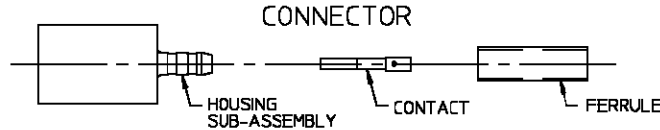
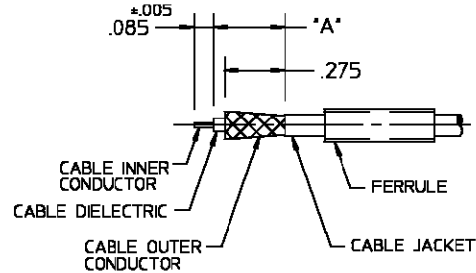


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
SMA con STRAIGHT CABLE CONNECTORS CRIMP ATTACHMENT	SEE TABLE	CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) CRIMP TOOLING: CRIMP TOOL 5698-5014-54 FERRULE CRIMP DIE 5698-5015-54 (.213 & .128 HEX) 2098-0323-54 (.151 HEX) CENTER CONTACT CRIMP DIE 2598-5379-54 (.042 HEX) OPTIONAL CRIMP TOOLING: CRIMP TOOL 2598-5006-54 FERRULE CRIMP DIE 2598-5007-54 (.213 & .128 HEX) 2598-5380-54 (.151 HEX) CENTER CONTACT CRIMP DIE 2598-5380-54 (.042 HEX) FOR SPECIFIC APPLICATION SEE TABLE ON SHEET 2 OF THIS PROCEDURE

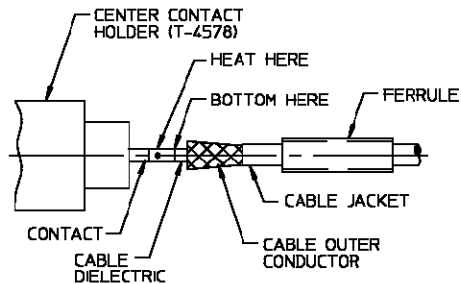


### ASSEMBLY OPERATIONS

- 1.0 PREPARE COAXIAL CABLE END
  - 1.1 PLACE FERRULE ON CABLE.
  - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
  - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
  - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
  - 1.5 FLARE OUTER CONDUCTOR.

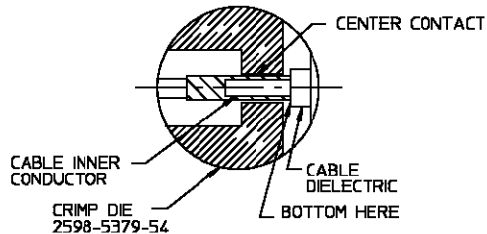


- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR
  - 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 PLACE CONTACT IN HOLDER, HEAT CONTACT AND PUSH IT OVER THE CABLE INNER CONDUCTOR TO REST FIRMLY AGAINST THE CABLE DIELECTRIC AS SHOWN.
  - 2.3 REMOVE EXCESS SOLDER.

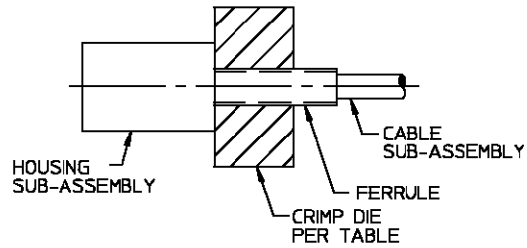


OPTIONAL CRIMPING OF THE CENTER CONTACT INSTEAD OF SOLDERING

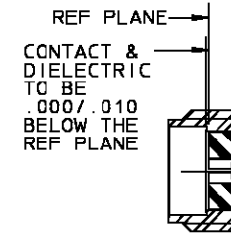
- 3.0 CRIMPING OF CENTER CONTACT TO CABLE INNER CONDUCTOR
  - 3.1 ASSEMBLE CONTACT OVER THE CABLE INNER CONDUCTOR UNTIL IT RESTS FIRMLY AGAINST THE CABLE DIELECTRIC AS SHOWN.
  - 3.2 HOLD CONTACT FIRMLY SEATED AGAINST CABLE DIELECTRIC AND CRIMP CONTACT IN PLACE.



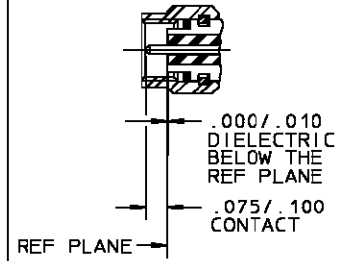
- 4.0 CRIMP CABLE TO INNER SLEEVE.
- 4.1 INSERT CABLE SUB-ASSEMBLY INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
- 4.2 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 4.3 HOLD CABLE FIRMLY SEATED AND CRIMP OUTER SLEEVE IN PLACE.
- 4.4 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 5.0 INSPECTION OF COMPLETED ASSEMBLY.
- 5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN.



JACK INTERFACE



PLUG INTERFACE

CONNECTOR NO.	TYPE	CRIMP DIE	HEX SIZE	DIM "A"	CABLE TYPE
2231-7316-XX	PLUG	2098-0323-54	.151	.320	RD-316 DOUBLE BRAID
2231-7341-XX	PLUG	5698-5015-54 NO. B	.213	.315	RG-142, RG-55, RG-223, RG-400
2231-7388-XX	PLUG	5698-5015-54 NO. C	.128	.320	RG-174, RG-188, RG-316
2234-7316-XX	JACK	2098-0323-54	.151	.325	RD-316 DOUBLE BRAID
2234-7341-XX	JACK	5698-5015-54 NO. B	.213	.315	RG-142, RG-55, RG-223, RG-400
2234-7388-XX	JACK	5698-5015-54 NO. C	.128	.325	RG-174, RG-188, RG-316

NOTE: CRIMPING TO SOLID CENTER CONDUCTOR CABLES IS NOT RECOMMENDED