

CONNECTOR NUMBER	CRIMP DIE	HEX SIZE [Inch]	CABLE TYPE
1408339-1, -2	1060714-1, No. C	.128	RG-174/U, RG-188/U, RG-316/U
1408339-3, -4	1055270-1	.151	RD-316/U Double Braid
1408339-5, -6	1060714-1, No. B	.213	RG-142/U, RG-55/U, RG-223/U, RG-400/U
1408339-7, 8			RG-58/U, RG-141/U, RG-303/U

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for QMA Bulkhead Cable Connector Assemblies 1408339-1 through 1408339-8, which are applied onto various cable types. Refer to the table in Figure 1 for connector, crimp die, and cable type combinations.

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



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

TOOL DESCRIPTION	TE PART NUMBER
Center Contact Holder	1055454-1
Crimp Tool	1060713-1
Ferrule Crimp Die [.213 and .128 Hex]	1060714-1
Ferrule Crimp Die [.151 Hex]	1055270-1
OPTIONAL TOOLING	
Crimp Tool	1055780-1
Ferrule Crimp Die [.213 and .128 Hex]	1055781-1
Ferrule Crimp Die [.151 Hex]	1055880-1

Figure 2

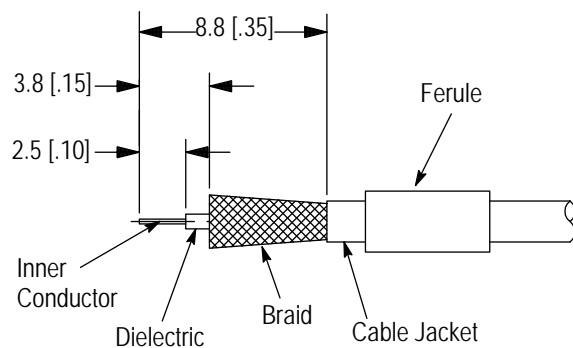
2. DESCRIPTION

The connector assemblies consist of a housing subassembly, a center contact, a ferrule, a mounting nut, and a lockwasher.

3. ASSEMBLY PROCEDURES

3.1. 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.
5. Flare braid.



NOTE: Not to Scale

Figure 3

3.2. Solder Center Contact to Inner Conductor (Figure 4)



To avoid personal injury, be sure to exercise care when working around soldering equipment.

1. Tin inner conductor of cable.
2. Place contact in center contact holder.
3. Heat contact and push it over the inner conductor to rest firmly against the dielectric as shown in Figure 4.
4. Remove excess solder.

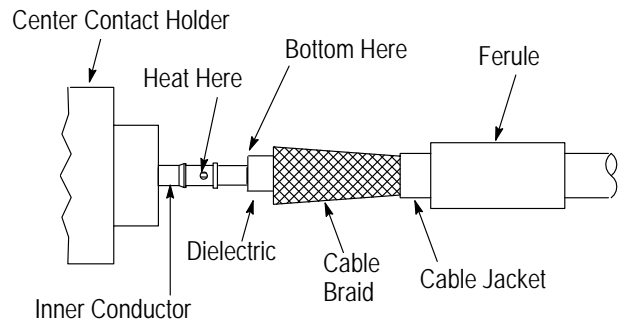


Figure 4

3.3. Crimp Cable to Ferrule (Figure 5)

1. Insert the cable subassembly into the housing subassembly and seat firmly.
2. Slide the ferrule over flared portion of cable braid.
3. Hold the cable firmly seated and crimp the ferrule in place. Refer to the table in Figure 1 for connector, crimp die, and cable type combinations.
4. Trim and remove excess cable braid.

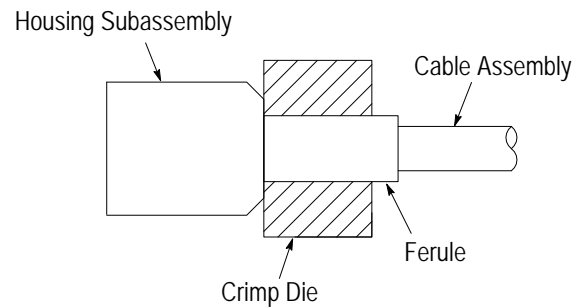


Figure 5

3.4. Inspection of Completed Assembly

Following the assembly procedures in this instruction sheet should yield tolerance shown in Figure 6.



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

4. REVISION SUMMARY

- Updated document to corporate requirements
- New logo

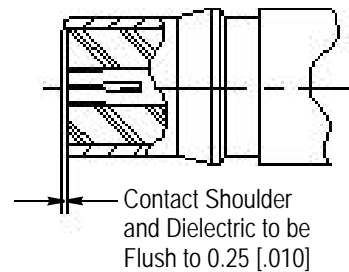


Figure 6