

SMB Straight Cable Plug Crimp Attachment 1044981–1, 1086675–1, and 1060368–1

Instruction Sheet 408–4727 (was A.P. 51–036) 08 FEB 00 Rev O EC 0990–0122–00

TOOLS REQ'D CONNECTOR CABLE TYPE TYPE CENTER CONTACT HOLDER: 2098-5237-10(T-4579) CRIMP TOOL: 2598-5005-54(DIE NO.*C*) RG174/U RG188/U RG316/U SMB STRAIGHT CABLE PLUG -CRIMP ATTACHMENT TORQUE WRENCH 2598-5243-54 CONTACT HOUSING SUBASSY INNER SLEEVE FERRULE ∠_{DIELECTRIC} CLAMP NUT ∠ DIELECTRIC ASSEMBLY OPERATIONS -1/16 SLOT (2) 180° APART (OPTIONAL) **--** 39/64 33/64 1.0 PREPARE COAXIAL CABLE END CABLE JACKET 1.1 PLACE FERRULE ON CABLE
1.2 REMOVE END PORTION OF CABLE JACKET
AND TRIM CABLE TO DIMENSIONS SHOWN
1.3 FLARE OUTER CONDUCTOR
1.4 CUT TWO SLITS IN CABLE JACKET
AS SHOWN (OPTIONAL). 15/64 FERRULE OUTER CONDUTOR CABLE DIELECTRIC CABLE INNER CONDUCTOR CRIMP TOOL (DIE NO."C") 2.0 CRIMP CABLE TO INNER SLEEVE 2.1 ASSEMBLE CLAMP NUT ONTO INNER SLEEVE
2.2 INSERT CABLE INTO INNER SLEEVE AND SEAT FIRMLY, DIELECTRIC TO BE FLUSH TO INNER SLEEVE, TRIM IF REQUIRED. 3/32 -FERRULE REQUIRED
2.3 SLIDE FERRULE OVER FLARED PORTION
OF OUTER CONDUCTOR
2.4 HOLD CABLE FIRMLY AND CRIMP FERRULE
IN PLACE
2.5 TIN INNER CONDUCTOR
2.6 TRIM INNER CONDUCTOR AS SHOWN. CLAMP NUT INNER SLEEVE -CABLE INNER CONDUCTOR 3.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR CENTER CONTACT HOLDER (T-4579) 3.1 ASSEMBLE REAR DIELECTRIC ONTO INNER 3.1 ASSEMBLE REAR DIELECTRIC ONTO INN CONDUCTOR 3.2 PLACE CENTER CONTACT INTO HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE WITH LARGE DIAMETER OF OF REAR DIELECTRIC RESTING FIRMLY AGAINST THE INNER SLEEVE 3.3 REMOVE EXCESS SOLDER AND FLUX INNER SLEEVE REAR DIFLECTRIC CENTER CONTACT 4.0 SECURE HOUSING SUB-ASSEMBLY TO INNER SLEEVE ASSEMBLY HOUSING SUB-ASSEMBLY 4.1 INSERT DIELECTRIC INTO HOUSING SUB-ASSY
4.2 CARFULLY INSERT CENTER CONTACT INTO
DIELECTRIC OF THE HOUSING
SUB-ASSEMBLY
4.3 ENGAGE THREADS OF INNER SLEEVE TO
SUB-ASSEMBLY AND TORQUE TO 7-10 IN. LBS. -INNER SLEEVE SUB-ASEMBLY REF PLANE 007 MIN CONTACT 5.0 INSPECT COMPLETED ASSEMBLY 5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN .007 MIN -DIELECTRIC