

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for QMA Right-Angle Cable Plug Connector 1408347-1. See Figure 1. This solder attachment-type plug is used on .141 semi-rigid (RG402/U) and conformable cables with similar diameters.



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

2. DESCRIPTION

QMA Right-Angle Plug Connector 1408347-1 consists of a housing subassembly and a disc.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Coaxial Cable End (Figure 2)

1. Remove the end portion of the outer conductor and dielectric to expose the inner conductor.
2. Trim the inner conductor to length.

3.2. Soldering the Inner Conductor Housing Subassembly (Figure 3)

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



To avoid personal injury, be sure to follow all local safety practices when using soldering equipment.

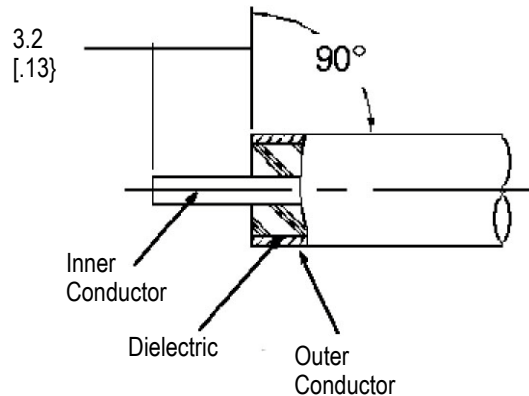


Figure 2

2. Tin inner conductor of cable.
3. Insert cable into housing subassembly.
 - a. Nest the inner conductor in contact slot.
 - b. Bottom the outer conductor in the housing subassembly as shown in Figure 3. Hold in place

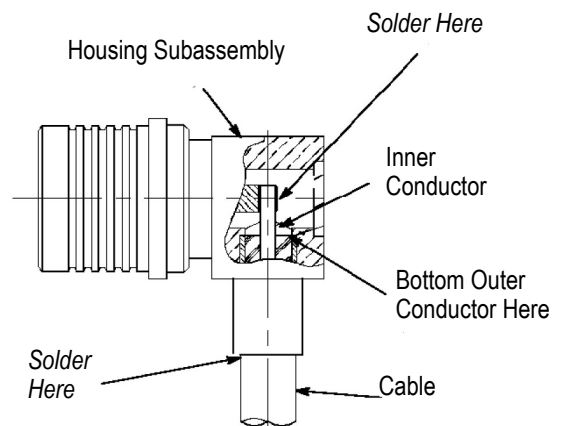


Figure 3

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

3.3. Soldering the Cable Subassembly to the Housing Subassembly

Solder the housing subassembly to the outer conductor as shown in Figure 3.

3.4. Sealing the Opening in Housing

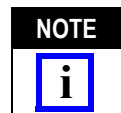
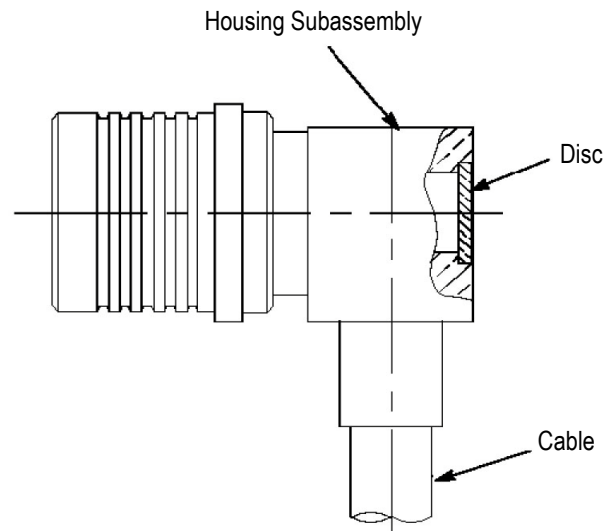
1. Press disc into opening in rear housing subassembly. See Figure 4.
2. Disc may be epoxied into place.



Do not allow epoxy to penetrate inside housing.



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



Not to Scale

Figure 4

4. REVISION SUMMARY

Since the previous revision, the TE logo has been applied.