

Figure 1

1. INTRODUCTION

FAKRA-compliant SMB 50-Ohm Inline Plug Kits 638832-[] (shown in Figure 1) and 1326626-[] are designed to be crimped onto flexible coaxial cable. Cable sizes and applicable tooling are listed in Figure 2. For detail procedures on using the tooling, refer to the instructions packaged with the hand tool.

NOTE *Dimensions in this instruction sheet are in millimeters [with inches in brackets].*

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

2. DESCRIPTION

The plug kit consists of a housing and a lock, and one (1-position) or two (2-position): subassembly, socket

contact, and ferrule. When assembled, the lock secures the terminated subassembly to the housing. The housing features keys and a locking latch. The keys are used for inadvertent mating of similar assemblies, and the locking latch is used to ensure full mating.

3. ASSEMBLY PROCEDURE

NOTE *For detailed application requirements, refer to Application Specification 114-13069.*

Perform the following steps for each plug position.

- Slide the ferrule onto the cable.
- Strip the cable to the dimensions shown in Figure 3. Be careful not to nick or cut the center conductor or cable braid. Flare the braid.
- Slide the socket contact onto the cable center conductor until the contact butts against the cable dielectric. See Figure 4. Crimp the contact. Check the crimp to make sure that there is no gap between the contact and cable dielectric.
- Insert the crimped contact into the subassembly until it bottoms in the internal dielectric. Make sure that the cable braid is positioned over the tail end of the subassembly. See Figure 5.

NOTE *Because the subassembly in the plug kits contain a press-fit dielectric, the crimped contact must be pushed firmly into the subassembly until it bottoms.*

CABLE SIZE (RG/U)	PLUG KIT	TOOLING					
		CONTACT CRIMP		FERRULE CRIMP			
		DMC Crimp Tool AFM8 Military M22520/2-01		PRO-CRIMPER* III Frame Assembly 354940-1		DMC Crimp Tool HX4 Military M22520/5-01	
		Positioner	Selector Setting	Die Assembly	Crimping Chamber	Die Set	Hex Position
174●, 316	638832-[]	K699	4●	58483-1	.128 (B)	Y-1637	.128
	1326626-[]						

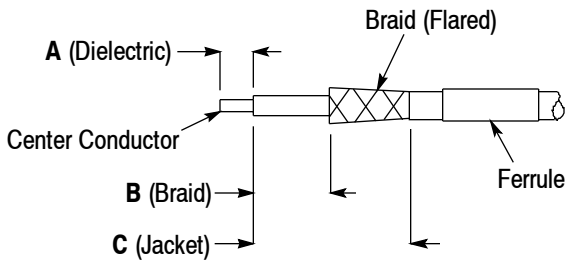
- Cheminax* Coaxial Cable 5024P1309 (equivalent to cable size RG 174/U) can be used. Selector setting should be "2" or "3" when using this cable. To obtain this cable, call PRODUCT INFORMATION at the bottom of this page.

Figure 2

FAKRA is Fachkreis Automobil — DIN Standardization Committee of Motor Vehicles (FAKRA) 70010, DMC is Daniels Manufacturing Company

Recommended Stripping Dimensions

Note: Not to Scale



CABLE SIZE (RG/U)	DIMENSION ± 0.25 [± 010]		
	A	B	C
174, 316	3.25 [.128]	3.75 [.148]	10.95 [.431]

Figure 3

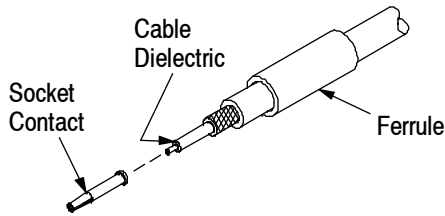


Figure 4

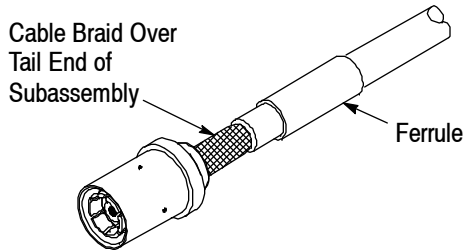
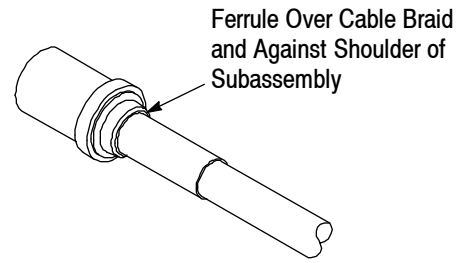


Figure 5

5. Slide the ferrule over the cable braid until the ferrule butts against the shoulder of the subassembly. See Figure 6, Detail A.
6. Crimp the ferrule. Visually inspect the crimped ferrule according to Figure 6, Detail B.
7. Slide the subassembly into the housing at an angle so that the mating end of the subassembly slides under the locking latch. See Figure 7, Detail A.
8. Push the subassembly into the housing until the collar bottoms on the stop. See Figure 7, Detail B.

Detail A



Detail B

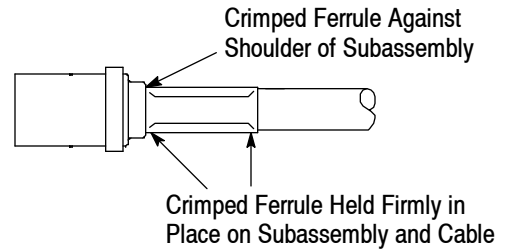
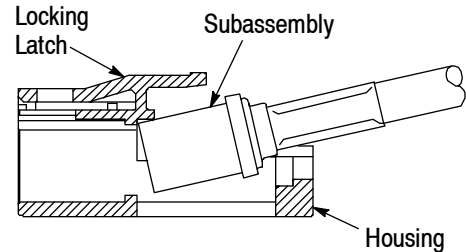


Figure 6

Detail A



Detail B

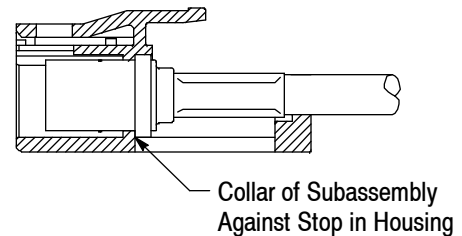


Figure 7

9. Align the locking windows of the lock with the latches of the housing. See Figure 8. Push the lock onto the housing until it “snaps” into place. Check that all latches are fully engaged. If any latch is not fully engaged, press down on the top of the lock while pressing inward on the sides of the lock.
10. Depress the locking latch to make sure that it moves freely. See Figure 9. If the locking latch cannot be depressed, remove the lock and terminated subassembly from the housing, and repeat Steps 6 through 9.

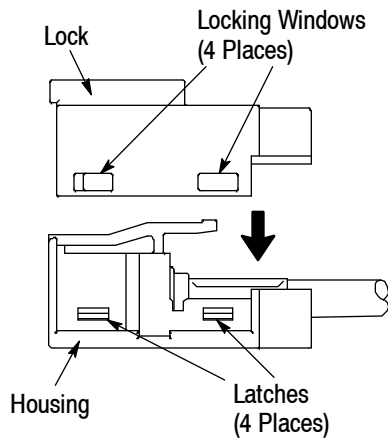


Figure 8

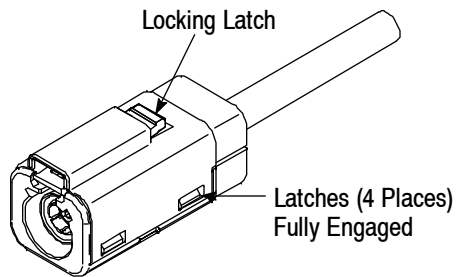


Figure 9

4. REPLACEMENT AND REPAIR

Plug kit components are not repairable. Replace any damaged components. DO NOT re-use terminated socket contacts, ferrules, or subassemblies by removing the cable.

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company logo
- Removed Plug Kits 1326159-[], 1326665-[], and 1488335-[]
- Changed contact information to obtain Cheminax coaxial cable