

TYCO ELECTRONICS PART NUMBERS	DESCRIPTION	CABLE
1060871-1 and 1060872-1	MCX Straight Cable Plug, Crimp Attachment	RG316, RG188, AND RG174
1060875-1 and 1060875-2	MCX Straight Cable Plug, Crimp Attachment	RD316
1060869-1 and 1060868-1	MCX Straight Cable Plug, Crimp Attachment	RG-178 AND RG-196

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedure for the MCX Straight Cable Plugs listed in Figure 1. These connectors are crimp attachment type connectors that attach to the flexible cable listed in Figure 1.

The table in Figure 2 references the crimp tooling used to apply these connectors. The table includes tool descriptions, the Tyco Electronics part number, and the corresponding (previous) part number.

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	Tyco Electronics Part Number	Crimp Configuration Contact(Sq)/Ferrule(Hex)
PRO-CRIMPER* II Hand Tool Frame	354940-1	--
Crimp Die (RG316,)	1583696-1	0.70 [.028]/ 3.25 [128]
Crimp Die (RD316)		0.70 [.028]/ 3.86 [.151]
Crimp Die (RG-178)		0.70 [.028]/ 2.67 [.105]

Figure 2



Dimension on this sheet are in millimeters [with inches in brackets], unless otherwise specified.

2. DESCRIPTION

Each MCX Straight Cable Plug Connector consists of a housing assembly, a center contact, and a crimp ferrule. See Figure 1.

3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

1. Slide the crimp ferrule onto the cable.



To avoid personal injury, be sure to use appropriate safety equipment, including gloves, when using cable stripping tools.

2. Strip the cable according to the dimensions in Figure 3.



Do NOT damage the cable braid, dielectric, or inner conductor of the cable.

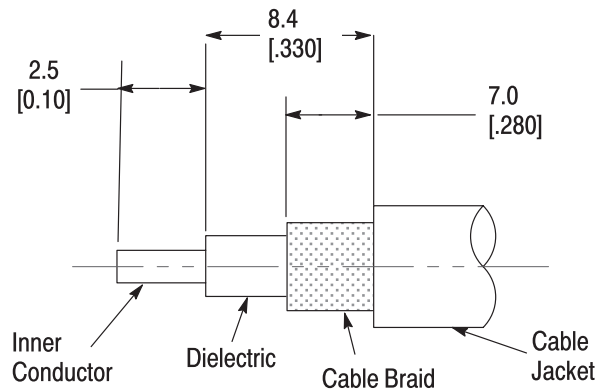


Figure 3

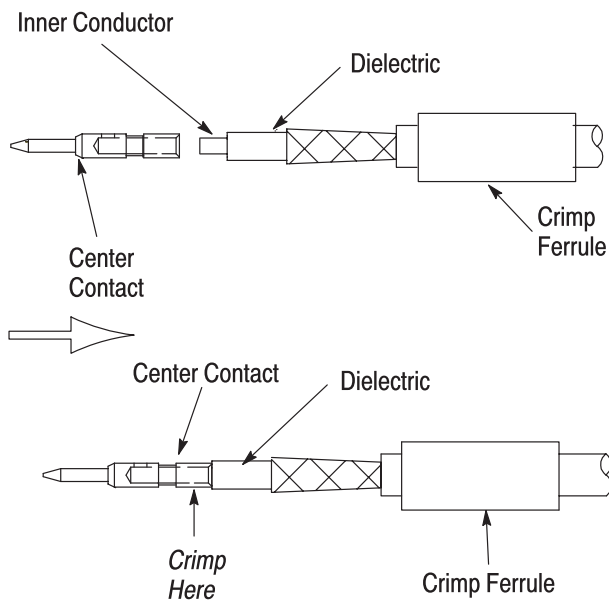


Figure 4

3. Push the center contact over the center conductor and crimp using the tooling listed in Figure 2. See Figure 4.

4. Flare the cable braid. Then push the housing assembly over the center contact (under the cable braid) until the center contact snaps into place.

5. Slide the crimp ferrule over the flared cable braid and the housing assembly.

6. Crimp using the tooling listed in Figure 2. Refer to Figure 5.

7. The completed crimp should appear as shown in Figure 6.

4. REVISION SUMMARY

- Changed Step 4 in the assembly procedure
- Updated format to the current corporate requirements

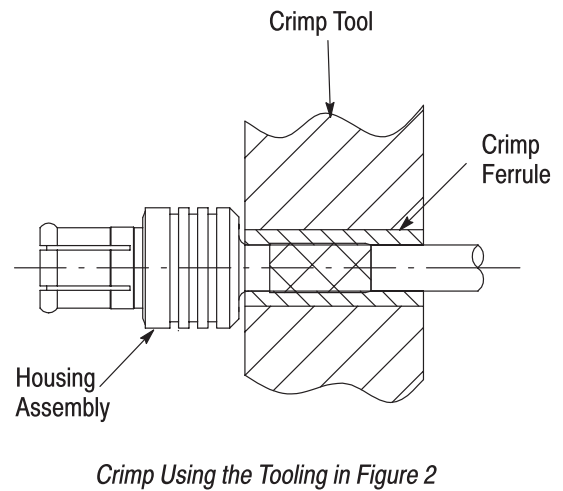


Figure 5

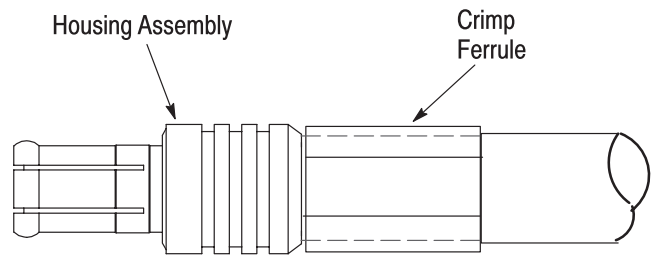


Figure 6