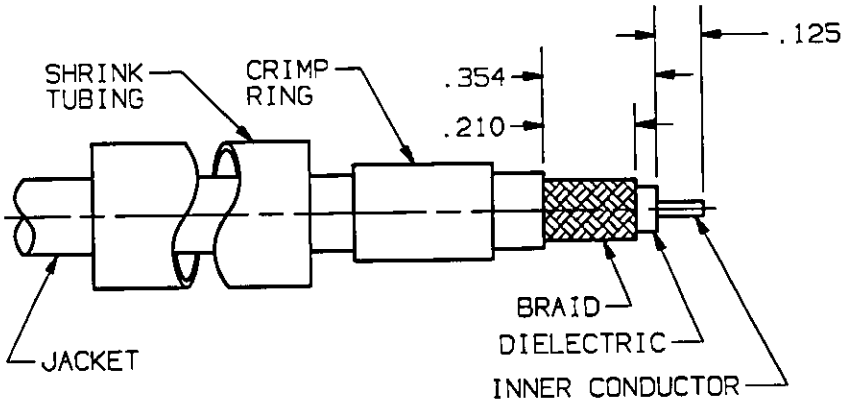
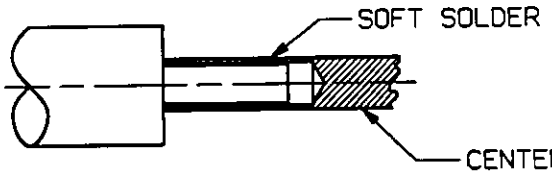
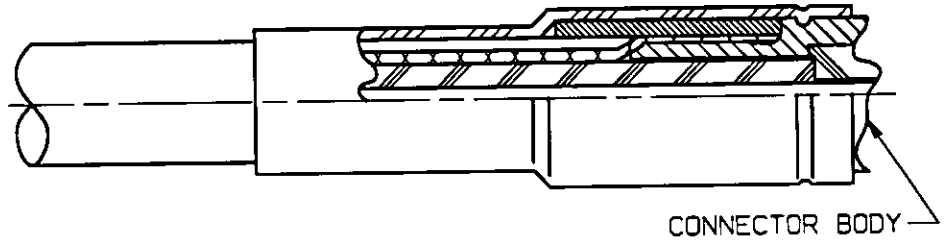
USED ON: 2903-6027

CAD GENERATED DRAWING	DCN CONTROLLED DOCUMENT	DWG. NO.
		300-80-832

ENG. FILE COPY







STEP 1
SLIDE SHRINK TUBING AND CRIMP RING ONTO CABLE AS SHOWN. TRIM CABLE JACKET, BRAID, DIELECTRIC AND INNER CONDUCTOR TO DIMENSIONS SHOWN. DO NOT NICK BRAID OR INNER CONDUCTOR.

STEP 2
TIN CABLE INNER CONDUCTOR. SOFT SOLDER CENTER CONTACT TO INNER CONDUCTOR. REMOVE EXCESS SOLDER.

STEP 3
INSERT CONNECTOR ONTO CABLE UNDER BRAID UNTIL DIELECTRIC BOTTOMS. SLIDE CRIMP RING FORWARD OVER CABLE BRAID AS SHOWN.

STEP 4
USING A CRIMP TOOL WITH THE CORRECT DIE CAVITY (SELECTED FROM THE CHART BELOW) CRIMP "CRIMP RING" OVER CABLE BRAID.

STEP 5
SLIDE SHRINK TUBING FORWARD OVER CRIMP RING AND CONNECTOR BODY. APPLY HEAT TO SHRINK.

RG-/U CABLE SELECTION	CRIMP TOOL SELECTION	DIE SIZE
178 & 196	M22520/10-05	.105
174, 188 & 316	M22520/10-05	.128

SYM.	DESCRIPTION	DATE	APPR.
-	REL. DCN 23409	4/17	

UNLESS OTHERWISE SPECIFIED:
1) ALL DIMENSIONS ARE AFTER PLATING.
2) BREAK CORNERS & EDGES .005 R.MAX.
3) CHAM. 1st & LAST THDS.
4) SURFACE ROUGHNESS 63 / MIL-STD-10.
5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R.
6) REMOVE ALL BURRS.

DRAWN: BRT 4/17/97
CHECKED: 5/28/97
APPROVED: 5/31/97

DIMENSIONS ARE IN INCHES
TOLERANCES:
DECIMALS: .X ±.030, .XX ±.015, .XXX ±.005
FRACTIONAL: ±1/64
ANGULAR: X° ±1°0′, X°X′±15′

MATERIAL: N/A
FINISH: N/A
□" AREA: O.D. N/A, I.D. N/A

SIZE	CAGE NO.	SCALE
A	95077	2X

SOLITRON VECTOR MICROWAVE
3301 ELECTRONICS WAY
WEST PALM BEACH, FL. 33407

TITLE: CABLE ASSEMBLY INSTRUCTIONS (CRIMP)

DWG. NO. 300-80-832