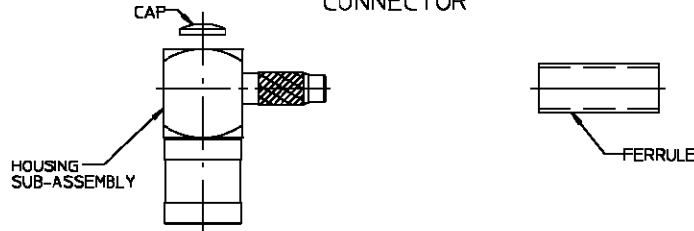


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
SMB RIGHT ANGLE CABLE PLUG CRIMP ATTACHMENT	RG-174/U RG-179/U RG-187/U RG-188/U RG-316/U	LOCATOR TOOL: 5198-5003-02 CRIMP TOOL: 2598-5005-54 DIE NO. C

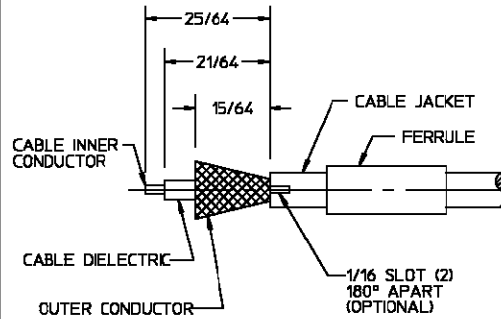
CONNECTOR



ASSEMBLY OPERATIONS

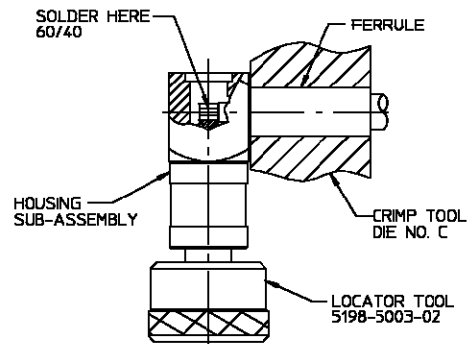
1.0 PREPARE COAXIAL CABLE END

- 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

- 4.1 STAKE METAL CAP INTO PLACE. (OPTIONAL) AFTER STAKING, THE CAP MAY BE EPOXYED OR SOLDERED IN PLACE.

