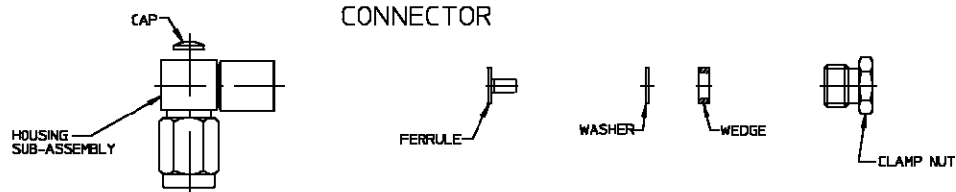


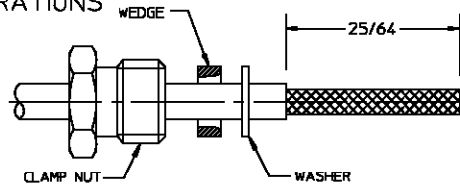
CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
SMC RIGHT ANGLE CABLE PLUG CLAMP ATTACHMENT	RG-178/U RG-188/U RG-196/U RG-316/U	TORQUE WRENCH: 2598-5243-54



ASSEMBLY OPERATIONS

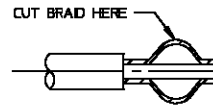
Step 1

- (a) Cut cable jacket to dimension shown, being careful not to nick braid.
- (b) Place nut (hex first), wedge (small opening first) and washer over cable.



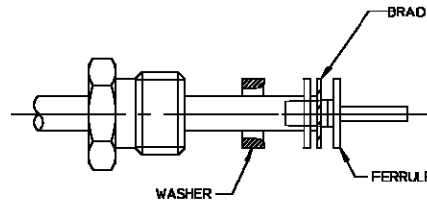
Step 2

- (a) Push back braid to expand and facilitate cutting. Cut braid with small pointed scissors at point of widest expansion.



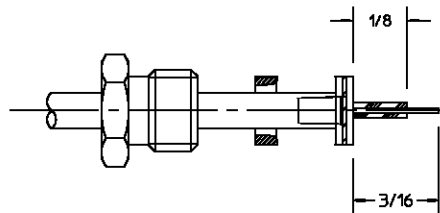
Step 3

- (a) Flare out remaining braid.
- (b) Then insert ferrule between the braid and cable dielectric until braid is wedged firmly between flange of ferrule and jacket.



Step 4

- (a) Trim braid to diameter of flange .
- (b) Trim cable dielectric to dimension shown.
- (c) Tin center conductor.
- (d) Trim center conductor to dimension shown.



Step 5

- (a) Thread clamp nut into housing sub-assembly with center conductor feeding through right angle contact and torque to 7-10 inch lbs.
- (b) Solder center conductor to contact.
- (c) Press dome cap into place using a .130 flat bottom punch.

