

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly of Coaxial RF Series 50-Ohm (228217-[]) Commercial SMB Bulkhead Jack Connectors. See Figure 1. The connectors are crimped onto various sizes of RG/U flexible coaxial cable using hand tools listed in Figure 2 and hand tools and die assemblies that are qualified to Military Specification M22520. For detailed crimping procedures, refer to the instructions packaged with the hand tool.



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 are provided in Section 5, REVISION SUMMARY.

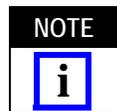
2. DESCRIPTION

The bulkhead jack connectors are supplied as kits consisting of a jack body, a lockwasher, a nut, a center

contact, and a ferrule. The threaded section of the jack body is designed with a flat surface to prevent rotation after the body is installed into the panel cutout. The kit specified for RG-196/U and 178/U cable includes a support spacer and a step-down ferrule to compensate for smaller diameter cable.

3. ASSEMBLY PROCEDURE

1. Slide ferrule over cable jacket. Strip cable according to the appropriate dimensions provided in Figure 3; then flare cable braid. Be careful not to nick or cut the center conductor or cable braid.



If using RG-196/U or 178/U cable, slide the support spacer over the dielectric.

2. Insert center contact into contact crimp section of the appropriate tool. Make sure contact is bottomed against the locator.

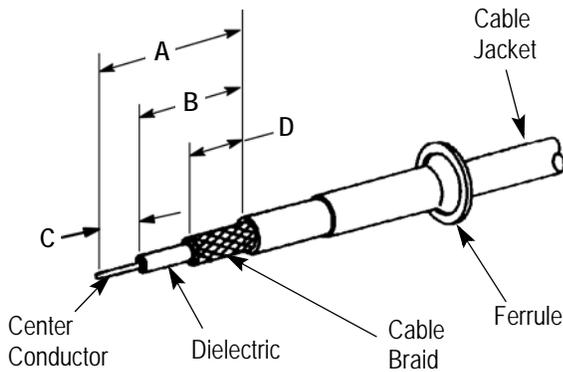
TOOLING

RG/U CABLE	PRO-CRIMPER* III FRAME ASSEMBLY 354940-1		HAND TOOL 69710-1 OR 626 "C" HEAD ADAPTER 318161-1	DANIELS M22520/ 2-01 (Contact Crimp)	DANIELS M22520/5-01 (Ferrule Crimp)	
	DIE ASSEMBLY	POSITION LETTER		DIE ASSEMBLY	POSITIONER	HEX DIE SET
		CONTACT CRIMP	FERRULE CRIMP			
174, 188, 316	58489-1	D	A	58108-1	K727 (Selector No. 4)	Y444
188, 316 (Double Braid)			C			Y196 (Location A)
178, 196			B			Y624
179, 187, H.P.† Cable	--	--	--	--	--	Y444 (50-Ohm) Y215 (75-Ohm)

† Hewlett Packard Company (Part No. 8120-0552-1)

Figure 2

Recommended Strip-Length Dimensions



CONNECTOR TYPE	DIMENSIONS (mm [in.])			
	A (Ref)	B	C	D
50-Ohm	9.27 [.365]	6.10 ±0.38 [.240 ±.015]	3.18 ±0.38 [.125 ±.015]	3.96 ±0.38 [.156 ±.015]

Figure 3

3. Slide contact onto center conductor of cable until contact is positioned against the cable dielectric.
4. Crimp contact as described in the instruction sheet packaged with the tool.
5. Insert crimped contact into bulkhead jack body until the contact shoulder bottoms inside the body. See Figure 4, Detail A.

NOTE Cable braid must be positioned over the support sleeve of the jack body as shown in Figure 4, Detail B.

6. Slide ferrule over braid and support sleeve until ferrule is positioned against the shoulder of the connector, as shown in Figure 4, Detail C.
7. Crimp ferrule according to instructions packaged with the appropriate tool. See Figure 4, Detail D.

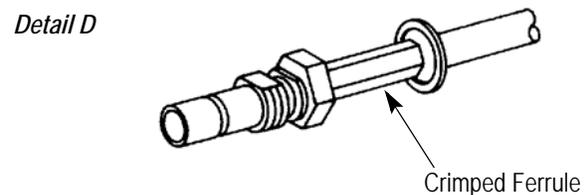
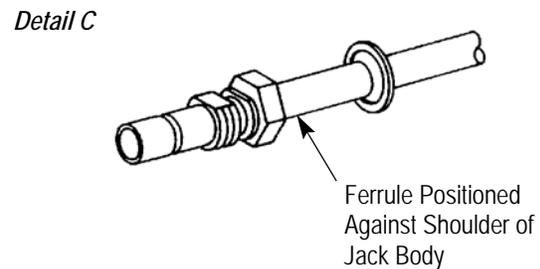
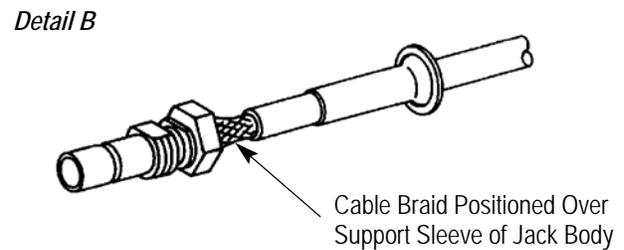
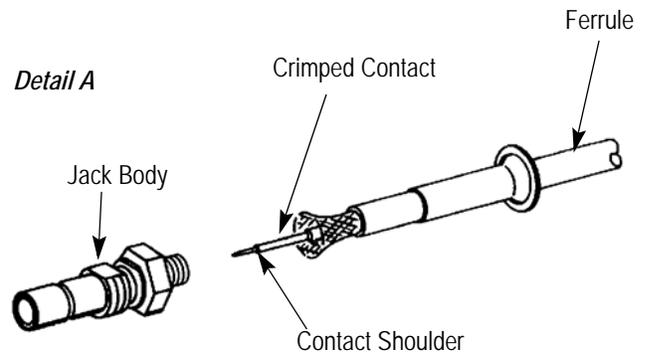
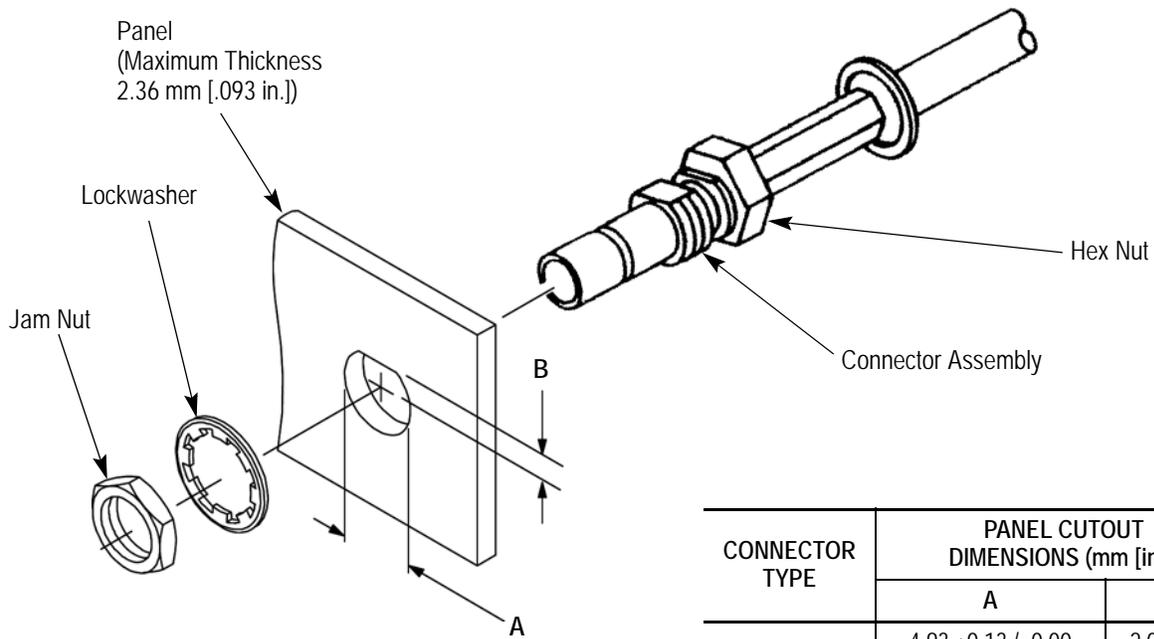


Figure 4



CONNECTOR TYPE	PANEL CUTOUT DIMENSIONS (mm [in.])	
	A	B
50-Ohm	4.93 +0.13 / -0.00 [.194 +.005 / -0.00]	2.01 - 2.08 [.079 - .082]

Figure 5

4. PANEL MOUNTING

1. Make a cutout in the panel using the appropriate dimensions provided in Figure 5.
2. Insert connector assembly into panel cutout, as shown in Figure 5. Install lockwasher and jam nut to secure connector to panel. Recommended tightening torque of jam nut is 0.45-0.68 N•m [4-6 in.-lb].



For panels with thicknesses less than 20 gauge (0.91 mm [.036 in.]) thick, hold hex nut on connector assembly when installing lockwasher and jam nut to avoid damage to the connector assembly and/or panel mount.

5. REVISION SUMMARY

Since the previous release of this document, the following changes were made

- Updated document to corporate requirements.