

CONNECTOR		CABLE
TYCO ELECTRONICS PART NUMBER	DESCRIPTION	
1330723-1 and 1330723-3	MCX Right-Angle Cable Plug	RG-316, RG 188, and RG-174
1363301-1 and 1363301-2	MCX Right-Angle Cable Plug	RD-316
1329293-1 and 1329293-2	MCX Right-Angle Cable Plug	RG-178 and RG-196

Figure 1

## 1. INTRODUCTION

These instructions cover the application of the MCX Right-Angle Cable Plugs listed in the table in Figure 1. This connector is used in crimp/solder-type attachment applications, on the cable listed in Figure 1.

**NOTE** *Dimensions in these instructions are in metric units [with U.S. customary units in brackets], unless otherwise indicated. Drawings are not to scale.*

The table in Figure 2 references the crimp tooling used to apply these connectors. The table includes Tyco Electronics part numbers and descriptions.

PART NUMBER	DESCRIPTION	CRIMP CONFIGURATION (Ferrule/Hex)
354940-1	PRO-CRIMPER II Hand Tool Frame	--
1583696-1	Crimp Die (RG-316)	3.25 [.128]
	Crimp Die (RD-316)	3.86 [.151]
	Crimp Die (RG-178)	2.67 [.105]

Figure 2

Reasons for revision are listed in Section 3, REVISION SUMMARY.

## 2. ASSEMBLY

### 2.1. Coaxial Cable Preparation (Figure 3)

- Slide the ferrule over the cable.
- Strip the end portion of the cable jacket to expose the cable braid to the dimensions in Figure 3.
- Trim the cable braid to length.
- Trim the cable dielectric to length.
- Trim the inner conductor to length.
- Flare the cable braid as shown in Figure 3.

### 2.2. Soldering the Center Contact to the Cable Inner Conductor (Figure 4)

**DANGER** *Soldering equipment is hot. To avoid personal injury, be sure to follow all local and safety practices (including wearing gloves).*

- Position and secure housing in a small bench or vise.
- Tin the inner conductor of the cable.
- Insert the cable into the housing subassembly.
  - Nest the cable inner conductor in the center contact slot.
  - Bottom the cable dielectric on the connector dielectric.
- Place a solder iron on the tip of the center contact and solder.

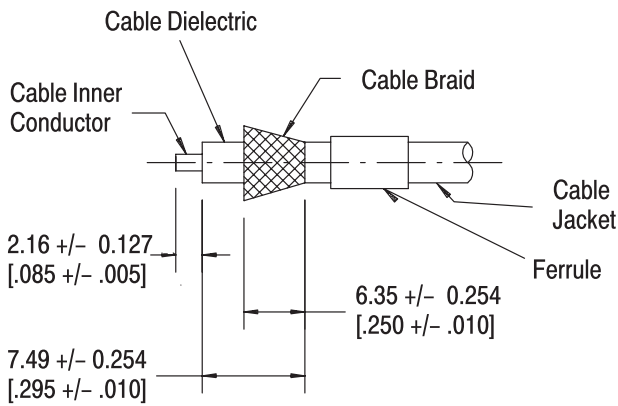


Figure 3

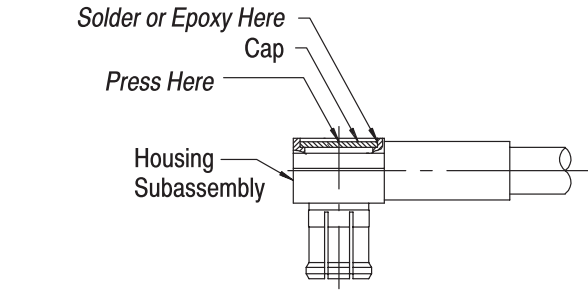


Figure 5

**2.3. Crimping the Connector to Cable** (Figure 4)

1. Slide the ferrule over the flared cable braid.
2. Crimp using the tooling listed in Figure 2.
3. Trim and remove excess cable braid strands.

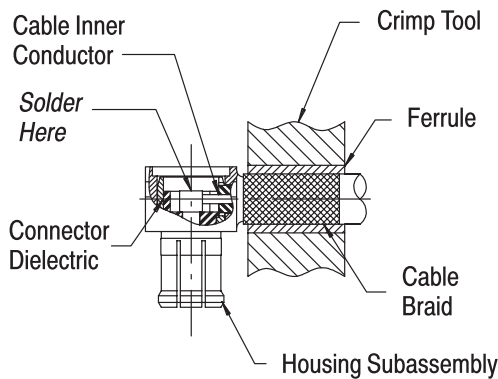


Figure 4

**2.4. Sealing the Housing Opening** (Figure 5)

Place the cap into the opening in the rear of the housing subassembly. Either press, solder, or epoxy the cap into place.



*Damaged components must not be used. They must be replaced with new components.*

**3. REVISION SUMMARY**

Since the previous release:

- Updated format to current corporate requirements
- Changed title