

DESCRIPTION	TYCO ELECTRONICS PART NUMBER	CABLE
MCX Bulkhead Feedthrough Cable Jack	1060882-1 1060883-1	RG316, RG188, RG174
	1060881-1 1060881-2	RD316
	1060884-1 1060884-2	RG178 and RG 196

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedure for the MCX Bulkhead Feedthrough Cable Jack Connectors listed in Figure 1. These connectors are crimp attachment type connectors that attach to the flexible cable also listed in Figure 1.

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

TOOL DESCRIPTION	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

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



2. DESCRIPTION

Each MCX Bulkhead Feedthrough Cable Jack consists of a retaining ring, a housing assembly, a center contact, a lockwasher and locknut, and a crimp ferrule. See Figure 1.

3. ASSEMBLY PROCEDURE

DANGER



Follow safety precautions included with the tools used for assembly.

- Slide the crimp ferrule onto the cable and install the retaining ring, lockwasher, and locknut onto the housing assembly.

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.

CAUTION



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

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

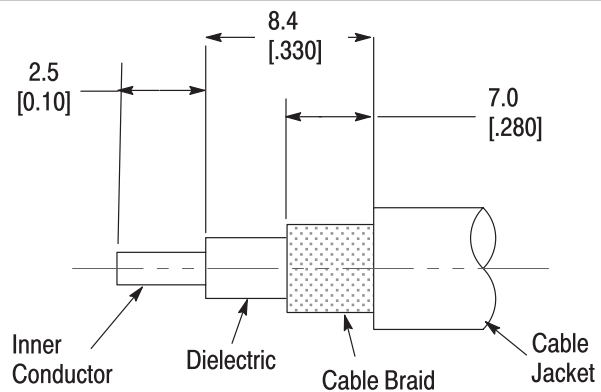


Figure 3

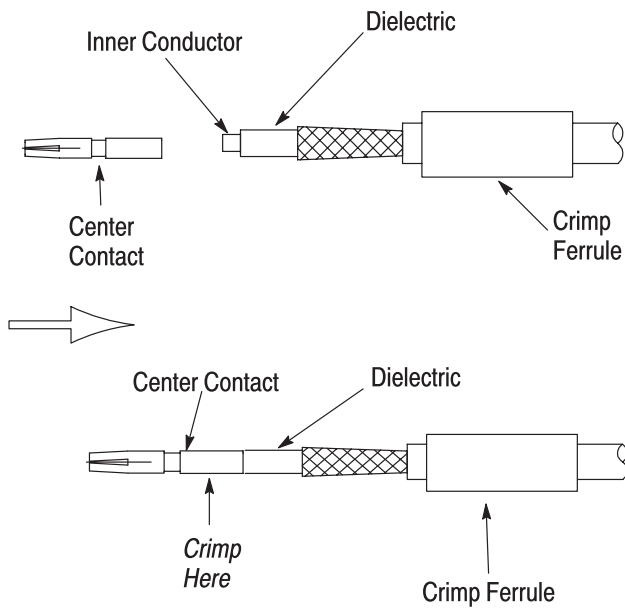


Figure 4

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.

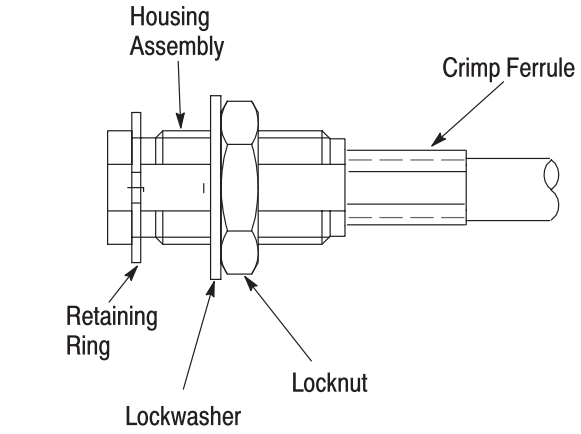
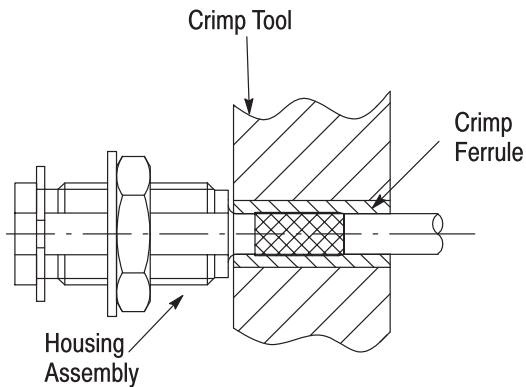


Figure 6



Crimp Using the Tooling in Figure 2

Figure 5

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

4. REVISION SUMMARY

Since the previous release, the following revisions were made:

- Center contact is now crimped
- The format was updated to the current corporate requirements