

DO NOT
SCALE FROM
THIS PRINT

PRF24-P-C-EP-086E-SS

SERIES
-24: 2.4mm

GENDER
-P: PLUG

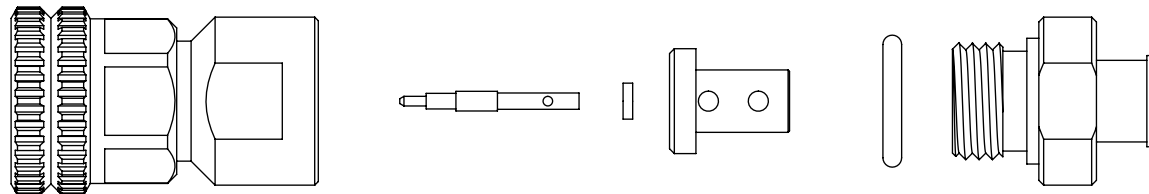
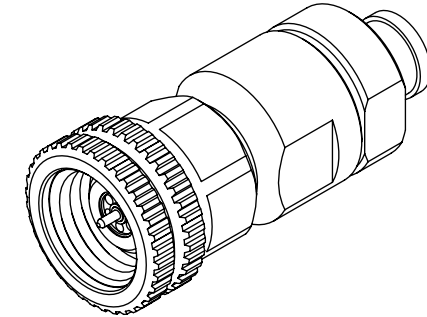
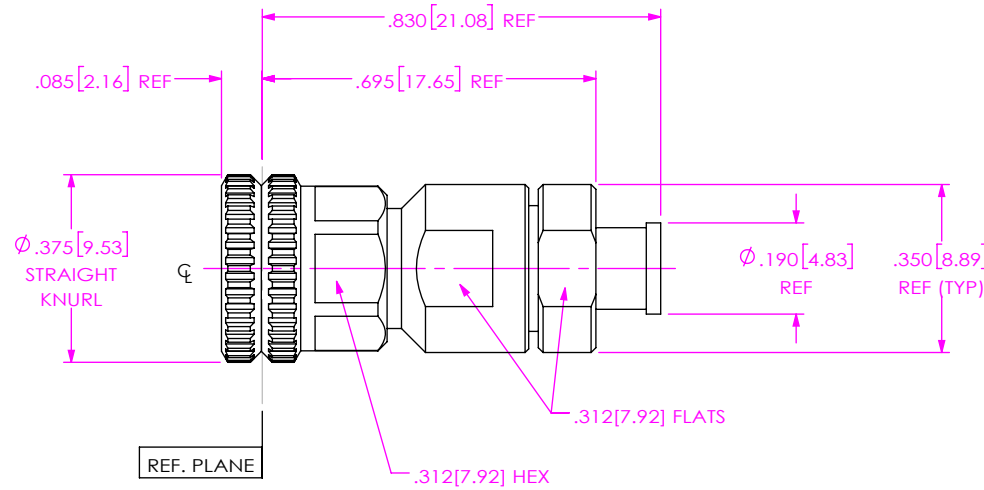
TYPE
-C: CABLE

TERMINATION
-S: SOLDER CLAMP

ORIENTATION
-S: STRAIGHT

CABLE TYPE
-086E: DYNAWAVE DF165

FINISH
-EP: 50μ" EXTRA HEAVY GOLD
CENTER CONTACT, PASSIVATED
OUTER CONTACT



EXPLODED VIEW
NOT TO SCALE
(FOR CLARITY ONLY)

NOTES:

- MATERIAL:**
BODY, COUPLING NUT & CLAMP NUT: STAINLESS STEEL.
CONTACT & LOCK RING: BERYLLIUM COPPER.
SOLDER FERRULE: BRASS.
GASKET & O-RING: SILICONE RUBBER.
DIELECTRIC STOP: ULTEM 1000.
FORWARD BEAD: NORYL.
- FINISH:**
BODY, COUPLING NUT & CLAMP NUT: PASSIVATED.
CONTACT & SOLDER FERRULE: GOLD OVER NICKEL PLATE,
50 μ" MIN GOLD OVER 50 μ" MIN NICKEL.
- PCI P/N: 4214.

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN INCHES.
TOLERANCES ARE:
DECIMALS ANGLES
.XX: ±.01 [0.3] 1°
.XXX: ±.005 [0.13]
.XXXX: ±.0005 [0.013]

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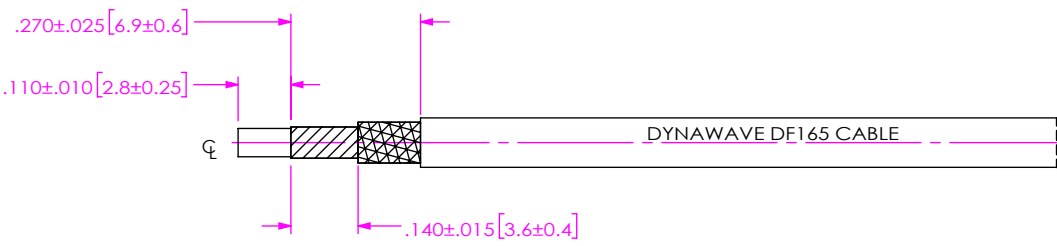
DO NOT SCALE DRAWING

SHEET SCALE: 2.5:1

DESCRIPTION: 2.4MM PLUG, SOLDER CLAMP FOR
DYNAWAVE DF165 CABLE

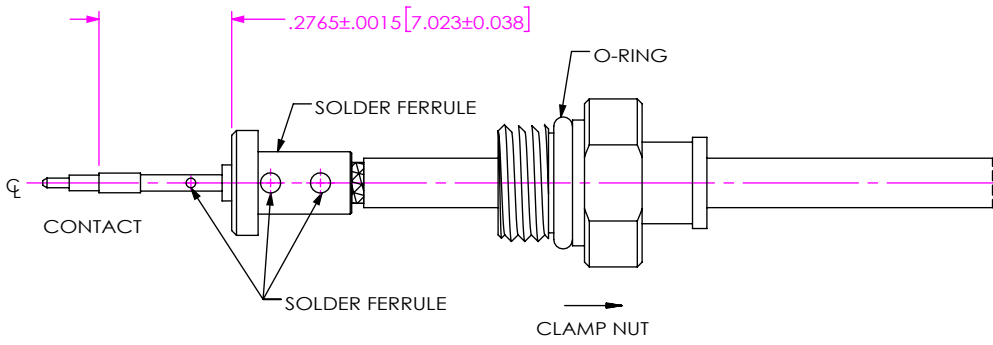
DWG. NO. PRF24-P-C-EP-086E-SS

BY: EVE L 01/07/2021 SHEET 1 OF 2



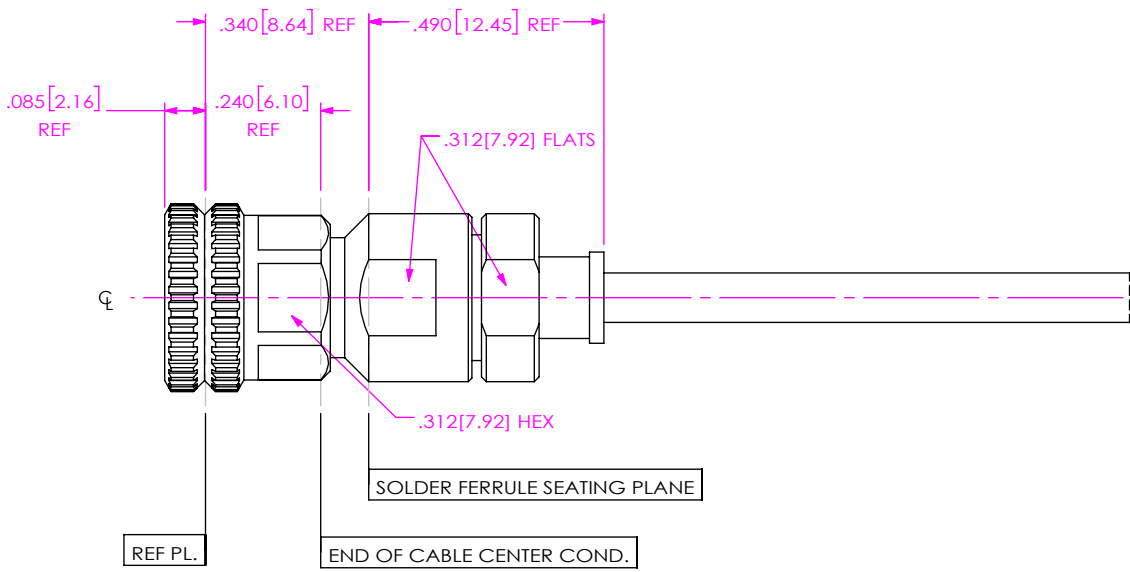
1A. TRIM CABLE TO EXPOSE DIELECTRIC CORE AND CABLE BRAIDS AS SHOWN.

IN-PROCESS 1



- 2A. SLIDE CLAMP NUT ONTO CABLE IN ORIENTATION SHOWN.
- 2B. INSERT CABLE INTO SOLDER FERRULE UNTIL FULLY SEATED. THEN SOLDER CABLE TO FERRULE WHERE SHOWN.
- 2C. TRIM CABLE DIELECTRIC FLUSH WITH FERRULE. (DO NOT SCORE CENTER CONDUCTOR.)
- 2D. SLIDE DIELECTRIC STOP OVER CABLE CENTER CONDUCTOR AND SOLDER CONTACT FLUSH TO STOP TO DIMENSION SHOWN.

IN-PROCESS 2



3A. INSERT CABLE SUB-ASSEMBLY INTO CONNECTOR BODY UNTIL SOLDER FERRULE IS SEATED AND TIGHTEN CLAMP NUT TO 25-35 IN-LBS.

IN-PROCESS 3

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	BY: EVE L 01/07/2021 SHEET 2 OF 2