

CONNECTOR NUMBER	CRIMP DIE	HEX SIZE (Inch)	CABLE TYPE
1408333-1, -2	1060714-1, No. C	.128	RG-174/U, RG-188/U, RG-316/U
1408333-3, -4	1055270-1	.151	RD-316/U Double Braid
1408333-5, -6	1000714-1, No. B	.213	RG-142/U, RG-55/U, RG-223/U, RG-400/U
1408333-7, -8			RG-58/U, RG-141/U, RG-303/U

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for QMA Straight Cable Connector Crimp Attachments 1408333-1 through 1408333-8, which are applied onto various cable types. Refer to the table in Figure 1 for connector, crimp die, and cable type combinations.

The table in Figure 2 represents tool numbers applicable to this instruction sheet.



*Unless otherwise stated, dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.*

## 2. DESCRIPTION

The connector crimp attachments consist of a housing subassembly, a center contact, and a ferrule.

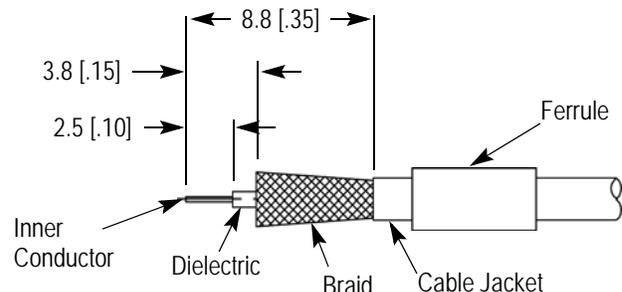
## 3. ASSEMBLY PROCEDURES

### 3.1. Prepare Coaxial Cable End (Figure 3)

1. Place ferrule on cable.
2. Remove end portion of cable jacket to expose braid.
3. Trim braid to length.
4. Trim dielectric to length.
5. Flare braid.

TOOL DESCRIPTION	TE CONNECTIVITY PART NUMBER
Center Contact Holder	1055454-1
Crimp Tool	1060713-1
Ferrule Crimp Die (.213 and .128 Hex)	1060714-1
Ferrule Crimp Die (.151 Hex)	1055270-1
Locator Tool	1673603-1
OPTIONAL TOOLING	
Crimp Tool	1055780-1
Ferrule Crimp Die (.213 and .128 Hex)	1055781-1
Ferrule Crimp Die (.151 Hex)	1055880-1

Figure 2



NOTE: Not to Scale

Figure 3

### 3.2. Solder Center Contact to Inner Conductor (Figure 4)

1. Tin inner conductor of cable.
2. Place contact in center contact holder.
3. Heat contact and push it over the inner conductor to rest firmly against the dielectric as shown in Figure 4.
4. Remove excess solder.

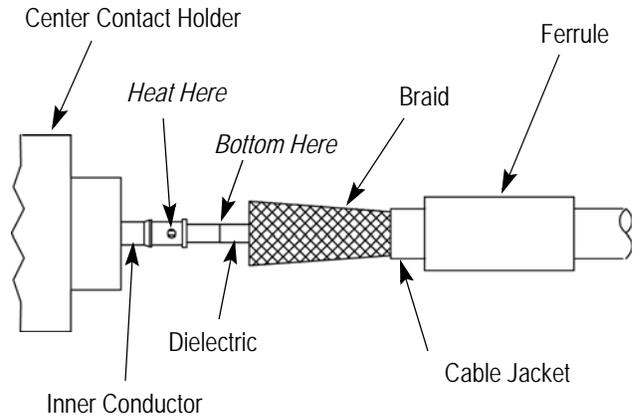


Figure 4

### 3.3. Crimp Cable to Ferrule (Figure 5)

1. Insert locator tool into housing subassembly.
2. Insert cable subassembly into housing subassembly and seat firmly.
3. Slide ferrule over flared portion of braid.
4. Hold cable firmly seated and crimp ferrule in place. Refer to the table in Figure 1 for connector, crimp die, and cable type combinations.
5. Remove locator tool.
6. Trim and remove excess braid.

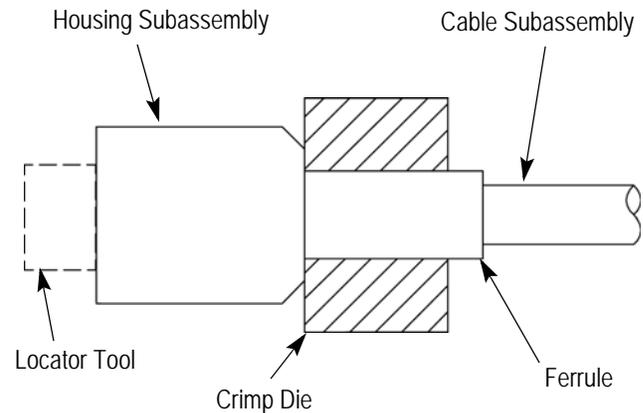


Figure 5

### 3.4. Inspection of Completed Assembly

Following the assembly procedures in this instruction sheet should yield tolerance shown in Figure 6.



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

## 4. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.

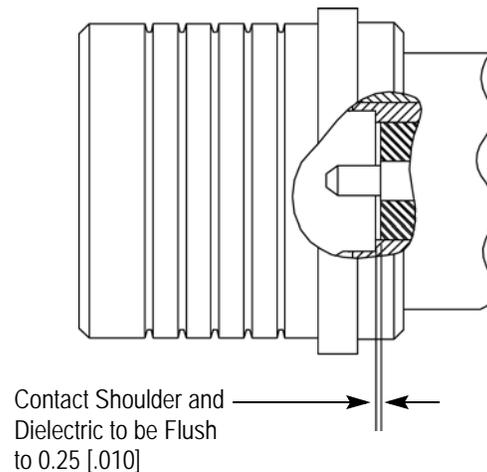


Figure 6