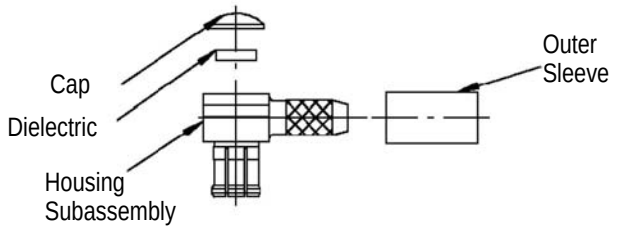

CONNECTOR PART NUMBER		CABLE
CURRENT (TE)	PREVIOUS	
106089-1	5837-5003-10	rg 174/u, 179, 187, 188, and 316

Figure 1

1. INTRODUCTION

These instructions cover the application of the MCX Right-Angle Cable Plug listed in the table in Figure 1. This connector is used in crimp-type attachment applications, on the cable listed in Figure 1.

NOTE
Dimensions in these instructions are in metric units [with U.S. customary units in brackets], unless otherwise indicated.

The crimp tooling is listed below:

Crimp Tool Kit	1055236-1	2098-0105-54

Reasons for revision are listed in Section 3, REVISION SUMMARY.

2. ASSEMBLY

2.1. Coaxial Cable Preparation (Figure 2)

1. Slide the outer sleeve (ferrule) over the cable.
2. Strip the end portion of the cable jacket to expose the cable outer conductor (cable braid) to the dimensions in Figure 2.
3. Trim the outer conductor to length.
4. Trim the cable dielectric to length.
5. Trim the inner conductor to length.
6. Flare the outer conductor as shown in Figure 2.

2.2. Soldering the Center Contact to the Cable Inner Conductor (Figure 3)

DANGER
Soldering equipment is hot. To avoid personal injury, be sure to follow all local and safety practices (including wearing gloves).

1. Position and secure housing in a small bench or vise.
2. Tin the inner conductor of the cable.
3. Insert the cable into the housing subassembly.
   a. Nest the cable inner conductor in the center contact slot.
   b. Bottom the cable dielectric on the connector dielectric.
4. Place a solder iron on the tip of the center contact and solder.

2.3. Crimping the Connector to Cable (Figure 3)

1. Slide the outer sleeve (ferrule) over the flared cable braid.
2. Crimp the outer sleeve in place.
3. Trim and remove excess cable braid strands.

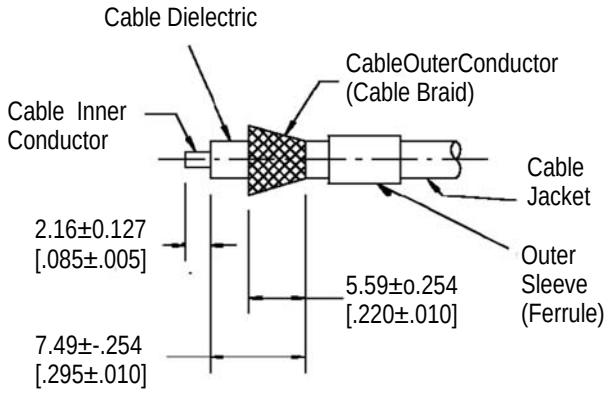

Figure 2

2.4. Sealing the Housing Opening (Figure 4)

1. Press the dielectric into the opening in the rear of the housing subassembly.
2. Place the cap into the opening in the rear of the housing subassembly. Either press, solder, or epoxy the cap into place.

CAUTION
Damaged components must not be used. They must be replaced with new components.

3. REVISION SUMMARY

Since the previous release of this document, the Crimp Tooling Kit part number was updated.

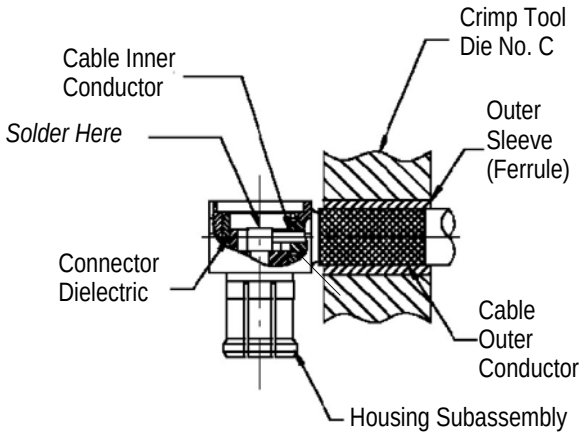

Figure 3

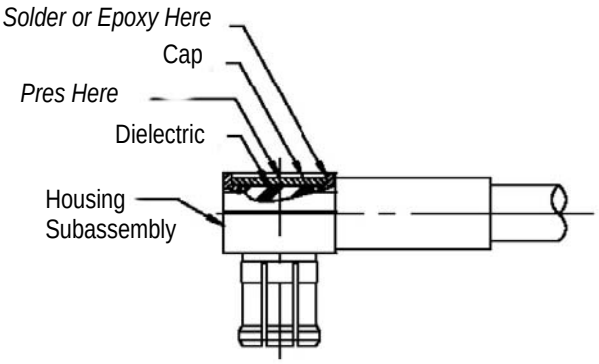

Figure 4