

LTR	REVISIONS		
	CHANGE - DESCRIPTION	DATE	APPD.
-	INITIAL RELEASE	1-24-96	JP

3190-354

TITLE

CONNECTOR ASSEMBLY PROCEDURE

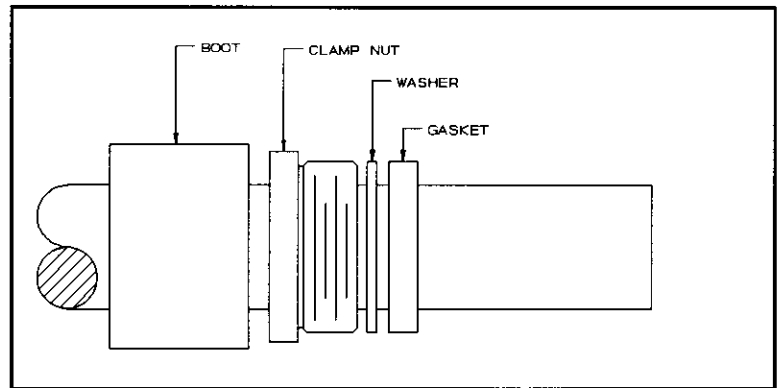
ENDORSEMENTS		DATE	TIMES MICROWAVE SYSTEMS, INC. CUSTOMER TERMINATION PROCEDURE FOR CONNECTOR P/N 3190-354	
WRITTEN:	J. PRETA	1-24-96		
APPROVED:	R. ALLARD	1-24-96		
TYPE: UHF-MALE		CABLE: LMR-500		CODE IDENT NO. 68999
				CAP: 3190-354
				SHEET 1 OF 3

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.

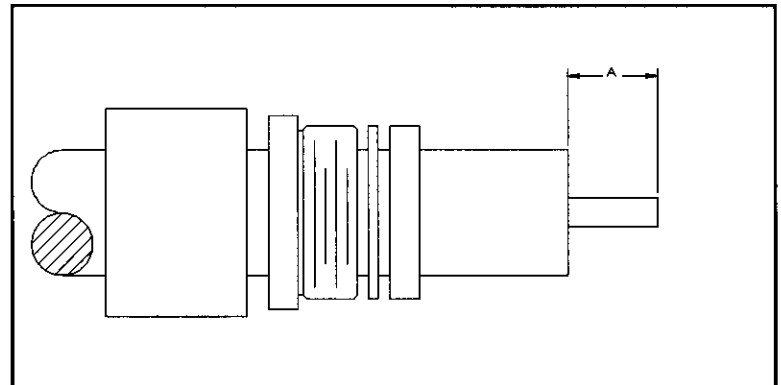
Slide on: Shrink Boot, Clamp nut, Washer, Gasket.

Connector Adds: 0.850" to length of assembly



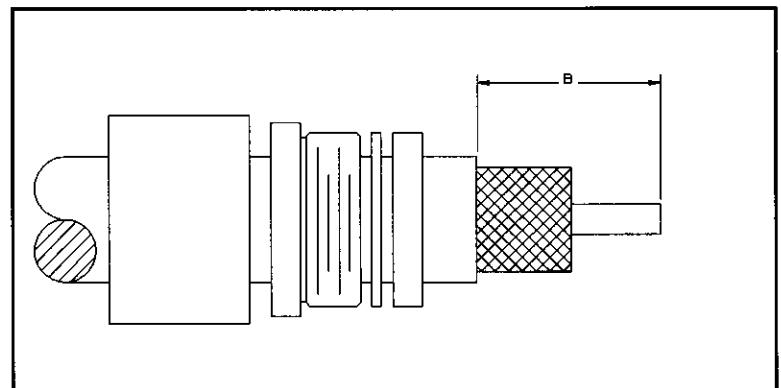
STEP 2. Expose conductor. $A = 0.300$ "

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

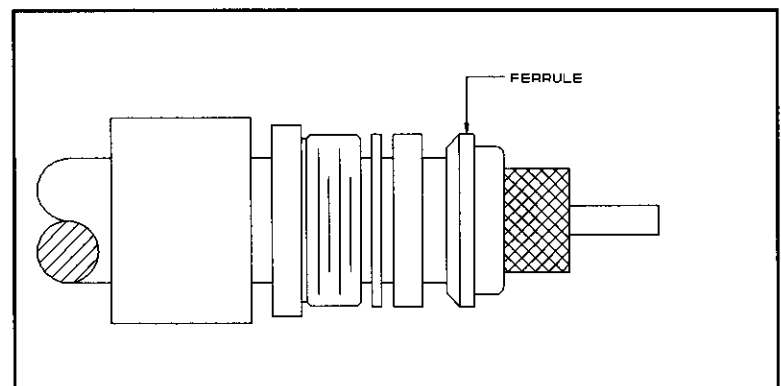


STEP 3. Expose outer braid. $B = 0.650$ "

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



STEP 4. Slide on Ferrule.

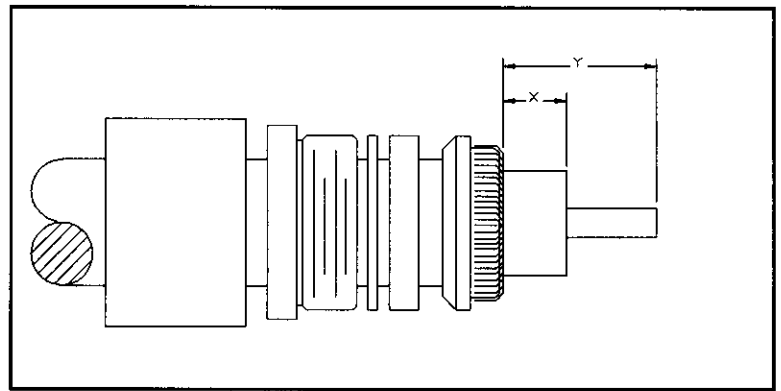


STEP 5. Flare out and straighten braids. Fold them back over the Ferrule.

Note: Trim dielectric core back to X dimension.
Trim cable conductor back to Y dimension.

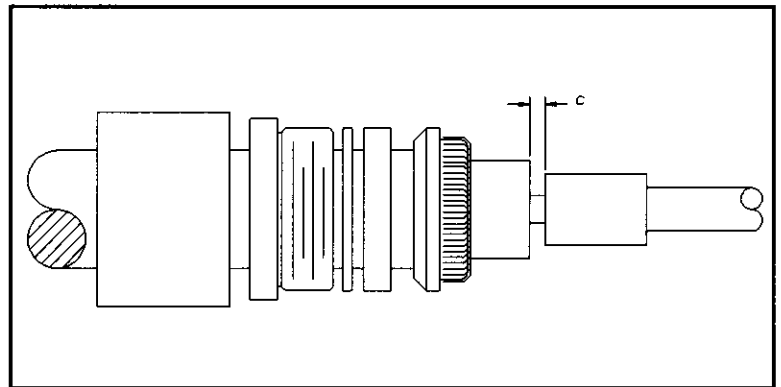
Check dimension: $X = 0.010" \pm 0.010"$

Check dimension: $Y = 0.420" \pm 0.020"$



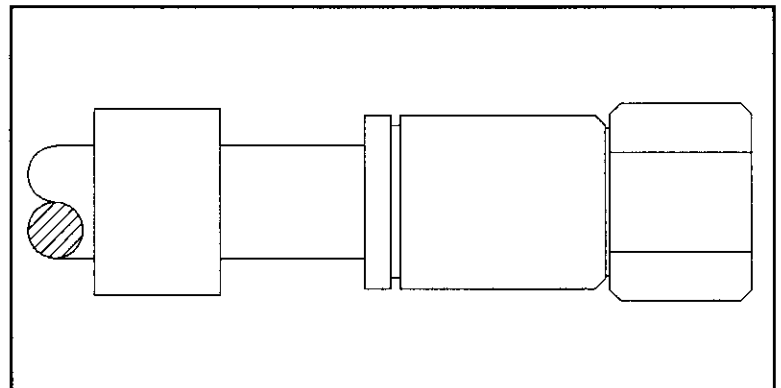
STEP 6. Install Contact. $C = 0.100"$

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



STEP 7. Install Connector Body.

Note: Slide connector Body until fully seated on contact. Slide Clamp Nut up into Connector Body. Apply **LOCTITE 242 (BLUE)** to threads. Thread and tighten to 50 in-lbs.



STEP 8. Install Strain Relief.

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

