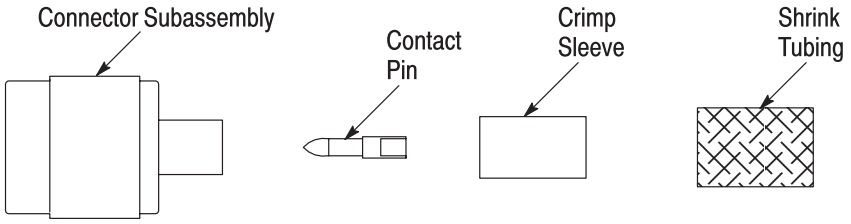


CONNECTOR	CABLE TYPE
1274532–1	LMR–240 Coaxial Cable
1274693–1	WP93385L3 Coaxial Cable
1314078–1	MA318 .320–in. Low–Loss Coaxial Cable
1314078–2	

Figure 1

1. INTRODUCTION

This instruction sheet covers the cable preparation, contact assembly, and inspection of Type “N” straight cable connectors shown in Figure 1. Cable type used with each connector is given in Figure 1.

NOTE

All numerical values in this instruction sheet are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Figures are not drawn to scale.

Refer to Figure 2 for tooling required to apply these connectors.

CONNECTOR	REQUIRED TOOLING
1274532–1	.268–in. Hex Crimp Dies
1274693–1	.213–in. Hex Crimp Dies
1314078–1	Braid Spreading Tool 1314084–1 Locating Tool 1251599–1 .384–in. Hex Crimp Dies
1314078–2	

Figure 2

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

2. CABLE PREPARATION

Prepare the coaxial cable end as follows:

1. Slide the shrink tubing and the crimp sleeve onto the cable.

2. Strip the cable to the dimensions given on the appropriate customer drawing for the connector. See Figure 3, Detail A.

DANGER

To prevent personal injury, use protective gloves and other standard protective equipment when using a knife.

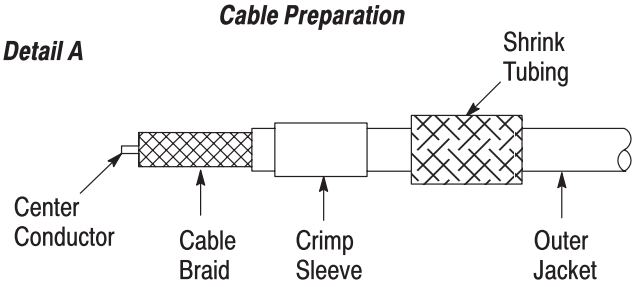
3. When using MA318 low–loss cable, use the braid spreading tool to flare the two cable braid layers away from the cable dielectric. See Figure 3, Detail B.

CAUTION

Be careful not to damage the fluoropolymer core when spreading the cable braids.

Cable Preparation

Detail A



Detail B

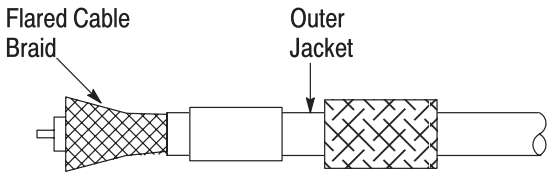


Figure 3

3. CONNECTOR ASSEMBLY

3.1. Solder Center Contact to Cable Center Conductor

To avoid personal injury, be sure to follow all local safety practices when soldering the center contact.

1. Place solder in the contact pin then position the pin on the center conductor so that the shoulder of the pin is flush against the cable dielectric. See Figure 4, Detail A.

2. Solder the contact pin to the center conductor, keeping the contact pin flush to the fluoropolymer cable dielectric.

3.2. Crimp Connector Subassembly to Cable

1. When using MA318 low–loss cable, install the connector subassembly onto the locating tool.

2. Slide the connector subassembly *over* the cable dielectric and *under* the cable braid. See Figure 4, Detail B.

3. Slide the crimp sleeve over the back–end of the connector subassembly then using the appropriate hex crimp dies, crimp the crimp sleeve to the cable and connector. See Figure 4, Detail C.

4. Trim off any excess braids.

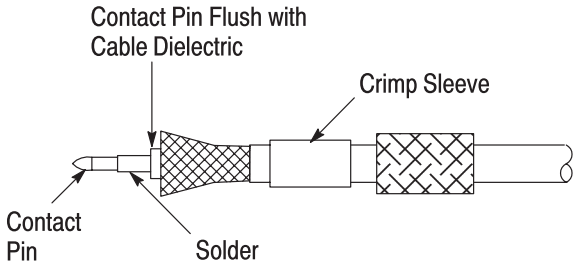
3.3. Apply Heat Shrink Tubing to Crimped Connector

1. Slide the heat shrink tubing against the body of the connector subassembly.

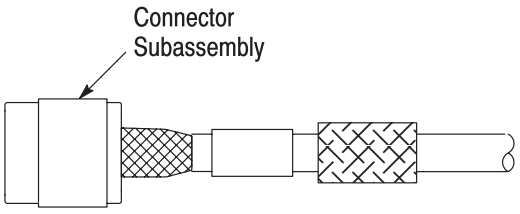
2. Apply heat to the tubing, shrinking it onto the cable. See Figure 4, Detail D.

Conenctor Assembly

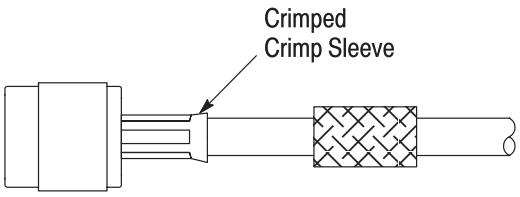
Detail A



Detail B



Detail C



Detail D

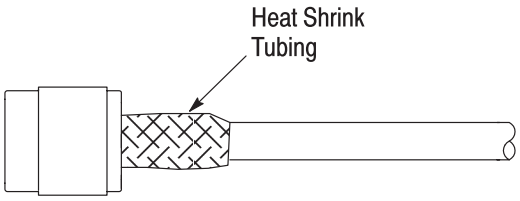


Figure 4

4. INSPECTION

Adherence to these steps will result in the dimension given in Figure 5.

Inspection

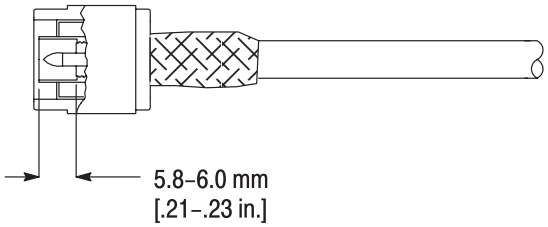


Figure 5

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements
- Added Connector 1274693–1