

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.

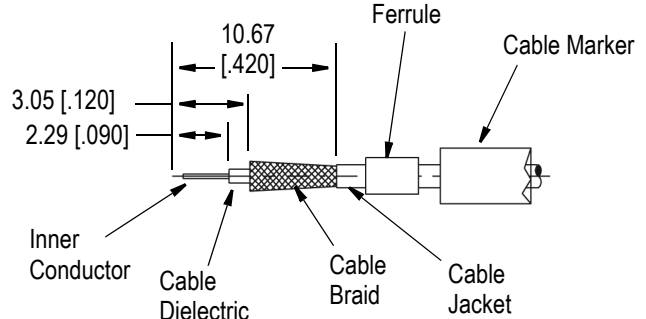


Figure 2

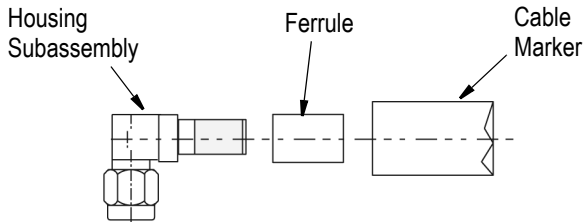


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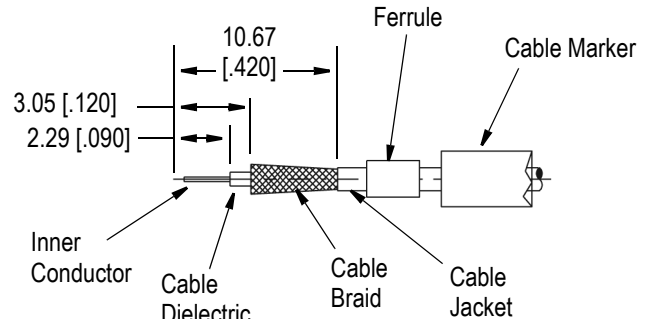


Figure 2

3.2. Crimping Cable Subassembly to Housing Subassembly

1. Insert the cable inner conductor into the pre-assembled 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.

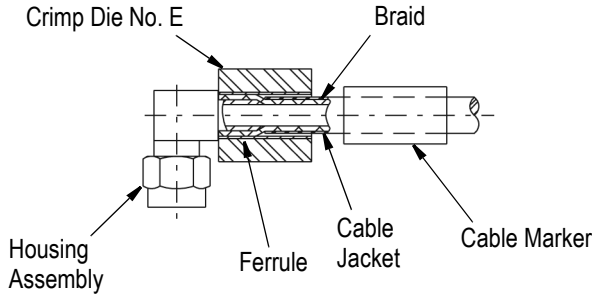


Figure 3

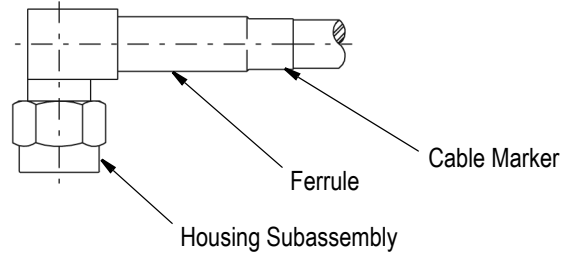


Figure 4

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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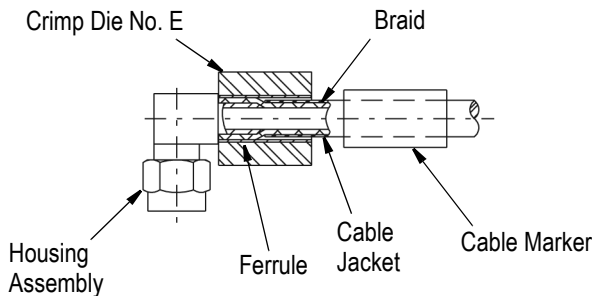


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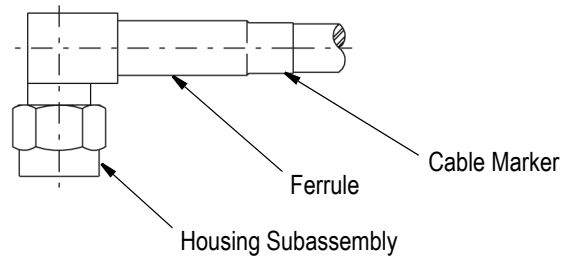


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