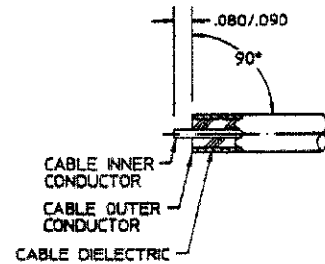
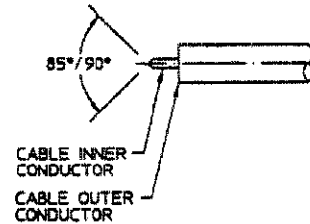


ASSEMBLY OPERATIONS

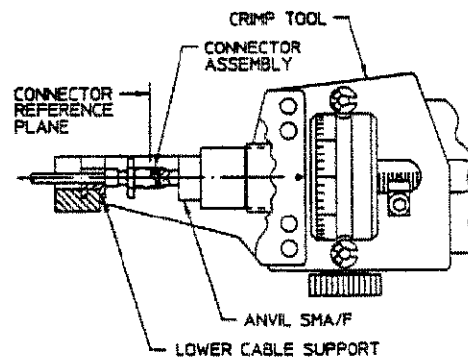
- 1.0 PREPARATION OF CABLE
1.1 TRIM CABLE TO DIMENSION SHOWN.



- 2.0 SHAPE INNER CONDUCTOR OF CABLE
2.1 SHAPE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° CONE.



- 3.0 INSTALL CABLE INTO CONNECTOR ASSEMBLY
3.1 INSTALL LOWER CABLE SUPPORT (FOR .141 CABLE) AND ANVIL (SMA/F) INTO CRIMP TOOL.
3.2 SET CRIMP LENGTH ON CRIMP TOOL TO .569
3.3 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE-ASSEMBLED CENTER CONTACT OF CONNECTOR ASSEMBLY UNTIL CABLE BOTTOMS ON SHOULDER IN CONNECTOR ASSEMBLY.
3.4 PLACE ASSEMBLY INTO CRIMP TOOL, BOTTOMING THE CONNECTOR REFERENCE PLANE AGAINST ANVIL AND ALLOWING THE CABLE TO SETTLE IN THE LOWER CABLE SUPPORT.
3.5 SQUEEZE HANDLES OF CRIMP TOOL UNTIL RATCHET RELEASES.
3.6 ASSEMBLY IS NOW COMPLETE.



CABLE TRIM INFORMATION

NOTE

- 1.) DIMENSION FROM CONNECTOR REFERENCE PLANE TO WHERE CABLE OUTER CONDUCTOR SEATS = .363 ± .010
2.) WHEN ASSEMBLED DIMENSION FROM REFERENCE PLANE TO END OF REAR BUSHING = .574 ± .010