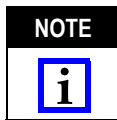


CONNECTOR ASSEMBLY 1408338	CABLE SIZE AND TYPE (RG/U, Unless Noted)	FERRULE CRIMPING DIE		HEX SIZE (mm [in.])	CRIMP TOOL FRAME	CENTER CONTACT HOLDER
		RECOMMENDED	ALTERNATE			
-1, -2	174, 188, 316	1060714-1	1055781-1	3.25 [.128] (C)	1060713-1 or 1055780-1	1055454-1
-3, -4	RD-316/U Double Braid	1055270-1	—	3.84 [.151]	1060713-1	
-5, -6	142, 55, 223, 400	1060714-1	1055781-1	5.41 [.213] (B)	1060713-1 or 1055780-1	
-7, -8	58, 141, 303, SF142					

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly procedure for QMA Straight Cable Connector Assemblies 1408338-[]. Applicable cable sizes and types and tooling used to assemble the connector assembly are given in Figure 1.



Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

Each connector assembly consists of a housing subassembly, center contact, and ferrule. See Figure 1.

3. ASSEMBLY PROCEDURE

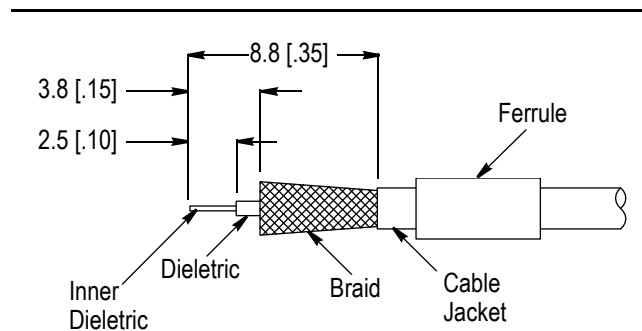
3.1. Prepare Cable (Figure 2)

1. Place the ferrule on the cable.
2. Remove the end portion of the cable jacket to expose the braid.
3. Trim the braid and dielectric to given lengths.
4. Flare the braid.

3.2. Solder Center Contact to Cable (Figure 3)



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



Note: Not to Scale

Dimensions are in millimeters [with inches].

Figure 2

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

3.3. Crimp Ferrule to Cable (Figure 4)

1. Insert the cable subassembly into the housing subassembly and seat it firmly.
2. Slide the ferrule over the flared portion of the cable braid.
3. Hold the cable firmly seated, and crimp the ferrule in place.
4. Trim and remove excess cable braid.

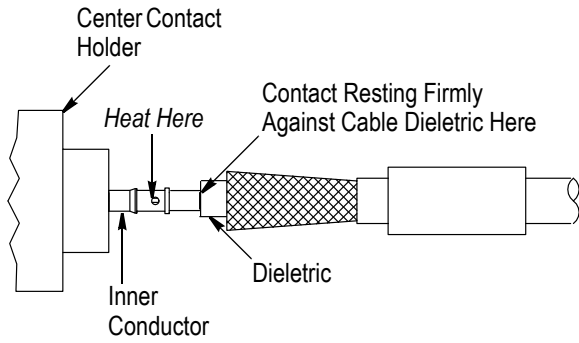


Figure 3

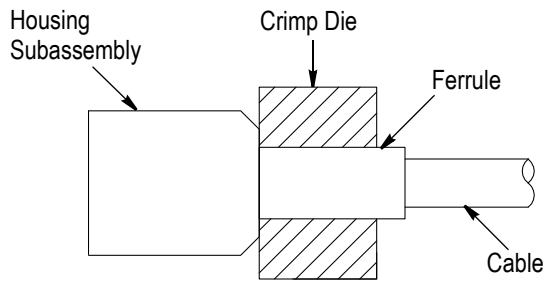


Figure 4

3.4. Inspection

Following this assembly procedure should yield the tolerance given in Figure 5.



Do not use damaged components. They should be replaced with new components.

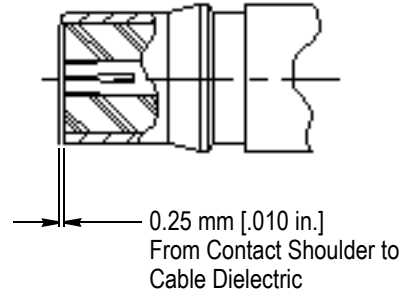


Figure 5

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Combined previous Figure 2 with Figure 1
- Removed obsolete ferrule crimp die (.151 hex)