

LTR	REVISIONS		
	CHANGE - DESCRIPTION	DATE	APPD.
-	INITIAL RELEASE	9-13-96	JP

3195-444

TITLE

CONNECTOR ASSEMBLY PROCEDURE

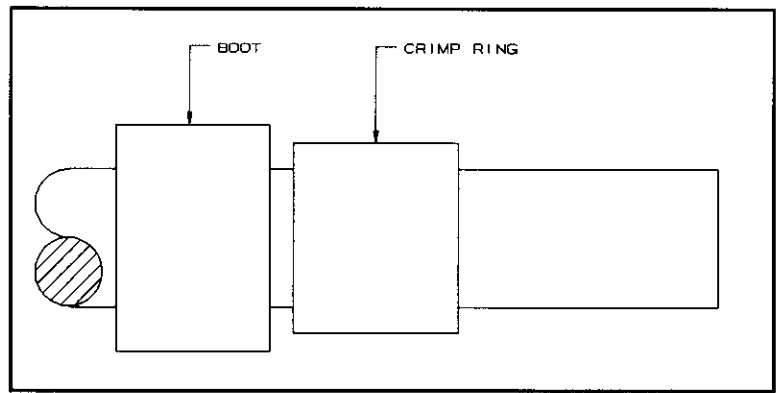
ENDORSEMENTS		DATE	TIMES MICROWAVE SYSTEMS, INC. CUSTOMER TERMINATION PROCEDURE FOR CONNECTOR P/N 3190-444	
WRITTEN:	J. PRETA	9-13-96		
APPROVED:	R. ALLARD	9-13-96		
TYPE: MINI-UHF		CABLE: LMR-200		CODE IDENT NO. 68999
				CAP: 3195-444
				SHEET 1 OF 3

STEP 1. Flush cut end of cable using a fine saw blade.

Note: Cut cable such that end remains round and face is perpendicular to cable.

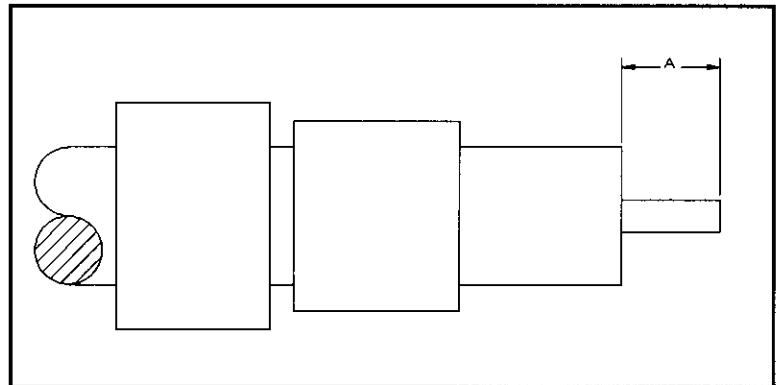
Slide on: Shrink Boot & Crimp Ring.

Connector Adds: 0.400" to length of assembly



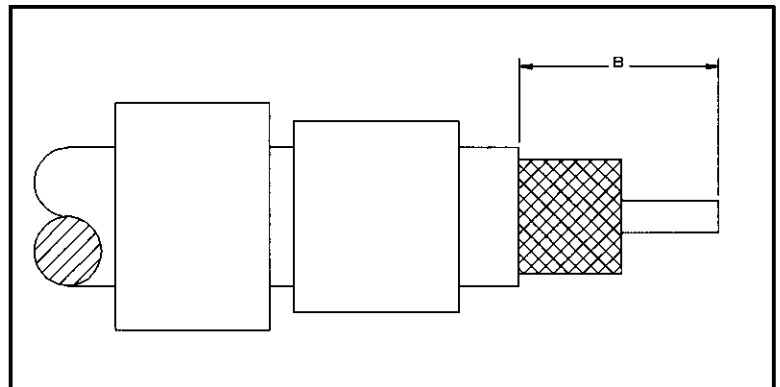
STEP 2. Expose conductor. $A = 0.150$ "

Note: Cut thru Jacket, Braids, and dielectric core. Do not nick cable conductor.

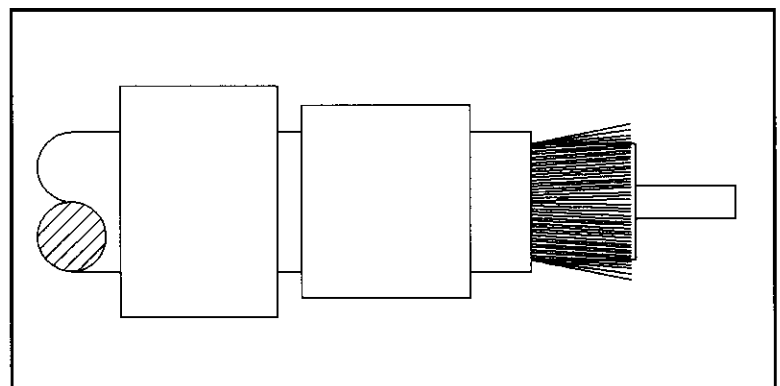


STEP 3. Expose outer braids. $B = 0.475$ "

Note: Do not nick the outer braids when removing cable jacket.

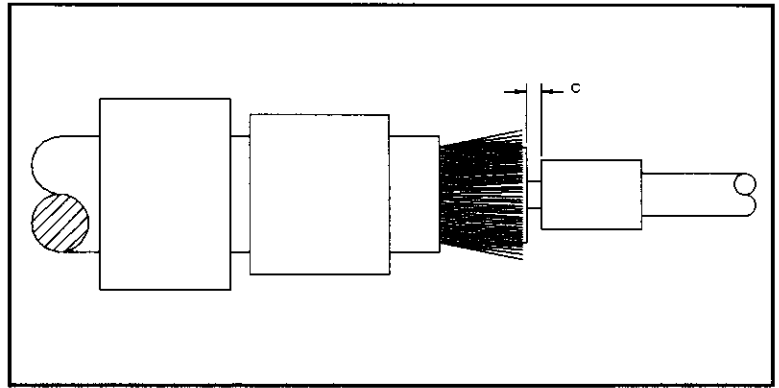


STEP 4. Flare out braids. Tin conductor 3/4 of its length. Chamfer end of conductor.



STEP 5. Install Contact. $C = 0.020$ "

Note: Solder on the connector Contact using 60/40 solder. For best results tin cable conductor prior to soldering on contact.

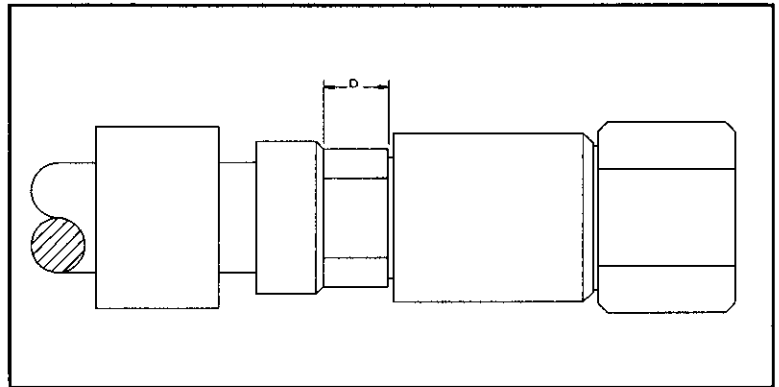


STEP 6. Install Connector Body.

Note: Slide connector Body until fully seated on contact. Slide Crimp Ring up against Connector Body.

Check Pin Height prior to crimp.

Crimp in place with 0.214" hex dies.
 $D = 0.300$ "



STEP 7. Install Strain Relief.

Note: Position Shrink Boot onto Connector Body. Apply hot air until boot is smoothly seated onto cable and connector.

