

CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
SMC STRAIGHT CABLE PLUG CLAMP ATTACHMENT	RG-178/U RG-188/U RG-196/U RG-316/U OSMT CABLE	TORQUE WRENCH: 2598-5243-54 CENTER CONTACT HOLDER 2098-5237-10

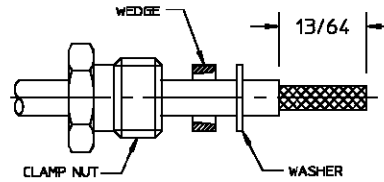
CONNECTOR



ASSEMBLY OPERATIONS

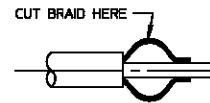
Step 1

- Cut cable jacket to dimension shown, being careful not to nick braid.
- Place nut (hex first) and wedge (small opening first over jacket) and washer over jacket



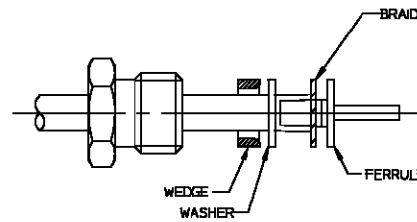
Step 2

- Push back braid to expand and facilitate cutting. Cut braid with small pointed scissors at point of widest expansion.



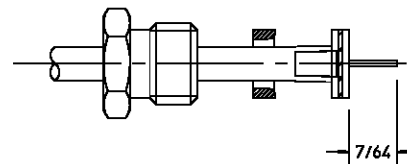
Step 3

- Flare out remaining braid.
 - Then insert ferrule between the braid and cable dielectric until braid is wedged firmly between flange of ferrule and jacket.
- Note: Two razor slits approx. .12 long and 180° apart will ease the insertion of the ferrule.



Step 4

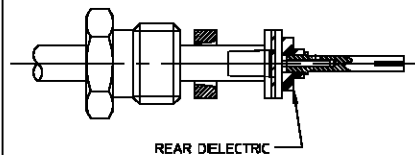
- Trim braid to dia of flange.
- Trim cable dielectric flush with ferrule.
- Tin center conductor.
- Trim center conductor to dimension shown.



Step 5

- Slip rear dielectric over center contact.
- Using center contact holder, solder center contact to center conductor of cable to seat rear dielectric against the flange of the inner sleeve.

NOTE:
TO AVOID DAMAGE TO THE CABLE WHEN USING OSMT CABLE MINIMIZE TIME AT TEMPERATURE WHEN SOLDERING AND/OR HEAT SHRINKING CONNECTOR TO CABLE. AVOID DIRECT HEAT ON EXPOSED CABLE JACKET.



Step 6

- Place dielectric over center contact, move washer, wedge, and clamp nut up to braid. Insert into back end of housing sub-assembly and tighten clamp nut to torque of 7 to 10 in-lbs.

