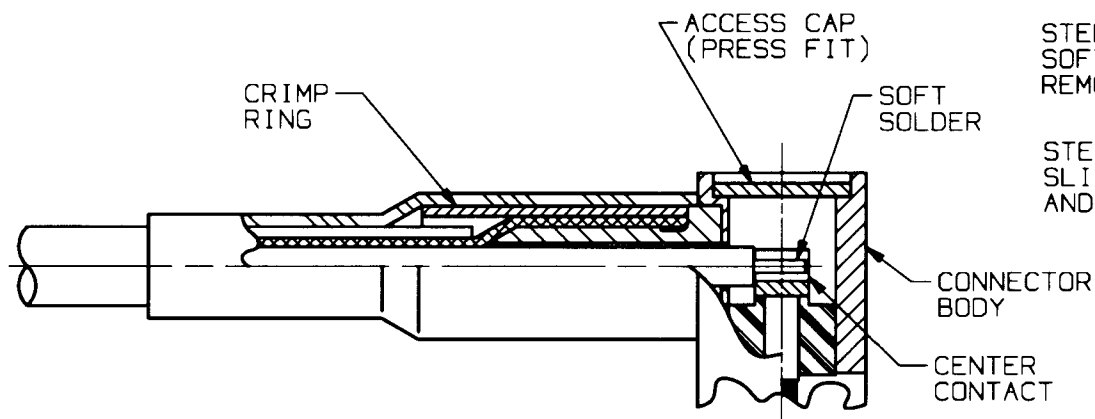
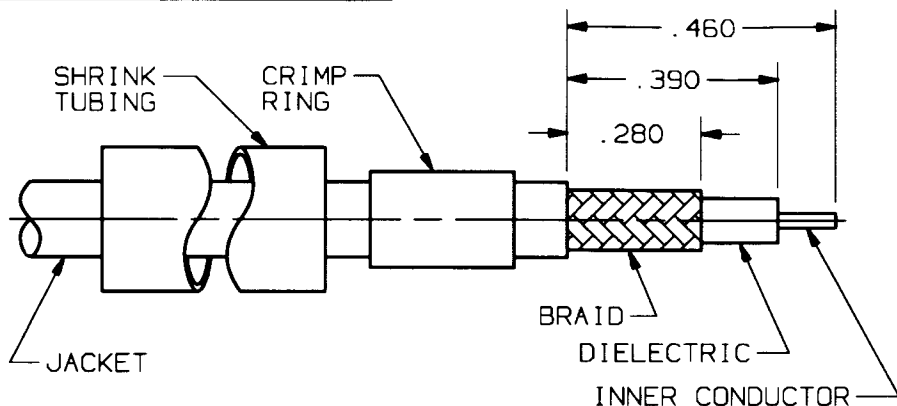


USED ON: 2913-6001

CAD GENERATED DRAWING DCN CONTROLLED DOCUMENT

DWG. NO. 300-80-834



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

STEP 3
USING A CRIMP TOOL WITH THE CORRECT DIE CAVITY (SELECTED FROM THE CHART BELOW) CRIMP "CRIMP RING" OVER CABLE BRAID.

STEP 4
SOFT SOLDER CENTER CONTACT TO INNER CONDUCTOR. REMOVE EXCESS SOLDER. INSTALL ACCESS CAP(PRESS).

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 & 316 | M22520/10-05 | .128 |

| SYM. | DESCRIPTION | DATE | APPR. | 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 J MIL-STD-10. 5) DIAS. ON COMMON CENTERS TO BE CONCENTRIC WITHIN N/A T.I.R. 6) REMOVE ALL BURRS. | DIMENSIONS ARE IN INCHES TOLERANCES: | | | SOLITRON VECTOR MICROWAVE 3301 ELECTRONICS WAY WEST PALM BEACH, FL. 33407 |
|------|----------------|-------|-------|---|---|----------------|-------------|---|
| | | | | | DECIMALS | FRACTIONAL | ANGULAR | |
| - | REL. DCN 23418 | 5/97 | JM | | .X ±.030 | | X° ±1°0' | TITLE: CABLE ASSEMBLY INSTRUCTIONS (CRIMP) |
| A | REV. DCN 24899 | 12/98 | JM | | .XX ±.015 | ±1/64 | X°X' ±15' | |
| | | | | DRAWN: BRT 4/15/97 | MATERIAL: N/A | | □ AREA: N/A | DWG. NO. 300-80-834 |
| | | | | CHECKED: SW 5/02/97 | FINISH: N/A | | O.D. N/A | |
| | | | | APPROVED: JM 5/06/97 | SIZE: A | CAGE NO. 95077 | I.D. N/A | |
| | | | | | | SCALE: 2X | | |