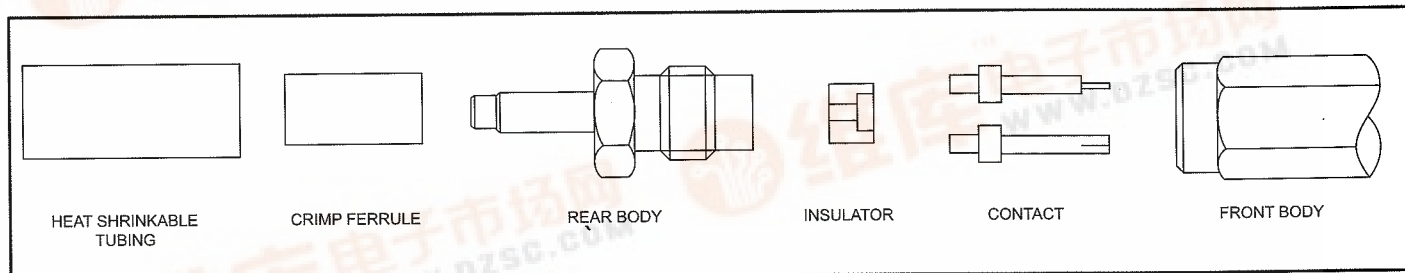
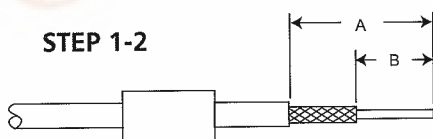


## ASSEMBLY INSTRUCTIONS

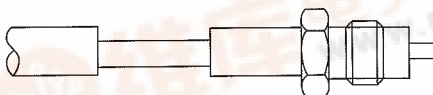
## AI-227 SMA Straight Connectors, Crimp Type for Braided Cable, Captive Contact



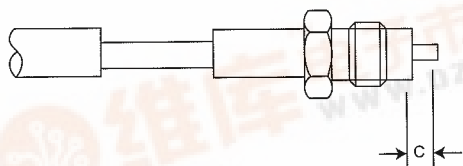
STEP 1-2



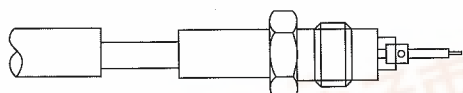
STEP 3



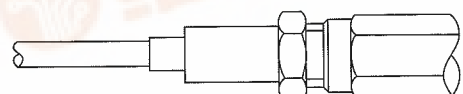
STEP 5



STEP 9



STEP 10



1. Slide ferrule and heat shrinkable tubing on to cable.

2. Trim cable to dimensions shown:

A	B	C
15,00 (.590)	9,00 (.354)	3,00 (.118)

3. Slide body over cable dielectric and under the braid until the braid is flush against the rear of the hexagonal nut. NOTE: When using cables with inflexible jackets, it is permissible to make two 3,17 (.125) longitudinal slits in the outer jacket.

4. Slide ferrule flush against the body and crimp in position using Cannon's Crimp Tool and suitable Die Set (see table).

5. Trim back dielectric and center conductor to dimensions shown.

6. Tin center conductor (DO NOT OVER TIN).

7. Assemble insulator over center conductor with counterbore in direction shown.

8. Place a small solder preform made from 0,26 - 0,31 (.010 - .012) dia.(28 swg) multi-core solder in rear of contact.

9. Assemble contact on center conductor, heat to make solder connection ensuring shoulder of contact is flush against rear insulator. Do not allow solder to protrude outside spill hole.

10. Insert crimped assembly into back end of body and tighten to a torque of 0.70 - 0.80 Nm (100-110 in. ozs.).

11. Slide heat shrinkable tubing over ferrule and apply heat until tubing shrinks down.

Cable Numbers	Cable Code	Die Size	Die Set
RG142/U	3196	2,67 (.105)	K29263
RG316/U	3188	3,25 (.128)	K29263
RD316	3875	3,84 (.151)	T1025/9