

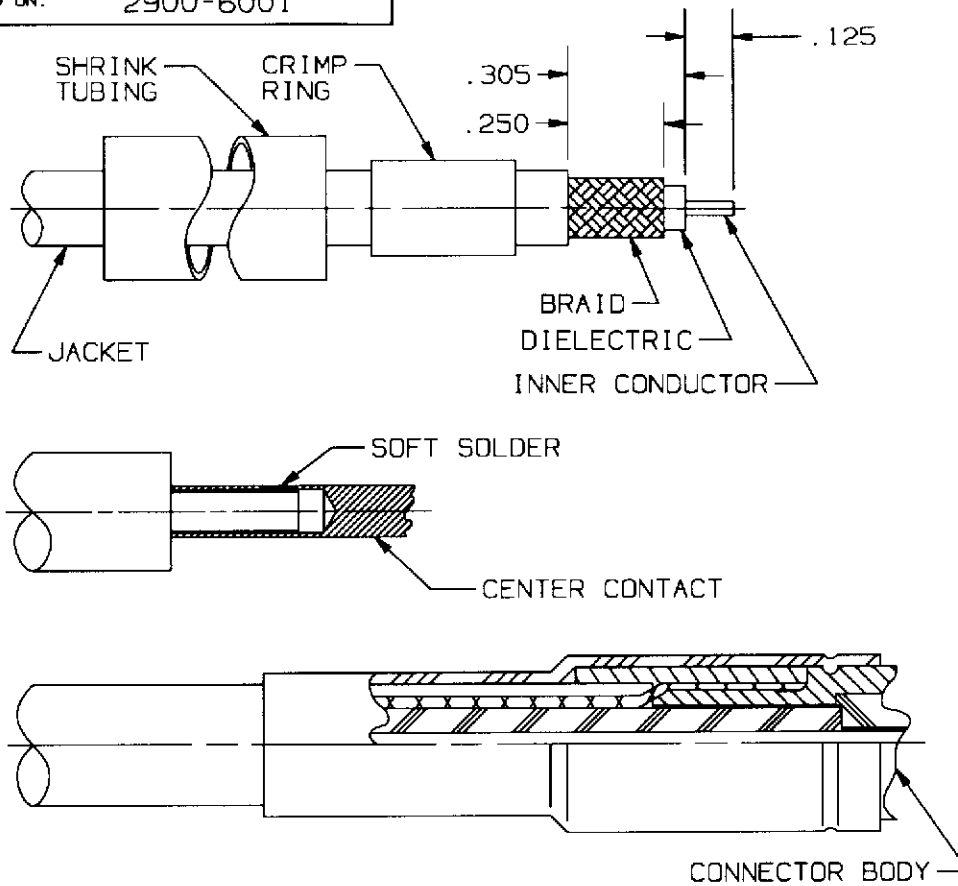
USED ON: 2900-6001

CAD
GENERATED
DRAWING

DCN
CONTROLLED
DOCUMENT

DWG. NO.

300-80-826



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
55, 58, 141, 142, 223, 303 & 400	M22520/10-07	.213
174, 179, 187, 188 & 316	M22520/10-05	.128
180 & 195	M22520/10-06	.160
178 & 196	M22520/10-05	.105

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 / 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			SOLITRON VECTOR MICROWAVE 3301 ELECTRONICS WAY WEST PALM BEACH, FL. 33407
					DECIMALS	FRACTIONAL	ANGULAR	
-	REL. NRN 23243	3/97	JM		.X ±.030		X° ±1°0'	TITLE: CABLE ASSEMBLY INSTRUCTIONS (CRIMP)
A	REV. DCN 24633	8/98	JM		.XX ±.015	±1/64	X°X' ±15'	
				DRAWN: BRT 3/05/97	MATERIAL: N/A		□ AREA: N/A	DWG. NO. 300-80-826
				CHECKED: SW 3/11/97	FINISH: N/A			
				APPROVED: JM 3/15/97	SIZE: A	CAGE NO.: 95077	SCALE: 2X	