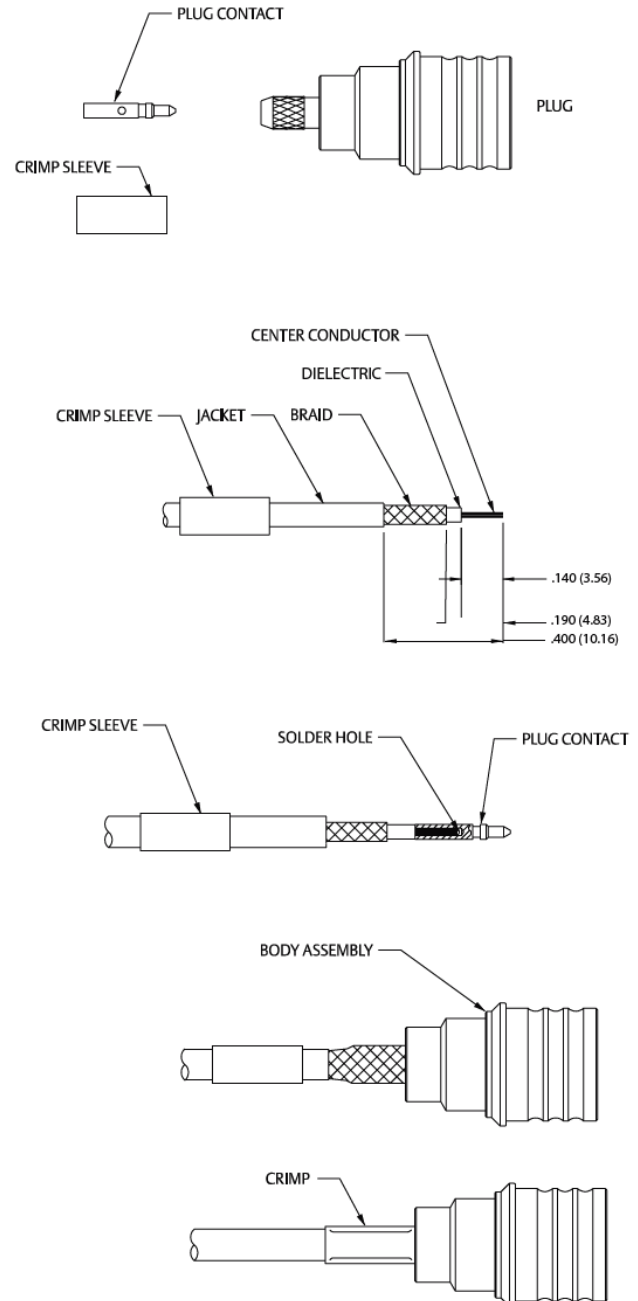


kwiQMAte™ Straight Plugs for Flexible Cable – Crimp or Solder Contacts

1. Identify connector parts. (3 piece parts)
2. Strip cable to dimensions shown. Do not nick braid or center conductor. Tin center conductor if contact will be solder attached. Do not tin center conductor if contact is to be crimp attached. Slide heat shrink (as applicable) and crimp sleeve onto jacket of cable.
3. Assemble contact onto cable as shown. Solder Attachment: Solder contact to center conductor through solder hole using .020 (0.51) diameter solder. Use a minimum amount of solder for a good joint. Crimp Attachment: Crimp contact to center conductor using Johnson® Hand Tool 144-0000-910, setting #2. Crimp location should be centered between end of contact and X-hole. Crimp attachment to solid center conductor cables is not recommended.
4. Flare braid and slide body assembly over contact and under braid. Then seat body assembly firmly onto contact. The cable may have to be held in a clamping fixture. Arrange braid uniformly around crimp stem. Slide crimp sleeve forward and crimp using recommended crimp tool. Slide heat shrink forward and shrink (as applicable).



Cable Group	Part No.	Crimp Hex
RG-316	146-0403-007	.128 (3.25)
RG-316 DS	146-0404-007	.151 (3.83)