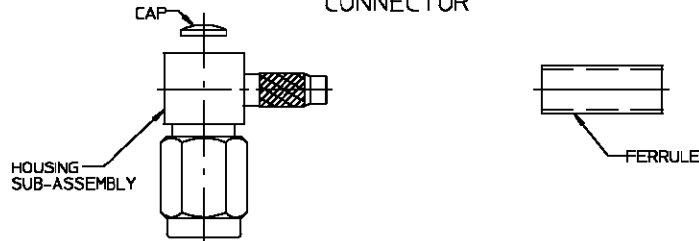


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
SMB RIGHT ANGLE CABLE PLUG CRIMP ATTACHMENT	RG-178/U RG-196/U	LOCATOR TOOL: 5098-5031-02  CRIMP TOOL: 2598-5005-54 DIE NO. A

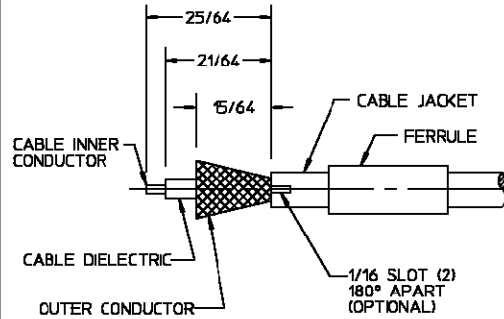
### CONNECTOR



### ASSEMBLY OPERATIONS

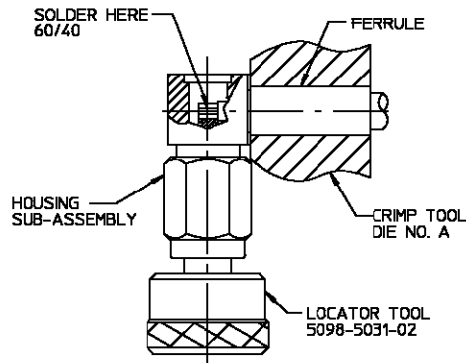
#### 1.0 PREPARE COAXIAL CABLE END

- 1.1 PLACE FERRULE ON CABLE.
- 1.2 REMOVE END PORTION OF CABLE JACKET AND TRIM CABLE TO DIMENSIONS SHOWN.
- 1.3 FLARE OUTER CONDUCTOR.
- 1.4 CUT TWO SLITS IN CABLE JACKET AS SHOWN (OPTIONAL).



#### 2.0 SOLDERING OF CABLE INNER CONDUCTOR TO HOUSING SUB-ASSEMBLY

- 2.1 SECURE LOCATOR TOOL TO HOUSING SUB-ASSEMBLY.
- 2.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 2.3 TIN INNER CONDUCTOR OF CABLE.
- 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND NEST INNER CONDUCTOR IN CONTACT SLOT.
- 2.5 PLACE SOLDERING IRON ON TIP OF CONTACT AND SOLDER.



#### 3.0 CRIMP CABLE TO HOUSING SUB-ASSEMBLY

- 3.1 SLIDE FERRULE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 3.2 CRIMP FERRULE IN PLACE.
- 3.3 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.

#### 4.0 SEAL OPENING IN HOUSING

- 3.1 STAKE METAL CAP INTO PLACE.

