Assembly Instructions

Audio Assembly Type Connector

For use with part number:

55-00146

Materials Needed

Assembly Connector

☐ Inner Sleeve (56-00002)
☐ Outer Sleeve (56-00003)
☐ Connector (50-00666)

Tools

☐ Soldering iron w/ solder
☐ Pliers (or other hand crimping tool)
☐ Wire stripping tool

Wire

☐ Round wire 2.5-5 mm outer
   diameter in desired length

Connector

Inner Sleeve

Outer Sleeve

Wire

1A. Locate the outer sleeve. Notice that the notches are numbered with the wire outer diameters.

1B. Find your desired wire diameter and cut outer sleeve at the notch above the number.

Example: This wire is 3.8 mm in diameter, so it was cut on the line above 4.

Tip: Round up to the nearest number if the wire's outer diameter is not available. For example, a wire that is 3.25 mm outer diameter will fit into the 3.5 mm notch but not the 3 mm notch.

5
4.5
4
3.5
3
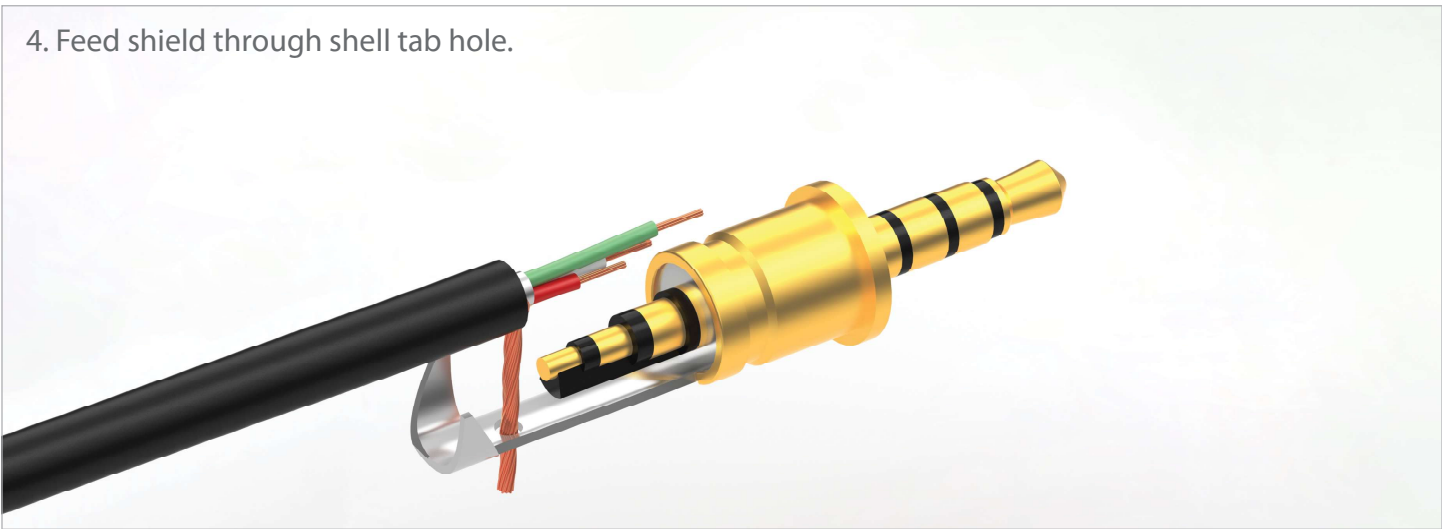
2A. Thread wire through the base of the outer sleeve.
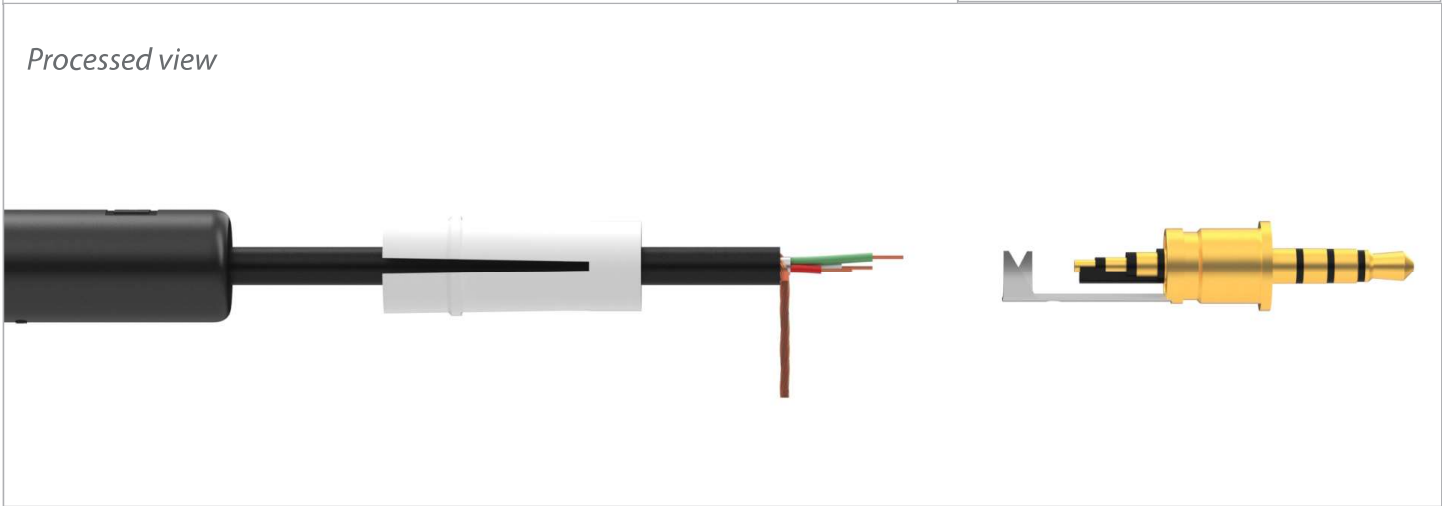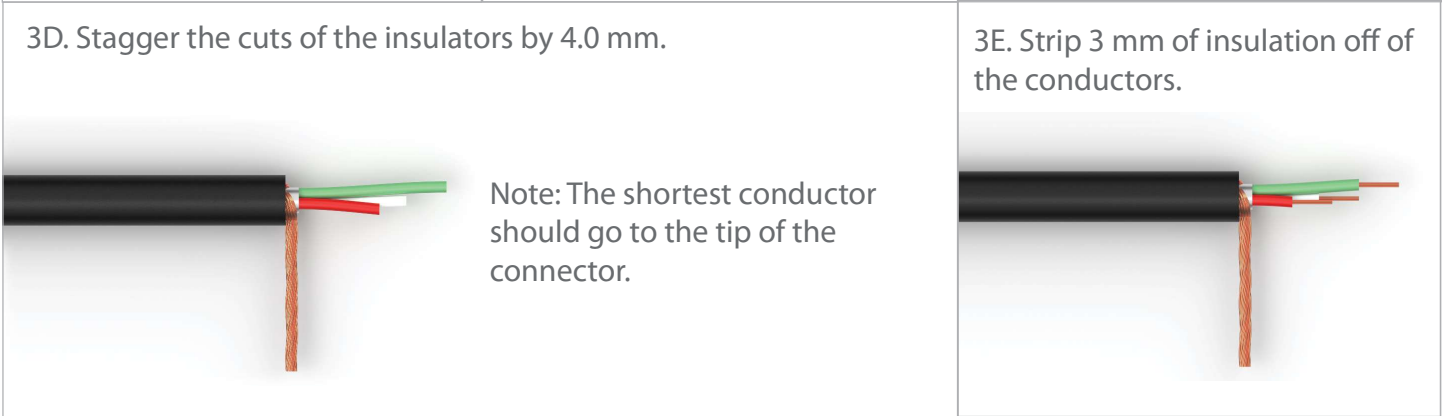
Result
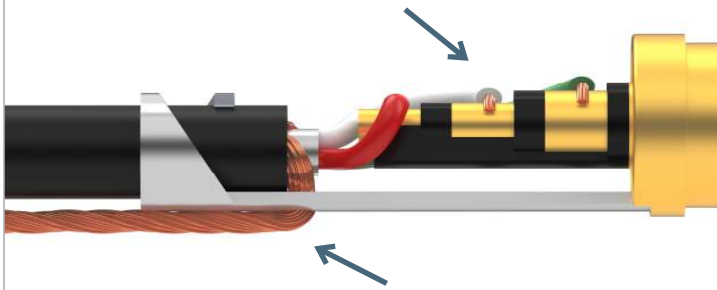
2B. Thread the wire through the the inner sleeve. These two steps must be completed prior to processing the wire.

3A. Strip 12 mm off of the blunt end of the jacket.

3B. Pull back and twist spiral shield together.

3C. Cut back foil shield to jacket.

3D. Stagger the cuts of the insulators by 4.0 mm.

Note: The shortest conductor should go to the tip of the connector.

3E. Strip 3 mm of insulation off of the conductors.

Processed view

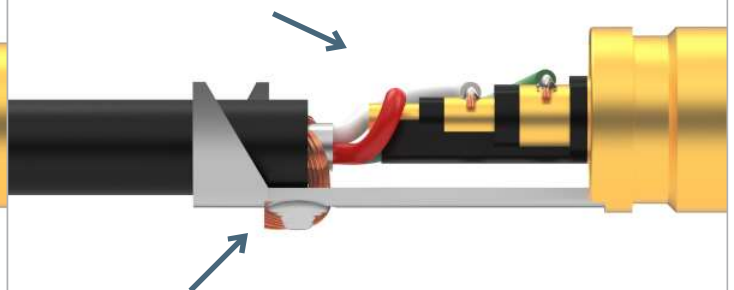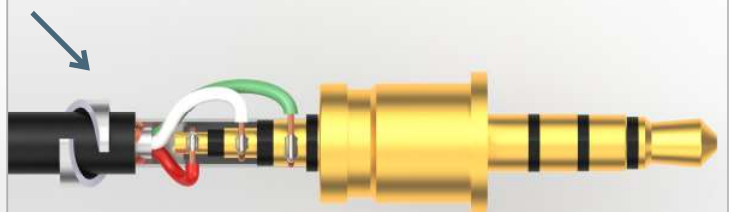**4.** Feed shield through shell tab hole.

5A. Arrange conductor onto their respective solder pads. Fold shield wire so that it is flat.

**5B .** Solder conductors to the connector and trim excess shield back to solder joint.

6. Using pliers, crimp shell tab to wire jacket. Try and avoid piercing the outer wire jacket.

Note: the wire should not slide when pulled.

7. Slide inner sleeve to the base of the connector collar. Note: the shell tab may need to be bent slightly in order to slide the inner sleave over the solder joints.
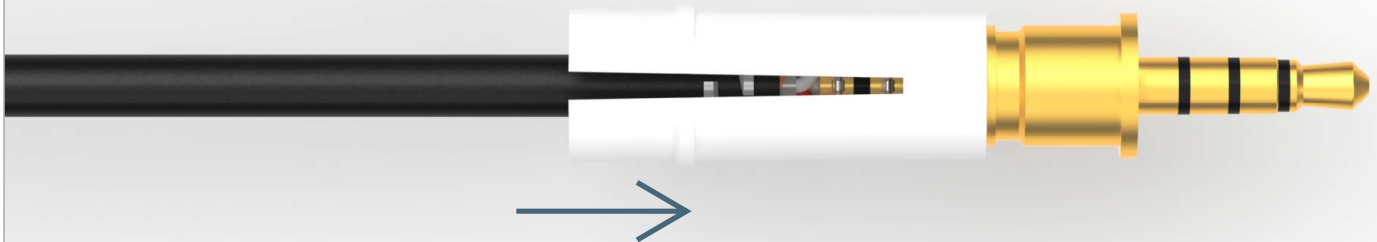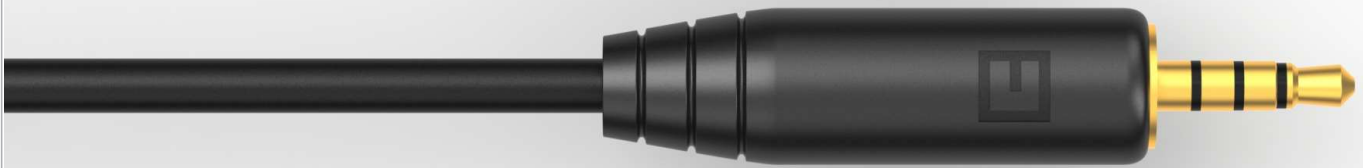
8. Snap the inner sleeve over the rest of the collar with your hands or an assembly tool.* Avoid breaking the tabs off of the inner sleeve.

*A 3D printable model of the assembly tool can be found on Tensility's website under part number 55-00167.

8. Slide the outer sleeve over the inner sleeve.

Note: the outer sleeve should not be able to slide off the inner sleeve easily once in position.

Completed cable: