Installation Instructions for 10-443090 (M85049/32), 10-450910, 10-443092 (M85049/33) and 10-450911 Series EMR Kits

Material and equipment

60% Tin - 40% Solder .030 in. dia.
Rosin Alcohol Flux (i.e., Kester #1544 Flux)
37-½ watt Soldering Iron

I. A. Screw threaded ring onto back of shell until the rear of the threaded ring extends 1/16 ± 1/64 above the rear threads of the connector.
B. Lightly flux area between I.D. of threaded ring and O.D. of connector threads. Place a ring of solder in this area. Using 37½ watt iron, solder ring to connector.

II. Soldering of Ferrule to Braid.
A. Strip cable braid and conductors to appropriate length.
B. Lightly pre-tin rear O.D. of ferrule.
C. Flux rear O.D. of ferrule and O.D. of cable braid.
D. Slide ferrule under braid and solder braid to ferrule using 37½ watt iron.

III. Soldering either straight ferrule adapter or 90° elbow ferrule adapter to ferrule.
A. If straight ferrule adapter is used.
a. Slide ferrule adapter over the ferrule and back on cable.
b. Solder conductors to contacts.
c. Flux rear O.D. of threaded ring.
d. Slide ferrule adapter down cable over the ferrule and onto the rear of the threaded ring.
e. Run soldering iron around the front circumference of the ferrule adapter until the solder plate on the ferrule adapter becomes liquid. More solder may have to be added to form the desired fillet.
B. Soldering ferrule to straight ferrule adapter.
a. Lightly pre-tin front O.D. of ferrule.
b. Slide ferrule into ferrule adapter until the radius on the ferrule reaches the rear of the ferrule adapter. (Insert ferrule in approximately .125 in.).
c. Support the cable so that the ferrule does not move while in the ferrule adapter.
d. Flux area between ferrule and ferrule adapter.
e. Solder ferrule to ferrule adapter using 37½ watt iron.

CAUTION

DO NOT FILL TWO HOLES IN FERRULE WITH SOLDER.

C. If 90° elbow adapter is used.
a. Slide 90° elbow adapter over ferrule and back on cable.
b. Solder conductors to contacts in connector.
c. Flux rear O.D. of threaded ring.
d. Slide elbow adapter onto threaded ring.
e. Run the soldering iron around the front circumference of the elbow adapter until solder plating becomes liquid. More solder may have to be added to form the desired fillet.
D. Soldering elbow cover to elbow adapter.
a. Pre-tin front of ferrule.
b. Bend cable 90° and place ferrule into elbow adapter.
c. Place elbow cover on elbow adapter and over ferrule.
d. Support cable so ferrule does not move.
e. Form a ring of solder around the area where the cover meets the adapter. Flux this area.
f. Run soldering iron around outside of elbow adapter until solder melts. More solder may have to be added in order to form the desired fillet.
E. Soldering of ferrule to elbow adapter and cover.
a. Make sure ferrule is inserted in ferrule adapter as in Step III, B.
b. Flux area between ferrule and elbow adapter and cover.
c. Heat ferrule with soldering iron and feed solder into groove until the desired fillet is formed around the circumference. It may be necessary to touch up the solder joints of the elbow cover and adapter. This can be done after the ferrule is soldered.

IV. Potting of connector.
A. Pressure pot ferrule adapter through large hole in front of ferrule adapter until potting compound flows out of the two small holes in the ferrule. This indicates that the potting operation is complete.