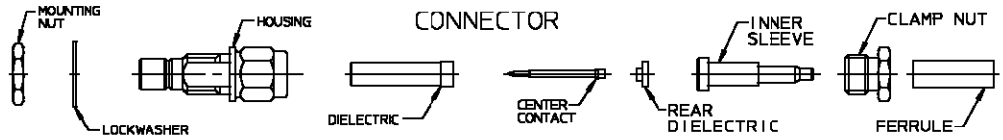
SMB Bulkhead Feedthrough Cable Jack Crimp Attachment 1060407–1

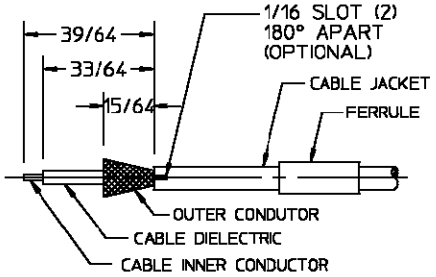
CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
SMB BULKHEAD FEEDTHROUGH CABLE JACK CRIMP ATTACHMENT	RG188 OSMT CABLE	CENTER CONTACT HOLDER: 2098-5237-10(T-4579) CRIMP TOOL: 2598-5005-54(DIE NO."C") TORQUE WRENCH 2598-5243-54



ASSEMBLY OPERATIONS

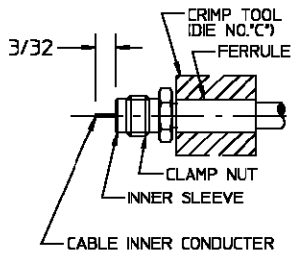
1.0 PREPARE COAXIAL CABLE END

1.1 PLACE FERRULE ON CABLE
1.2 REMOVE END PORTION OF CABLE JACKET AND TRIM CABLE TO DIMENSIONS SHOWN
1.3 FLARE OUTER CONDUCTOR
1.4 CUT TWO SLITS IN CABLE JACKET AS SHOWN (OPTIONAL).



2.0 CRIMP CABLE TO INNER SLEEVE

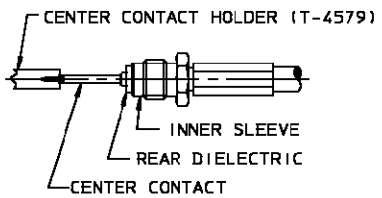
2.1 ASSEMBLE CLAMP NUT ONTO INNER SLEEVE
2.2 INSERT CABLE INTO INNER SLEEVE AND SEAT FIRMLY
2.3 CABLE DIELECTRIC TO BE FLUSH TO INNER SLEEVE. TRIM IF REQUIED
2.4 SLIDE FERRULE OVER FLARED PORTION OF OUTER CONDUCTOR
2.5 HOLD CABLE FIRMLY AND CRIMP FERRULE IN PLACE
2.6 TIN INNER CONDUCTOR
2.7 TRIM INNER CONDUCTOR AS SHOWN.



3.0 ■SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

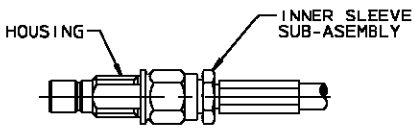
3.1 ASSEMBLE REAR DIELECTRIC ONTO CENTER CONTACT
3.2 PLACE CENTER CONTACT INTO HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE WITH LARGE DIAMETER OF REAR DIELECTRIC RESTING FIRMLY AGAINST THE INNER SLEEVE
3.3 REMOVE EXCESS SOLDER AND FLUX

■ 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.



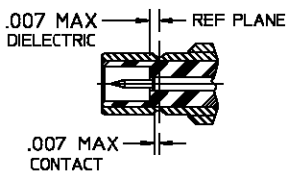
4.0 SECURE HOUSING TO INNER SLEEVE ASSEMBLY

4.1 INSERT DIELECTRIC INTO HOUSING
4.2 CARFULLY INSERT CENTER CONTACT INTO DIELECTRIC
4.3 ENGAGE THREADS OF INNER SLEEVE TO HOUSING AND TORQUE TO 7-10 IN. LBS.



5.0 INSPECT COMPLETED ASSEMBLY

5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN



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