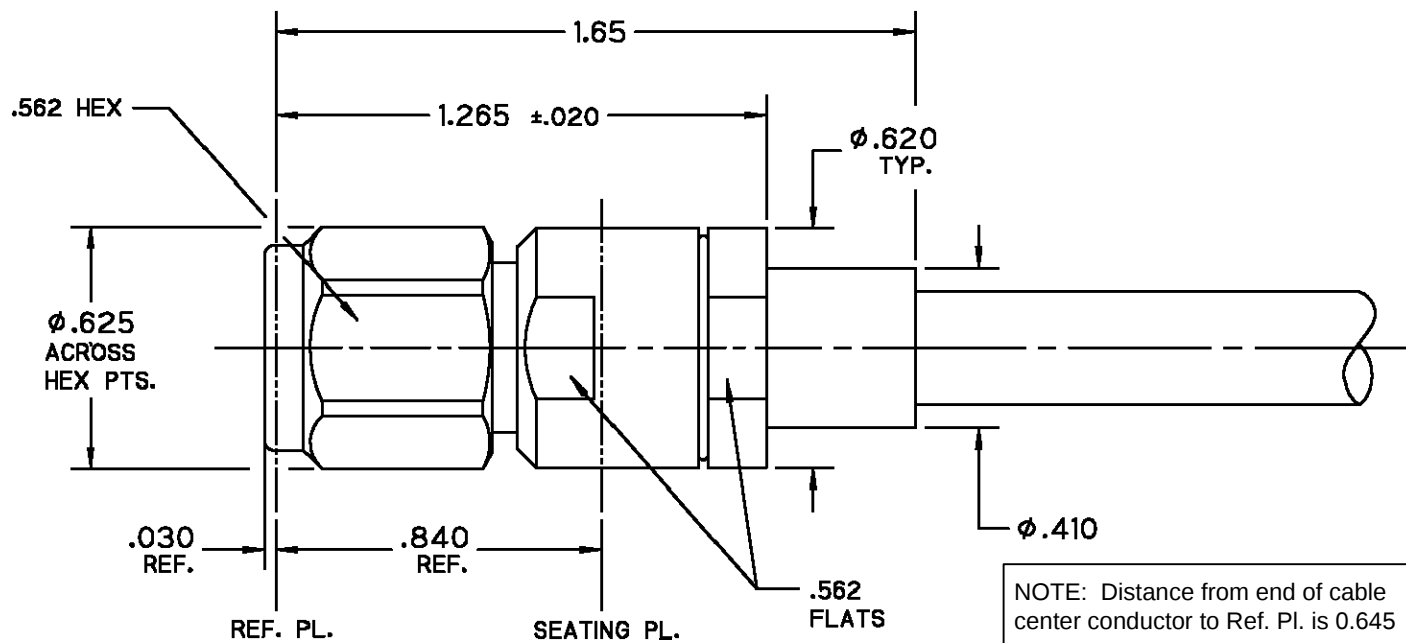




TNCA Plug, Solder Clamp for Semflex LA290 Cable



NOTES:

1.0 Materials

- 1.1 Body, Coupling, and Clamp Nut: Steel. Corrosion Resistant per ASTM-A582. UNS No. S30300.
- 1.2 Center Conductor: Beryllium Copper per ASTM-B196. UNS C17300.
- 1.3 Solder Ferrule: Brass per ASTM-B16. UNS C36000.
- 1.4 Lock Ring: Beryllium Copper per ASTM-B197. UNS C17200.
- 1.5 Gasket and O-Ring: Silicone Rubber per A-A-59588.
- 1.6 Insulator: PTFE Fluorocarbon per ASTM-D1710.
- 1.7 Cable Stop: Polyetherimide Thermoplastic (ULTEM 1000) per ASTM-D5205.

2.0 Finishes

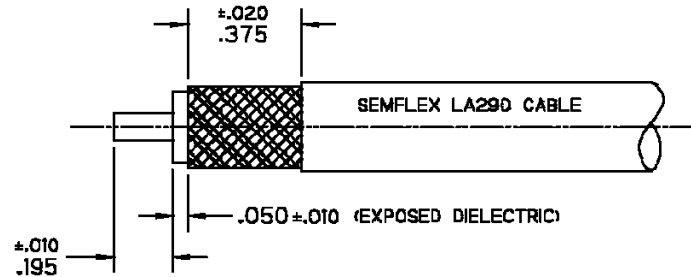
- 2.1 Center Contact and Solder Ferrule: Gold Plate per ASTM-B488 50 Microinches Min. thickness over Electrolytic Nickel Plate per ASTM-B689 50 Microinches Min. thickness.
- 2.2 Body, Coupling, and Clamp Nuts: Passivated per SAE-AMS-2700.
- 2.3 Gasket, O-Ring, Lock Ring, and Dielectrics: None.

3.0 Interface: TNCA Plug per MIL-STD-348. Figure 313-3.



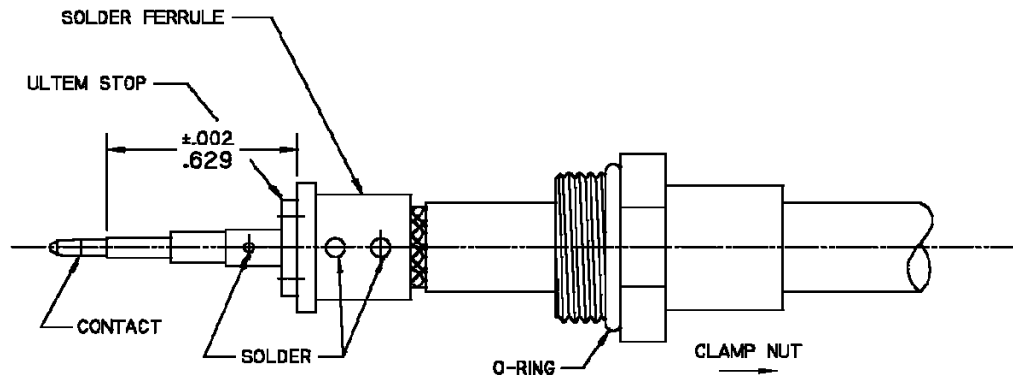


TNCA Plug, Solder Clamp for Semflex LA290 Cable



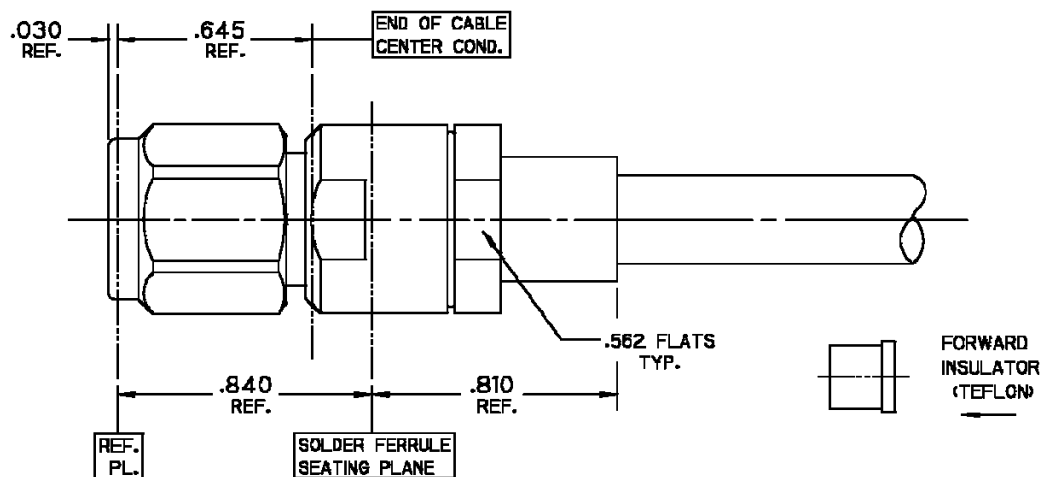
Step 1

1.1 Trim Cable as shown.



- 2.1 Slide clamp nut over cable as shown.
2.2 Insert cable into solder ferrule until cable dielectric is flush with face of ferrule. Then solder both cable braids where shown.
2.3 Slide dielectric stop over cable center conductor and solder contact flush against stop to dimension shown.

Step 2



- 3.1 Insert forward insulator into connector in orientation shown.
3.2 Insert cable/contact sub-assembly into connector until seated and tighten clamp nut to 35-45 in-lbs.

Step 3

Product Control:

Crystek Part Number:	CS-TM-MSD	Release Date:	04-Jan-11
Revision Level:	A	Responsible:	K. Piotrowicz



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