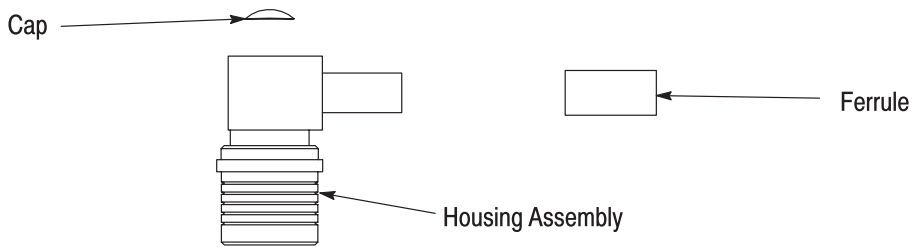



| PLUG NUMBER | CRIMP DIE | HEX SIZE [Inch] | CABLE TYPE |
|---|---|---|---|
| 1408336–1, –2 | 1060714–1, No. C | .128 | RG–174/U, RG–188/U, RG–316/U |
| 1408336–3, –4 | 1055270–1 | .151 | RD–316/U Double Braid |
| 1408336–5, –6 | 1060714–1, No. B | .213 | RG–142/U, RG–55/U, RG–223/U, RG–400/U |
| 1408336–7, –8 | | | RG–58/U, RG–141/U, RG–303/U |
| 1–1408336–0 | 2031875–1 | .384 | MA–318 |

*Figure 1*

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for the QMA Right–Angle Cable Plugs — Crimp Attachment (Figure 1), which are applied onto various cable types. Refer to the table in Figure 1 for plug, crimp die, and cable type combinations.

The table in Figure 2 represents tool numbers applicable to this instruction sheet.

**NOTE**

*Unless otherwise stated, dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale*

The plug crimp attachments consist of a housing assembly, a cap, and a ferrule.

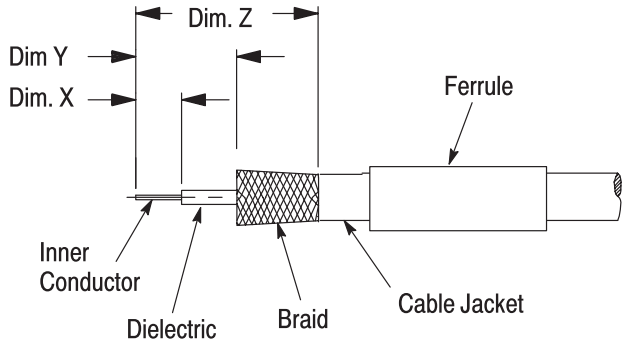
## 2. ASSEMBLY PROCEDURES

### 2.1. Prepare Coaxial Cable End (Figure 3)

1. Place ferrule on cable.
2. Remove end portion of cable jacket to expose braid.
3. Trim braid to length.
4. Trim dielectric to length.

| TOOL DESCRIPTION | TYCO ELECTRONICS PART NUMBER |
|---|---|
| Crimp Tool | 1060713–1 |
| Ferrule Crimp Die (.213 and .128 Hex) | 1060714–1 |
| Ferrule Crimp Die (.151 Hex) | 1055270–1 |
| Ferrule Crimp Die (.384 Hex) | 2031875–1 |
| ***OPTIONAL TOOLING*** | |
| Crimp Tool | 1055780–1 |
| Ferrule Crimp Die (.213 and .128 Hex) | 1055781–1 |
| Ferrule Crimp Die (.151 Hex) | 1055880–1 |

*Figure 2*




**NOTE:** *Not to Scale*

| PART NO. | DIM. X MM [IN.} | DIM. Y MM [IN.} | DIM.Z MM [IN.} |
|---|---|---|---|
| 1408336–1 through 1408336–8 | 2.8 [0.11] | 6.2 [.24] | 11.2 [.44] |
| 1–1408336–0 | 3.8 [0.15] | 7.6 [0.30] | 19.8 [.78] |

*Figure 3*

5. Trim inner conductor to length.

6. Flare braid.

### 2.2. Solder Inner Conductor Housing Assembly
(Figure 4)

1. Position and secure housing assembly in a small bench vise.

2. Tin inner conductor of cable.

3. Insert cable into housing assembly.

   a. Nest inner conductor in contact slot.

   b. Hold dielectric and inner conductor flush as shown in Figure 4.

4. Place soldering iron on tip of contact and solder.

### 2.3. Crimp Cable Subassembly to Housing Assembly (Figure 5)

1. Slide ferrule over flared portion of braid.

2. Crimp ferrule in place. Refer to the table in Figure 1 for plug, crimp die, and cable type combinations.

3. Trim and remove excess braid.

### 2.4. Seal Opening in Housing

1. Press cap into opening in rear housing assembly.

2. Cap may be epoxied into place.

**CAUTION**

*Do not allow epoxy to penetrate inside housing.*

**CAUTION**

*Damaged components should not be used. They should be replaced with new components.*

## 3. REVISION SUMMARY

Since the previous release of 408–8638:

- 1–1408336–0 and associated tooling was added to the document,
- The document was updated to the current corporate requirements.

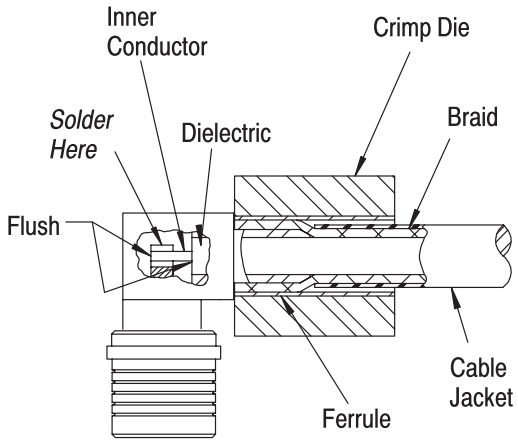



*Figure 4*

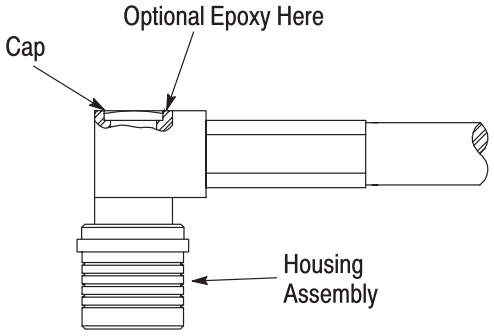



*Figure 5*