

RG/U CABLE	CONNECTOR P/N		HAND TOOL P/N (Instr. Sheet 2224)	DIE SET FOR TOOL P/N 69365 (Instr. Sheet 2983)
	GOLD	TARN. RES.		
174,188	51751-1	228028-1	220020-1	220018-1
178,196	51751-2	228028-2	220020-1	220018-1
179	51751-3	228028-3	220020-1	220018-1
196 DBL. BRD.	51751-7	228028-4	220020-1	220018-1
RD-316,188 DBL. BRD.	51751-8	228028-5	220020-2	-

Figure 1

1. INTRODUCTION

See Figure 1 for connector part numbers along with tools and dies used to terminate the cables listed.

Figure 2 shows a typical COAXICON series SMC connector assembly. Detailed crimping instructions are packaged with the crimping tools and dies. Refer to Figure 3 and steps below for assembly procedure.

Refer to Section 3 for use of center contact locating gage when assembling SMC connectors on RG 178 and 196 cables.

2. CONNECTOR ASSEMBLY (Figure 3)

- (a) Slide ferrule onto cable and strip cable to dimensions shown. (Note orientation of stepped ferrule in figures 2 and 4.) Flare braid.

NOTE: Center contact is partially enclosed in tape to facilitate handling and crimping.

- (b) Slide center contact onto center conductor of cable until it is bottomed. Crimp center contact; then remove tape (See instructions packaged with tool.)
- (c) Insert contact into connector with braid over support sleeve. Ensure cable dielectric bottoms inside connector.
- (d) Slide ferrule forward over braid and support sleeve.
- (e) Crimp ferrule (see tool instructions).

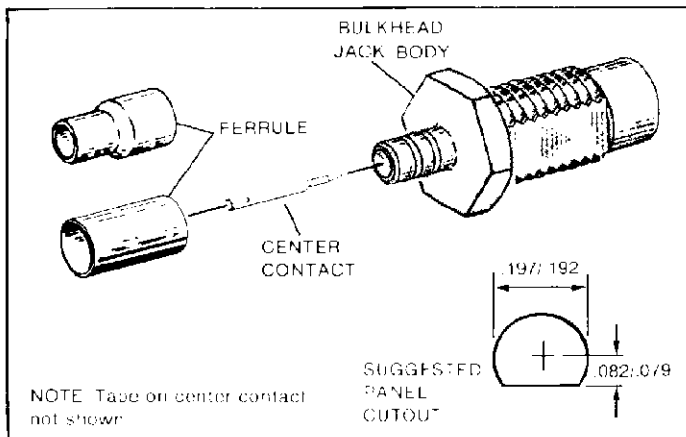


Figure 2

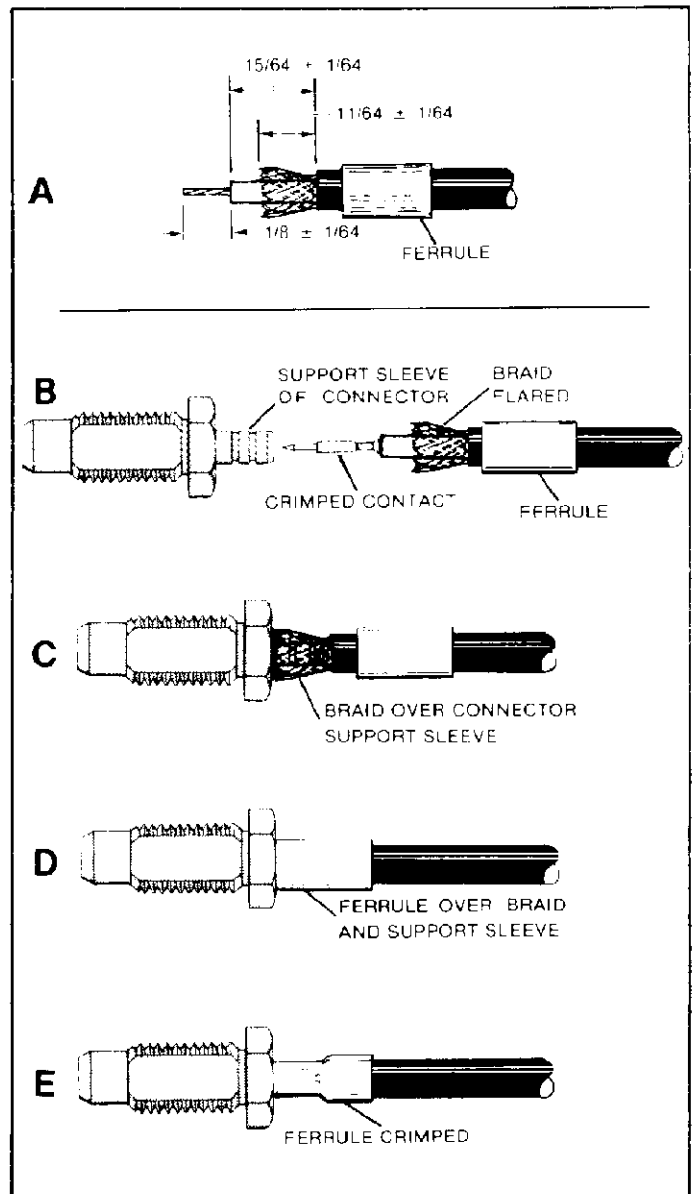


Figure 3

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3. CENTER CONTACT LOCATING GAGE FOR USE WITH RG 178, 196 CABLES

Center contact locating gage P/N 225162-1 is used as follows when assembling all SMC connectors on RG 178 and 196 cables.

- (a) Strip cable and crimp center contact as previously described.
- (b) Screw gage onto connector body.

- (c) Insert crimped contact into connector body until end of contact butts against stop inside gage.
- (d) Slide ferrule over braid and support sleeve until it butts against connector.
- (e) Remove gage from connector and complete ferrule crimp.

NOTE: Gage must be removed if assembly is crimped in hand tool P/N 220020-1, but can be left on connectors while crimping in tool P/N 69365.

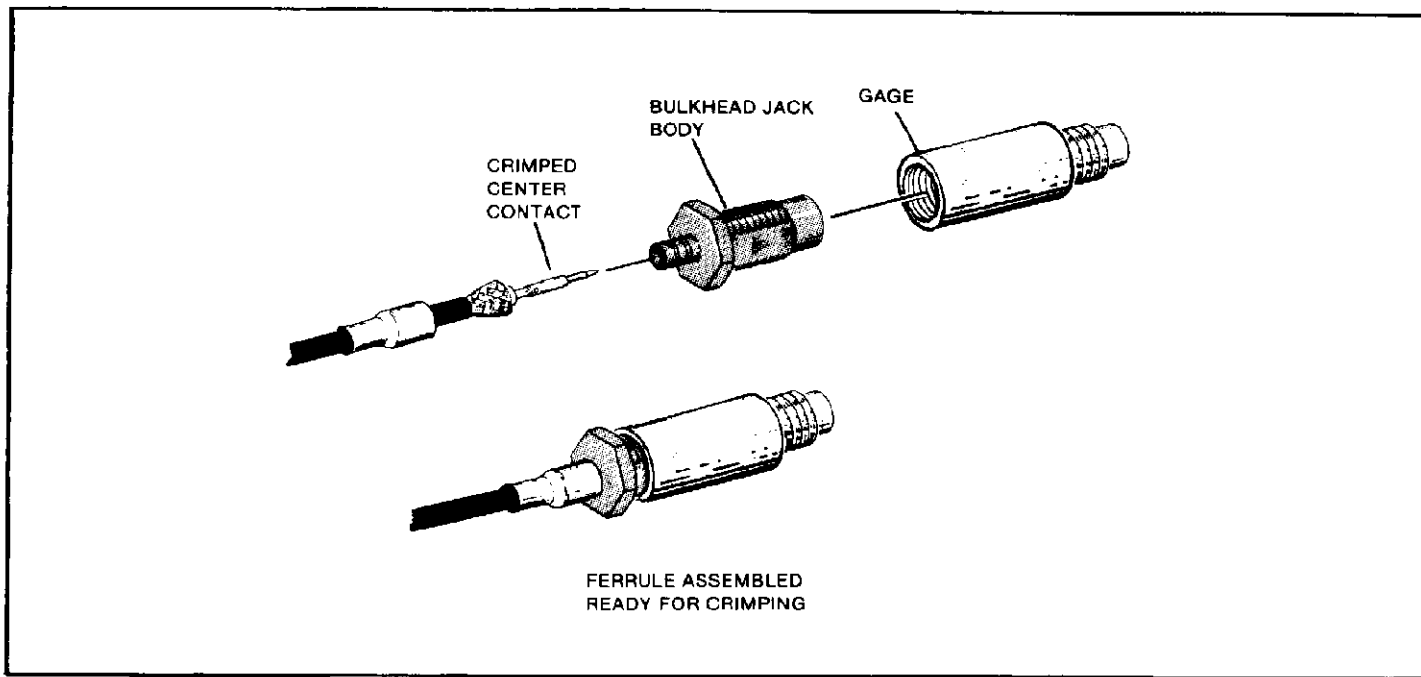


Figure 4

The following publications contain information on additional series SMC connectors.

- PLUGS – IS 2224-1
- JACKS – IS 2224-2
- PANEL JACKS – IS 2224-4
- RIGHT ANGLE PLUGS – IS 2224-5
- RIGHT ANGLE BULKHEAD JACKS – IS 2224-6