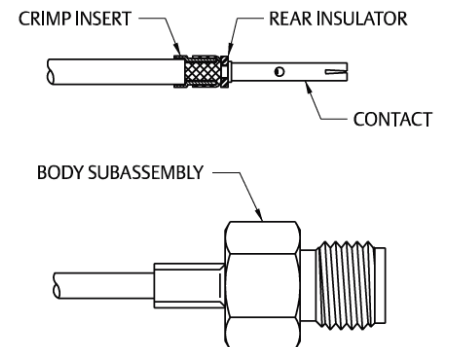
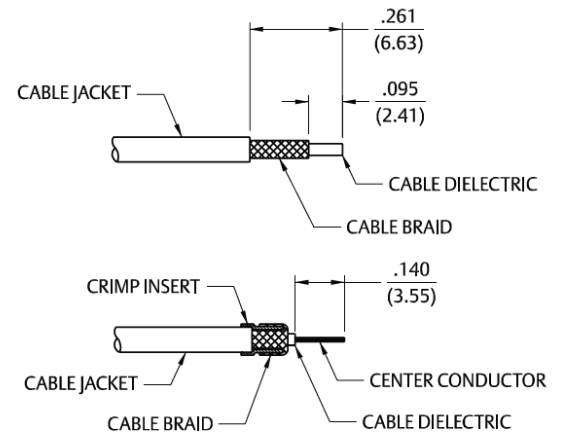


SMA 3-Piece Plug, Jack and Bulkhead Jack for RG-178 Flexible Cable

1. Identify piece parts. (4 piece parts plus nut and washer for bulkhead.)
2. Strip cable jacket and braid to dimensions shown. Do not nick braid during strip operations.
3. Slide crimp insert over braid and against jacket. Fold braid around crimp insert as shown. Strip dielectric to dimension shown. If cable is being manually stripped the rear insulator can be assembled and used as a guide. Do not nick center conductor during strip operation. Tin center conductor if contact is to be solder attached. Do not tin center conductor if contact is to be crimp attached.
4. Assemble rear insulator over cable dielectric and contact over center conductor as shown. **Solder attachment:** Solder contact to center conductor using 60/40 tin/lead solder. Care should be taken that excess solder is not applied. **Crimp attachment:** Crimp contact to center conductor using production tooling or hand tool 144-0000-910, setting #2 with positioner 141-0000-907. Crimp location should be centered between end of contact and x-hole. Crimp attachment to solid center conductor cables is not recommended.
5. Slide body assembly over contact, rear insulator and crimp insert. Crimp body using recommended crimp tool. Maintain forward pressure on cable while crimping. Body crimp die hex: .105 (2.67) hex.



Cable Group	Part No.	Crimp Hex
RG-178/U, 196	142-0402-011	.105 (2.67)
	142-0402-016	.105 (2.67)
	142-0302-011	.105 (2.67)
	142-0302-016	.105 (2.67)
	142-0302-431	.105 (2.67)
	142-0302-436	.105 (2.67)

