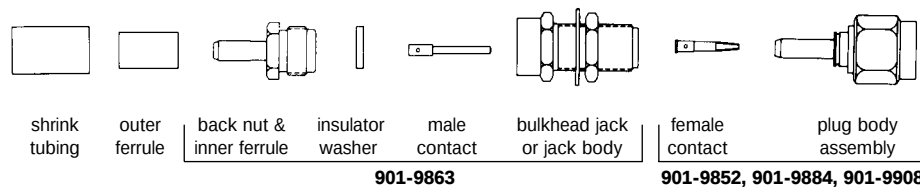


Assembly Instructions-C58

SMA-Reverse Polarity

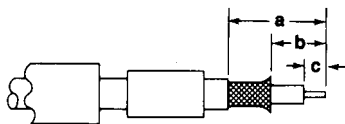
Amphenol®

BRAID CRIMP-SOLDER CENTER CONTACT TYPES FOR FLEXIBLE CABLE



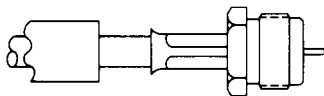
Amphenol Number	Connector Type	Cable RG-/U	Strip Dimensions, inches (mm)			Hex Cavity for Outer Ferrule	Die Set for Tool 227-944
			a	b	c		
901-9884	Plug	55, 142, 223, 400	.480 (12.2)	.250 (6.4)	.140 (3.6)	.213 (5.4)	227-1221-11 Cavity A
901-9852	Plug	174,179,187,188,316	.500 (12.7)	.260 (6.6)	.150 (3.8)	.128 (3.3)	227-1221-3 Cavity A
901-9863	Bulkhead Jack	174,179,187,188,316	.610 (15.5)	.340 (8.6)	.110 (2.8)	.128 (3.3)	227-1221-3 Cavity A
901-9908	Angle Plug	223	.475 (12.1)	.235 (6.0)	.120 (3.0)	.213 (5.4)	227-1221-11 Cavity A
901-9990	Bulkhead Jack	178, 196	.255 (6.5)	.105 (2.67)	.075 (1.8)	.105 (2.67)	227-1221-03 Cavity B

Step 1



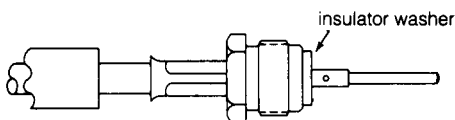
Step 1 Slide heat shrink tubing and outer ferrule onto cable. Strip cable jacket, braid and dielectric to dimensions shown in table above. All cuts are to be sharp and square. Do not nick braid, dielectric or center conductor when cutting. Tin center conductor. Avoid excessive heat to prevent swelling of cable dielectric. Flare end of cable braid slightly as shown to facilitate insertion of inner ferrule. Do not comb out braid.

For 901-9863 RP-Bulkhead Jack Step 2



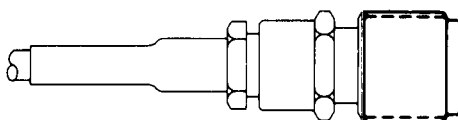
Step 2 Slide clamp nut over inner ferrule, and slide inner ferrule under braid until cable dielectric is flush with front of inner ferrule. Slide outer ferrule in place and crimp with die set shown in table above.

Step 3



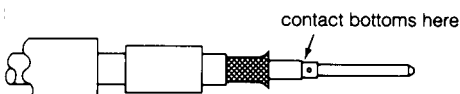
Step 3 Place insulator washer on cable center conductor and bottom against inner ferrule body as shown. Contact must butt firmly against insulator washer while soldering.

Step 4



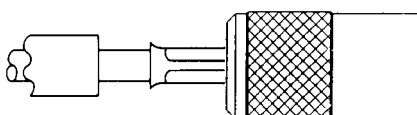
Step 4 Screw ferrule-contact assembly into body and tighten to 20-25 lbf.-in. torque. Slide heat shrink tubing over ferrule, up against clamp nut and shrink by applying heat.

For 901-9884, 901-9852, 901-9908 RP Plugs Step 2



Step 2 Solder center contact to cable center conductor as shown. Remove excess solder. Note: Contact must bottom against cable dielectric.

Step 3



Step 3 Install coupling nut and body assembly as shown. Place ferrule against body and crimp with die set shown in table above. Place heat shrink tubing over crimp ferrule, against body, and apply heat.