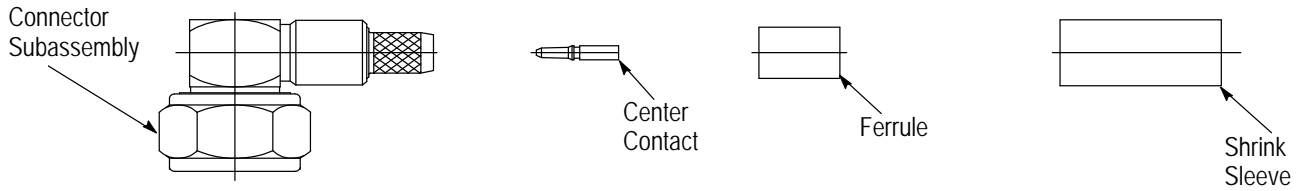


Type N Right-Angle Cable Plug

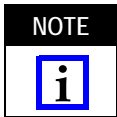


TE CONNECTIVITY PRODUCT PART NUMBER	PREVIOUS PRODUCT PART NUMBER	TE CONNECTIVITY CABLE TYPE NUMBER	CABLE TYPE
1361008-1	3037-5002-10	1314240-1	MA318
1361008-2	---	1314239-1	MA248

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the Type N Right-Angle Cable Plug Connectors shown in Figure 1. These connectors are crimp attachment type connectors that attach to the cable types listed in Figure 1.



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

The table in Figure 2 references the tools required spread the cable braid and apply these connectors to cable. The table includes tool descriptions and the current TE part numbers, as well as the connectors to which they apply.

BRAID SPREADING TOOL	HEX CRIMP TOOL	CONNECTOR PART NUMBER
MA318 Braid Spreading Tool 1314084-1	.384 In.	1361008-1
MA248 Braid Spreading Tool 1251594-1	.324 In.	1361008-2

Figure 2

Reasons for re-issue can be found in Section 3, REVISION SUMMARY.

Read and understand these instructions thoroughly before proceeding.

2. ASSEMBLY PROCEDURES

2.1. Preparing the Cable (Figure 3)

1. Place the shrink tubing and the crimp ferrule on the cable.



To avoid personal injury, be sure to wear gloves and adhere to all local safety practices when handling a cutting blade or knife.

2. Strip and trim the cable end to the dimensions shown in Figure 3.

3. Flare the cable braid layers away from the PTFE core using the appropriate braid spreading tool (refer to Figure 2).



Exercise caution when spreading the cable braid. Do NOT damage the PTFE core while spreading the braid.

2.2. Soldering the Center Contact to the Cable Inner Conductor (Figure 4)



To avoid personal injury and avoid burns, exercise caution when using soldering equipment.

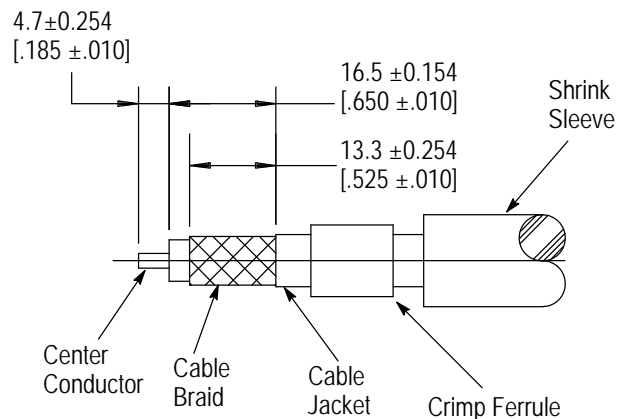


Figure 3

1. Tin the cable center conductor.
2. Place (63/37) solder into the center contact and position the pin on the cable center conductor.
3. Solder the center contact flush with the cable dielectric.

2.3. Crimping the Connector Subassembly to Cable

(Figure 5)

1. Slide the connector subassembly over the cable dielectric and under the flared cable braid.
2. Push the cable firmly into the connector subassembly until the pin contact snaps into the internal receptacle.
3. Slide the crimp ferrule over the back end of the connector and crimp using the appropriate hex die. (Refer to Figure 2 for the appropriate hex die.)
4. Trim off any excess cable braid.

2.4. Applying the Shrink Sleeve

1. Slide the connector subassembly over the cable dielectric and under the flared cable braid.
2. Heat the sleeve evenly using a hot air gun and shrink the sleeve onto the cable.

3. REVISION SUMMARY

- Updated document to corporate requirements
- New logo

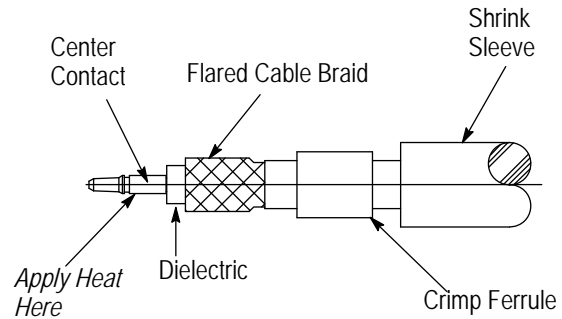


Figure 4

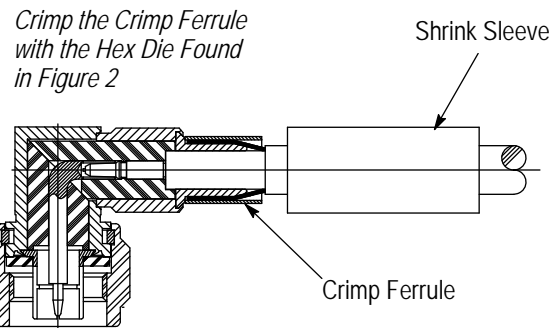


Figure 5

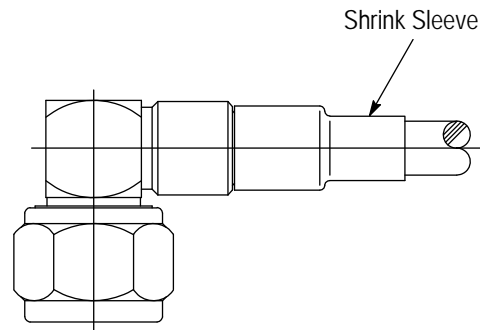


Figure 6