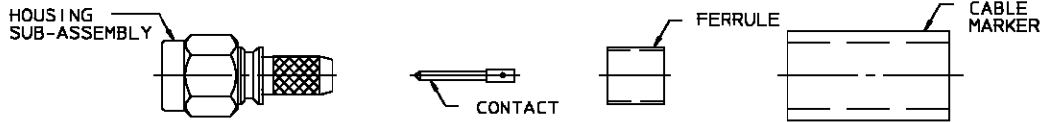


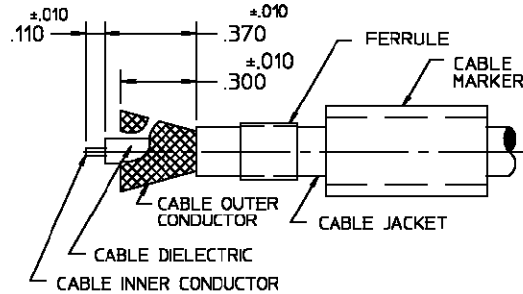
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
SMA CABLE PLUG CRIMP ATTACHMENT	RG-174/U RG-188/U RG-316/U	CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) CRIMP TOOL: 2098-0105-54 DIE NO. C LOCATOR TOOL: 2098-5218-02 (T-2367)

CONNECTOR

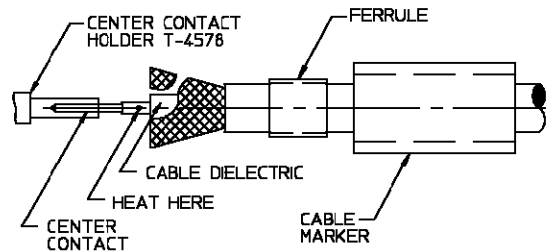


ASSEMBLY OPERATIONS

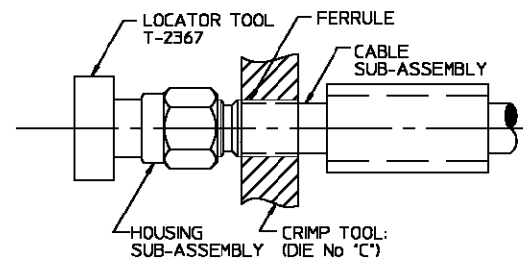
- 1.0 PREPARE COAXIAL CABLE END.
- 1.1 PLACE CABLE MARKER AND FERRULE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



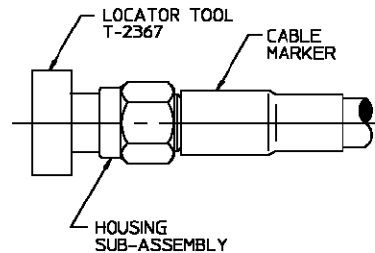
- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR
- 2.1 TIN INNER CONDUCTOR OF CABLE.
 - 2.2 PLACE CONTACT IN HOLDER, HEAT CONTACT AND PUSH IT OVER THE CABLE INNER CONDUCTOR TO REST FIRMLY AGAINST THE CABLE DIELECTRIC AS SHOWN.
 - 2.3 REMOVE EXCESS SOLDER.



- 3.0 CRIMP FERRULE TO CABLE.
- 3.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
 - 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 3.3 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
 - 3.4 SLIDE FERRULE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 3.5 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 4.0 SHRINK CABLE MARKER TO CABLE.
- 4.1 POSITION CABLE MARKER OVER FERRULE AS SHOWN.
 - 4.2 APPLY INDIRECT HEAT WITH A THERMO GUN TO SHRINK CABLE MARKER.
 - 4.3 REMOVE LOCATOR TOOL.
 - 4.4 ASSEMBLY IS NOW COMPLETE



NOTES:
INTERFACE DIMENSIONS PER MIL-STD-384A-310-1