

Figure 1

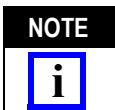
### 1. INTRODUCTION

This instruction sheet covers the assembly of Coaxial 75-Ohm (414075-[ ]) SMB Bulkhead Jack Connectors. See Figure 1. The connectors are crimped onto various sizes of RG/U flexible coaxial cable using TE hand tools and die assemblies that are Qualified to Military Specification M22520/5-01H. See Figure 2.

RG/U CABLE	PRO-CRIMPER III* TOOL FRAME ASSEMBLY 354940-1		DANIELS' TOOL HX4-1637	
	TE DIE ASSY	POS LETTER	DANIELS HEX DIE SET	SLCTR NO.
179, 187	58483-1	B	Y-1637	B
180, 195		C		C

Figure 2

For detailed crimping procedures, refer to the instructions packaged with the hand tool. Catalog 1307191 provides product application requirements, cable selection, and product part number information. For part numbers not listed in the catalog, contact your Tyco Electronics representative for recommendations.



*Dimensions are in metric units [followed by U.S. customary units in brackets].*

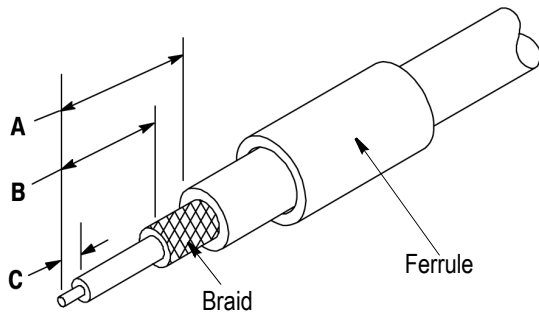
Reasons for reissue are provided in Section 5, REVISION SUMMARY.

### 2. DESCRIPTION (Figure 1)

The bulkhead jack connectors are supplied as kits consisting of a bulkhead jack body, a center contact, an insulator, a back nut, and a ferrule. Also supplied is a lockwasher and jam nut for panel mounting.

### 3. ASSEMBLY PROCEDURE

- Slide ferrule onto cable. Strip cable according to the appropriate dimensions provided in Figure 3; then flare the braid. Be careful not to nick or cut the center conductor or cable braid.
- Insert cable assembly through tail-end of bulkhead jack body until the cable braid is positioned against the shoulder of the back nut. See Figure 4, Detail A.
- Slide ferrule forward over cable braid until it is positioned against the shoulder of the back nut, as shown in Figure 4, Detail B.
- Crimp ferrule using the appropriate hand tool. See Figure 4, Detail C for a properly crimped ferrule.

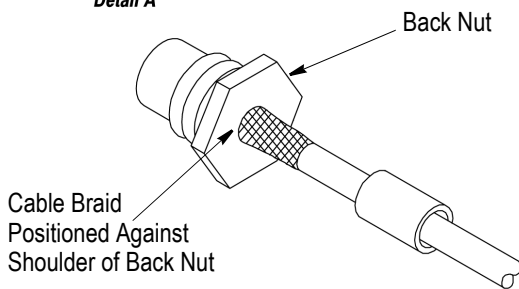


**NOTE:** Not To Scale

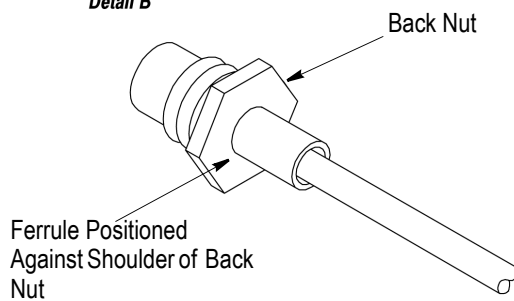
CONNECTOR TYPE	DIMENSIONS (mm [In.])		
	A	B	C
75-Ohm	18.42 [.725]	12.07 [.475]	2.54 [1.00]

Figure 3

**Detail A**



**Detail B**



**Detail C**

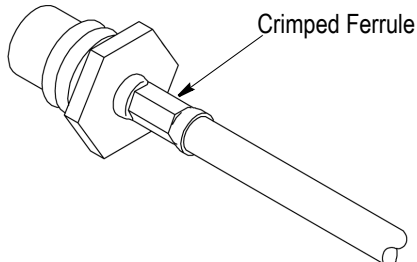


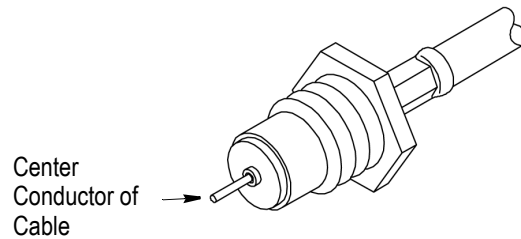
Figure 4

5. Position insulator over cable dielectric and center conductor, as shown in Figure 5, Detail A.

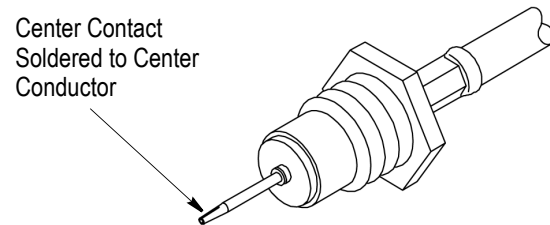
6. Solder center conductor of cable to contact using standard soldering techniques. See Figure 5, Detail B.

7. Insert cable assembly into bulkhead jack body and tighten back nut. Recommended tightening torque of back nut is .987-1.059 N•m [140-150 in.-oz]. See Figure 5, Detail C.

**Detail A**



**Detail B**



**Detail C**

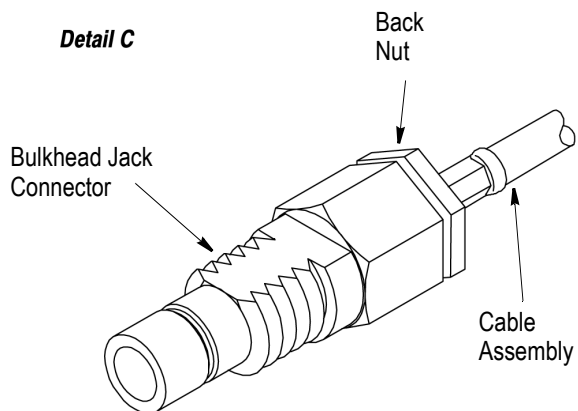


Figure 5

#### 4. PANEL MOUNTING

1. Make a cutout in the panel using the appropriate dimensions provided in Figure 6.

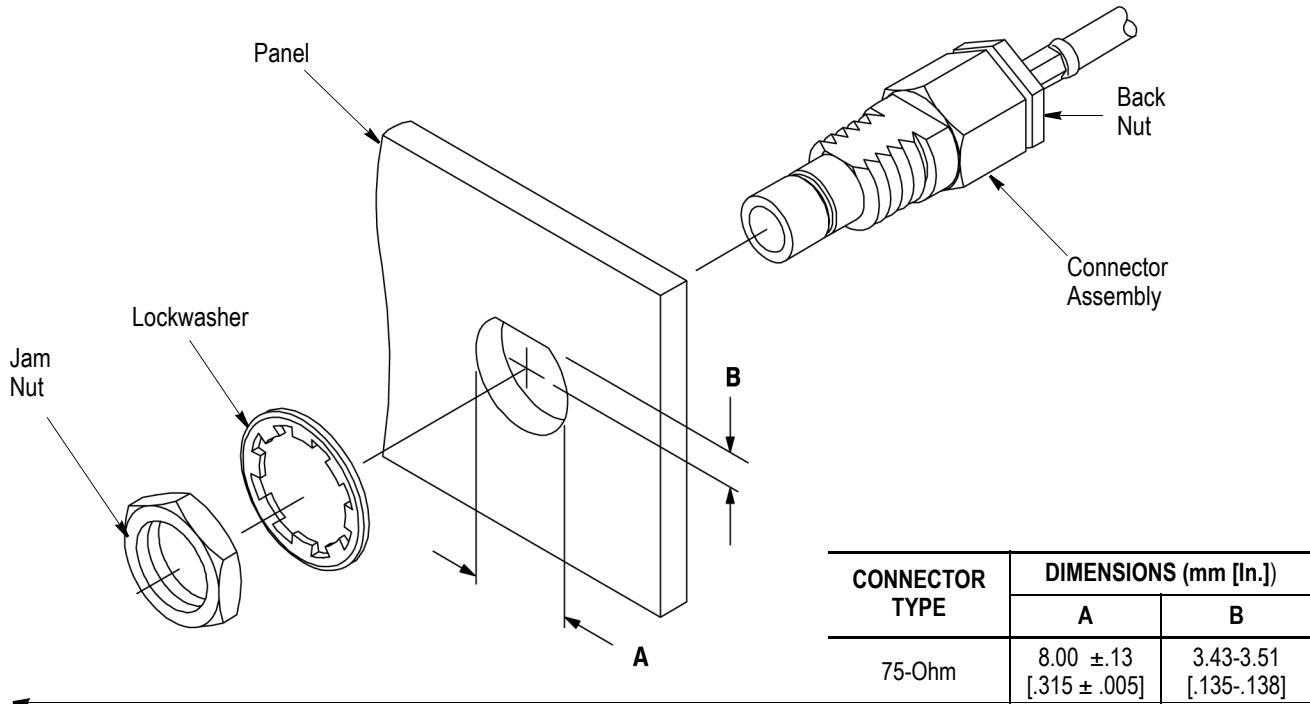
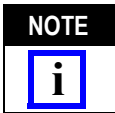


Figure 6

2. Insert connector assembly into panel cutout, as shown in Figure 6. Install lockwasher and jam nut to secure connector to panel. Recommended tightening torque of jam nut is 0.45-0.68 N•m [4-6 in.-lb].

**5. REVISION SUMMARY**

Since the previous release of this document, the TE Connectivity logo has been applied.



*For panels with thicknesses less than 20 gauge (0.91 mm [.036 in.]) thick, hold back nut on connector assembly when installing lockwasher and jam nut to avoid damage to the connector assembly and/or panel mount.*