

Part Number	Description	Cable
1408541-1	SMA Snap-Lock Push-On Straight Cable Plug Connector	RG316 or Equivalent
1274694-1	SMA Snap-Lock Push-On Right-Angle Cable Plug Connector	RG316 or Equivalent

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Snap-Lock Push-On cable connectors shown in Figure 1. These connectors are crimp attachment type connectors that attach to the cable listed in Figure 1.

The table in Figure 2 references the termination requirements to apply these connectors.

Part Number	Center Contact Termination	Ferrule Termination
1408541-1	Solder	.118 Hex Crimp
1274694-1	Solder	.118 Hex Crimp

Figure 2

2. DESCRIPTION

Each SMA Snap-Lock, Push-On cable connector (straight cable plug and right-angle plug) consists of a

plug assembly and crimp ferrule. The straight cable plug connector also contains a center contact. Refer to Figure 1.

NOTE



Dimension on this sheet are in inches [with millimeters in brackets], unless otherwise specified. Figures are not drawn to scale.

3. ASSEMBLY PROCEDURE

3.1. Assembly of Snap-Lock Straight Connectors

- Slide the crimp ferrule onto the cable.

DANGER



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

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

Stripping Dimensions for Straight Cable Plug

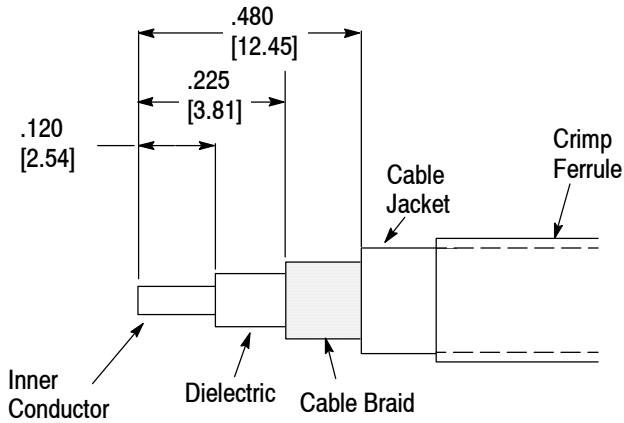


Figure 3

3. Push the center contact over the center conductor and solder in place. See Figure 4.

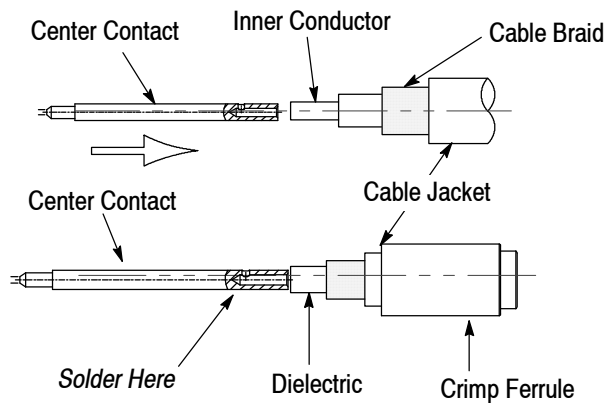


Figure 4

4. Flare the cable braid. See Figure 5. Then push the subassembly over the center contact, under the cable braid until the cable bottoms in the subassembly.

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 6.

3.2. Assembly of Snap-Lock Right-Angle Connectors

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.

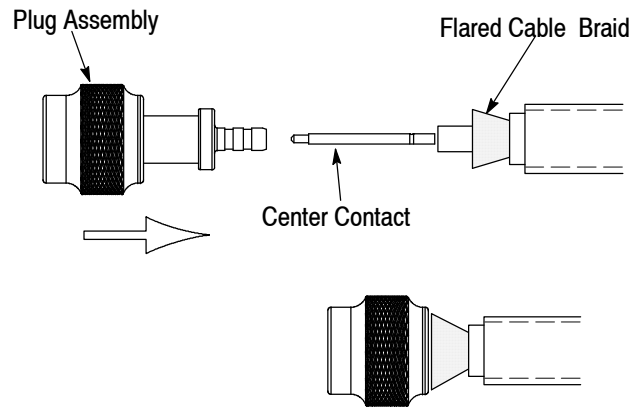
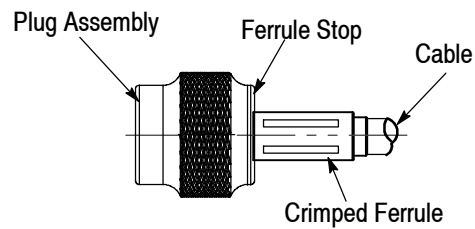


Figure 5



Crimp Using the Tooling in Figure 2

Figure 6

2. Strip the cable according to the dimensions in Figure 7.

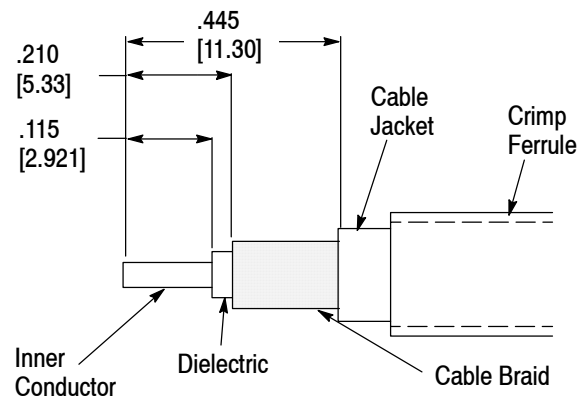


Figure 7



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

3. Flare the cable braid and push the subassembly over the inner conductor (under the cable braid). See Figure 8.

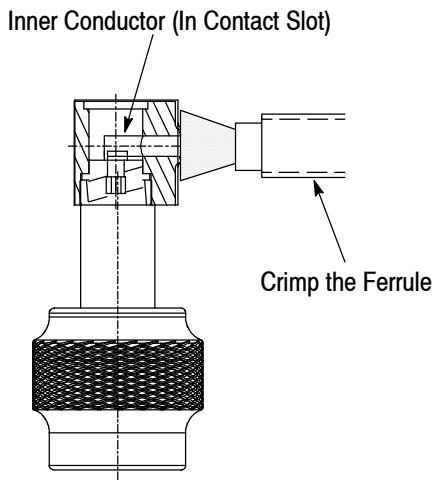
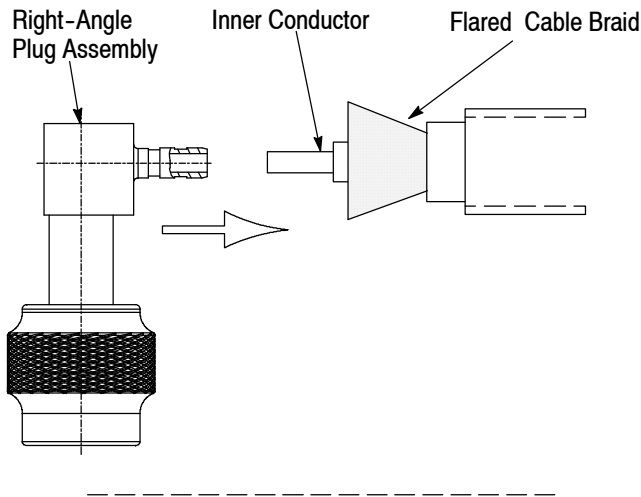
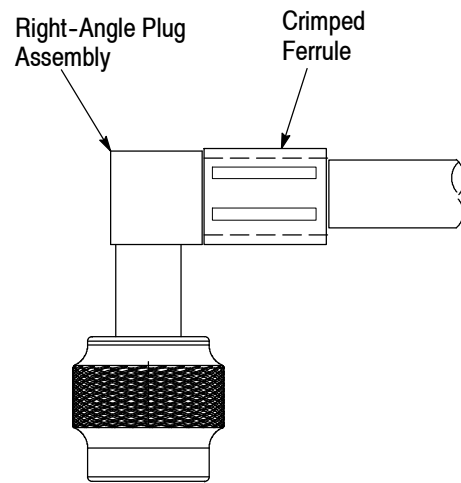


Figure 8



Crimp Using the Tooling in Figure 2

Figure 9

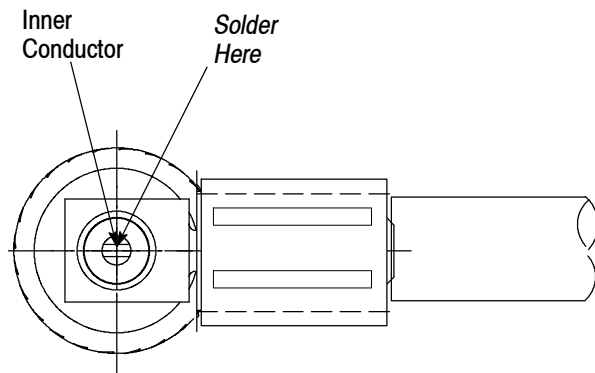


Figure 10

4. Crimp using the tooling listed in Figure 2. See Figure 9.



To avoid personal injury, be sure to exercise caution when handling hot soldering equipment.

5. Solder the cable inner conductor to the center contact in the housing assembly. See Figure 10.

6. Place cap in the right-angle plug assembly (if included) andpeen or dimple the cap firmly in place.

4. REVISION SUMMARY

- Updated document to corporate requirements.