

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for SMA Right-Angle Plug Connector 1408524-1. This crimp attachment type plug is used on LMR-240 type cable.

Tooling required includes Crimp Tool 1055236-1 (Die E)

2. DESCRIPTION

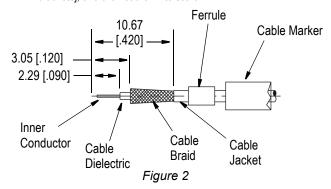
The plug kit consists of the components shown in Figure 1.

3. ASSEMBLY PROCEDURE

3.1. Cable Preparation

- 1. Place the cable marker and the ferrule onto the cable.
- 2. Strip and trim the cable to the dimensions shown in Figure 2.

Note: Dimensions are in millimeters [with inch equivalent in brackets], and are not drawn to scale.



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TOOLING ASSISTANCE CENTER 1-800-722-1111 PRODUCT INFORMATION 1-800-522-6752

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LOC B

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SMA Right-Angle Cable Plug Connector 1408524-1

Instruction Sheet

408-8927

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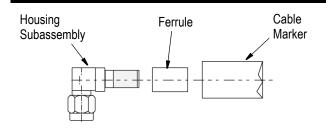


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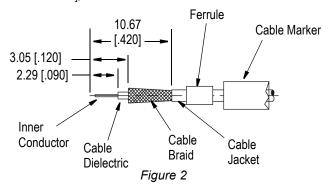
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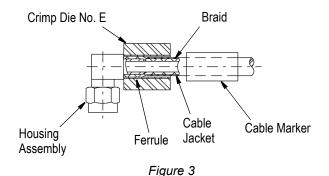


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3.2. Crimping Cable Subassembly to Housing Subassembly

- 1. Insert the cable inner conductor into the preassembled center contact of the housing subassembly.
- 2. Slide the ferrule over the flared portion of the cable braid.
- 3. Crimp ferrule in place (see Figure 3).
- 4. Trim and remove excess braid strands.



Ferrule
Housing Subassembly

Figure 4

3.3. Shrinking Cable Marker to Cable

- 1. Position the cable marker over the ferrule, as shown in Figure 4.
- 2. Apply indirect heat with a thermo gun.
- 3. Assembly is now complete.

4. REVISION SUMMARY

- Added dual dimensioning.
- Updated format to corporate requirements.

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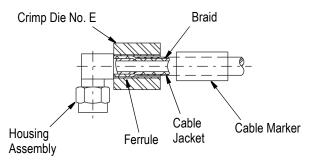


Figure 3

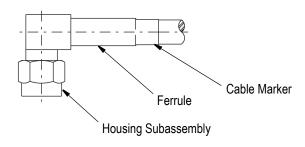


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