

Notes

Accu-Fast 500HV Assembly Instructions :

Single-Ended **MHV** and **SHV** (5kV DC) Vacuum-Side Connector Interface

See A111020 for AccuFast 500 (BNC) Wiring Instructions

Step-1 Strip and trim coaxial cable (4) jacket, braided shield, insulation and center conductor to specified dimensions. Use cable stripping tool 100192 set to #40 for .160 and #80 for .310 lengths. Coaxial cable TYP6, 26 AWG, 100720.

Step-2 Unbraid and comb cable shield strands back over Kapton jacket insulation. Distribute shield strands evenly around jacket perimeter as shown.

Step-3 Untwist center conductor strands and fold them back over Kapton insulation. Distribute conductor strands evenly around insulator perimeter as shown.

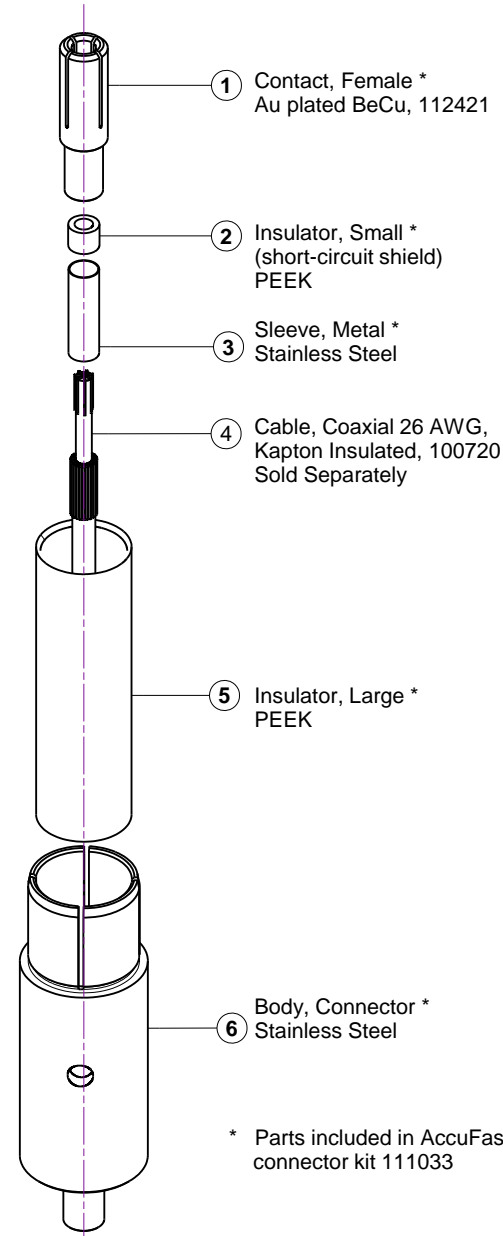
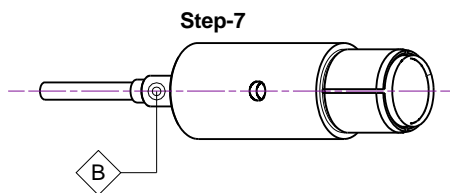
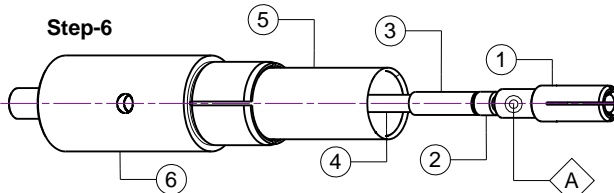
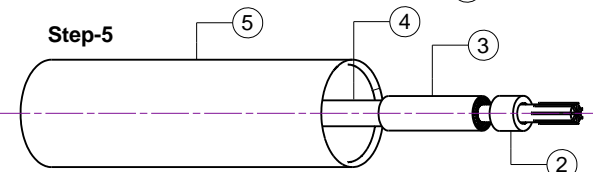
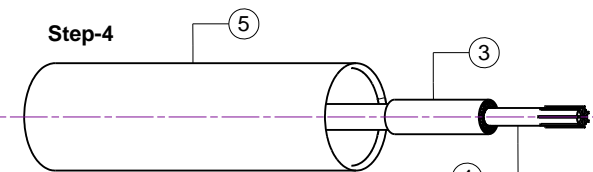
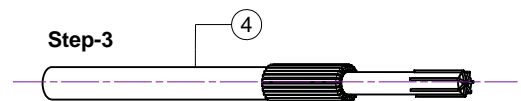
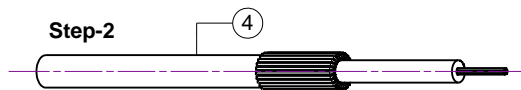
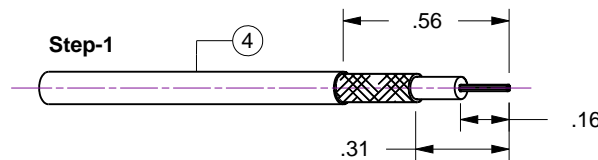
Step-4 Slide connector body (6) and large insulator (5) onto coaxial cable (large ID and counter-bore facing out)... then slide metal sleeve (3) over shield strands. **CAUTION, do not allow metal sleeve (3) to move completely past loose shield strand ends, as it's extremely difficult to pull this part back over shield strands.**

Step-5 Slide small insulator (2) over and past folded center conductor strands, allow it to butt up against metal sleeve and combed shield strands.

Step-6 Slide female contact (1) over folded center conductor strands until these bottom out inside contact's socket. Hex crimp in place using tool 100908 (set to size C), at location **A**. Rotate crimp tool 90 degrees and crimp once again.

Step-7 Slide large insulator (5) and connector body (6) over items (4), (3), (2) and (1). Verify that female contact (1) is properly seated against counter-bore shoulder, inside large insulator (5). Hex crimp in place with tool 100908 (set to size B) at location **B**

Step-8 Clean assembly in an ultrasonic bath of Isopropyl alcohol for five (5) minutes.



* Parts included in AccuFast 500 connector kit 111033

Rev	Description	Date
A	Initial Release	

UNCONTROLLED WEB DRAWING

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Material	
Tolerances, unless otherwise specified	
.X ± .030	Angles ± 0.5°
.XX ± .010	Finish 63Ra
.XXX ± .005	

Title			
AccuFast 500HV Instructions			
Drawn by	Ligeti	No.	Rev.
Date	7/8/2013	A111033	A
Approved			Sheet



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