

Fig. 1

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## 1. INTRODUCTION

This Instruction Sheet (IS) covers the selection and assembly of Series UHF Plugs listed in Figure 1. Read these instructions thoroughly before using the connectors.

### NOTE

Dimensions on this sheet are in millimeters [with inch equivalents in brackets].

## 2. DESCRIPTION

Figure 1 shows the plug connector assembly which consist of a plug body, a standard or long collar, and a step-down or straight ferrule. Plugs with long collars are crimped in hand tools only.

## 3. ASSEMBLY PROCEDURES

Determine the cable size needed for your application; then refer to the chart in Figure 1 and select the appropriate connector along with the correct tooling.

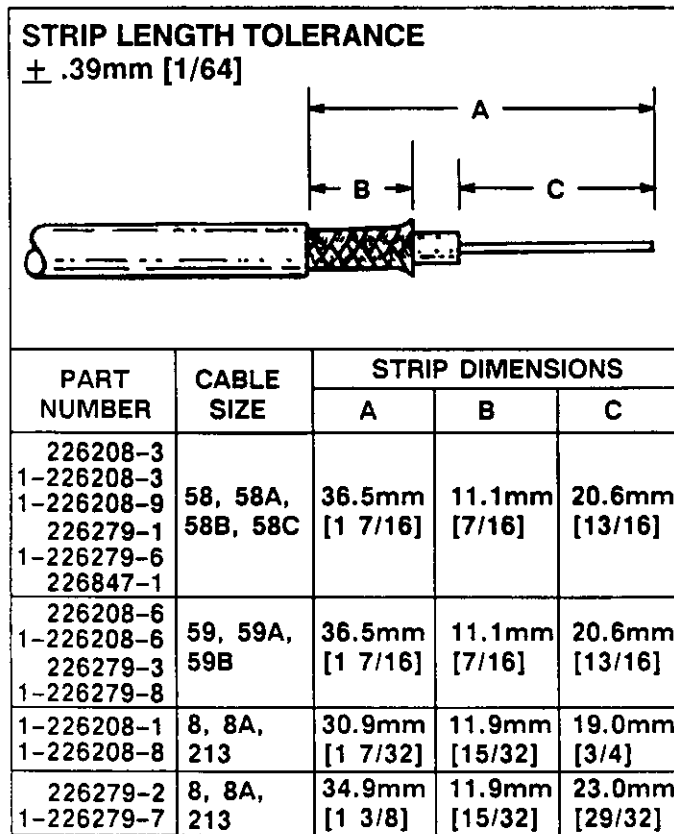


Fig. 2

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**NOTE**

*Crimping procedures are covered in separate publications shipped with the respective tooling.*

1. Slip the ferrule over the cable, followed by the collar. See Figure 3, Step A.
2. Strip the cable to the dimensions shown in Figure 2.
3. Flare the braid and insert the stripped cable into the plug body until the cable dielectric butts against the dielectric inside the body. The braid fits over the support sleeve. See Fig. 3, Step B.

**NOTE**

*The end of the center conductor will extend from the end of the contact for inspection purposes on some cable assemblies. After the crimp is finished, the center conductor should be trimmed flush with the end of the contact.*

4. When using hand tools, the center contact is crimped and the ferrule is assembled over the braid. See Fig. 3, Step C.
5. When using the bench machine, assemble the parts as shown in Steps C and D.
6. Complete the crimp as required by the tooling instruction sheet.

**TYPICAL PLUG ASSEMBLY PROCEDURE**

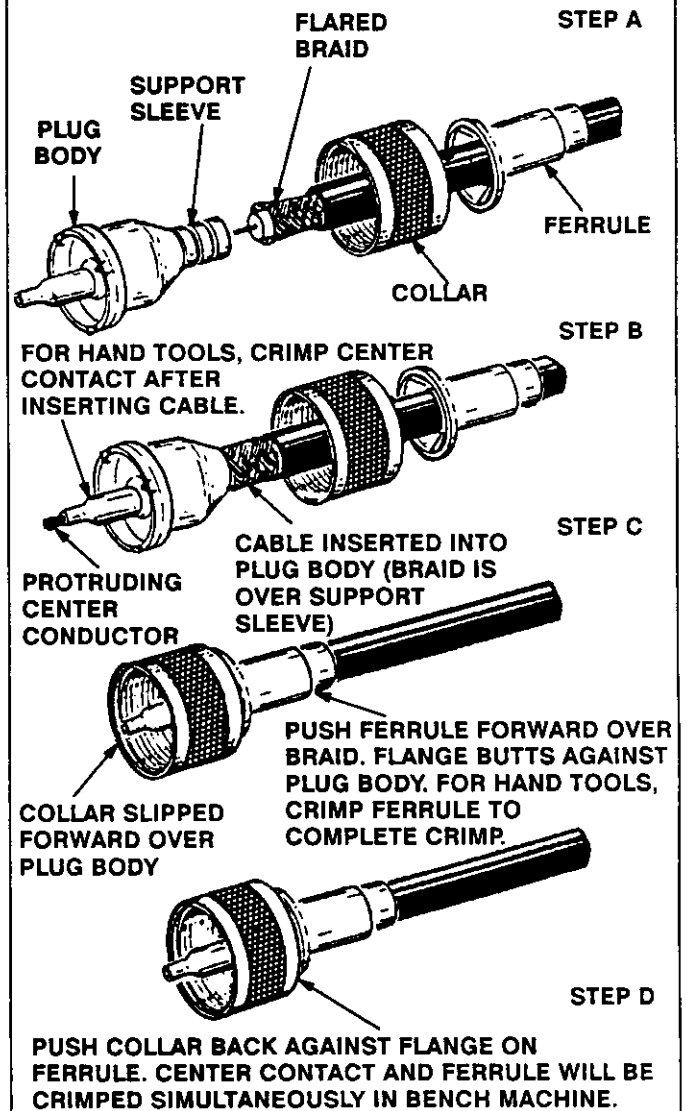


Fig. 3

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