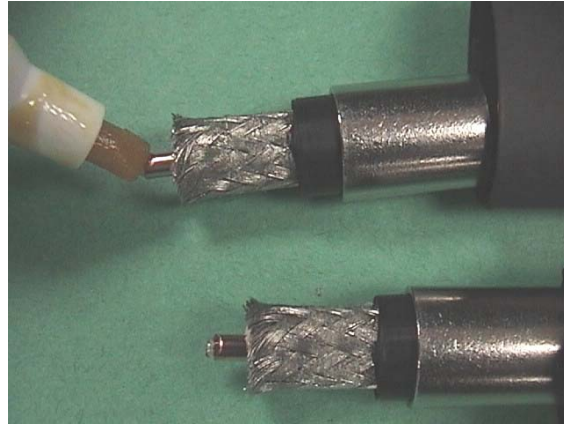
3. Debur the center conductor using the DBT-01 deburring tool or a file.



4. Insert the cable into End 2 of the ST-400-EZ prep/strip tool and rotate the tool in a clockwise motion until the tool spins freely. Remove the tool (If you are using a knife to accomplish this step, be careful not to nick the braids).



5. Apply a small amount of RMA flux around the exposed center conductor.



6. Place a piece of 0.025" diameter, 63/47 solder into the pin until it bottoms. Trim the solder flush with the back of the pin with a knife. Place a 0.010" shim over the cc and up against the core (a razor blade will do). Now place the pin over the center conductor and heat the base of the pin with a soldering iron while monitoring the weep hole in the pin. Remove the heat when you have seen the solder has flowed and wetted properly.



7. Remove the shim and slide the connector over the pin. Once the connector has been pushed all the way on so that the connector bottoms out onto the core, slide the ferrule over the braid, making an impression in the braid at the point that it protrudes between the ferrule and the connector. Trim the braid at this impression with a scissors.



8. Make sure that the connector is bottomed. Bring the ferrule all the way up to the back of the connector. Check the pin height with a pin gauge. Crimp the ferrule close to the connector with a CT-400 or equivalent tool. **DO NOT SECOND CRIMP**. A second crimp further back on the ferrule will end up compressing the core and cause degradation of performance. Slide the boot up to the back of the coupling nut and shrink with a heat gun until a lip of adhesive can be seen at both ends of the boot.

