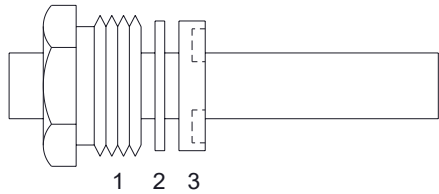
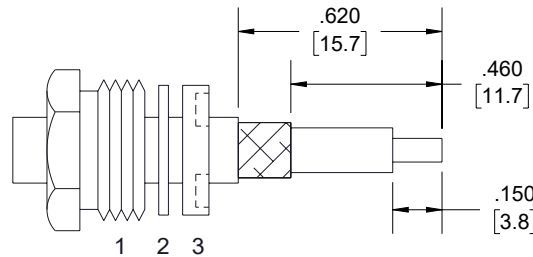


ASSEMBLY PROCEDURES

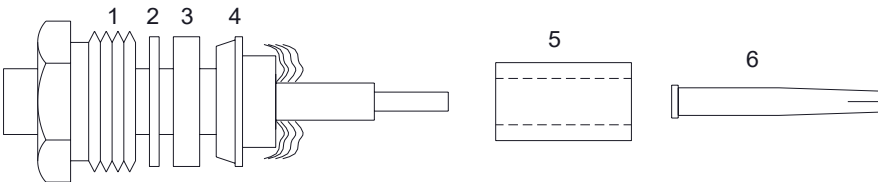
1. SLIDE CLAMP NUT (1), WASHER (2) & GASKET (3) OVER CABLE AS SHOWN.



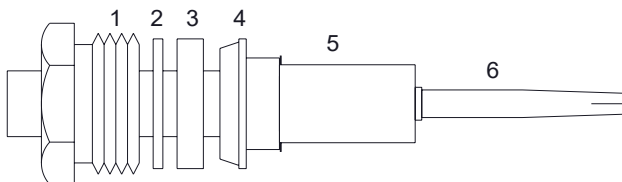
2. TRIM PER DIMENSIONS.



3. a) SLIDE BRAID CLAMP (4) OVER BRAID UNTIL IT STOPS ON CABLE JACKET.
b) FLAIR BRAID AS SHOWN.



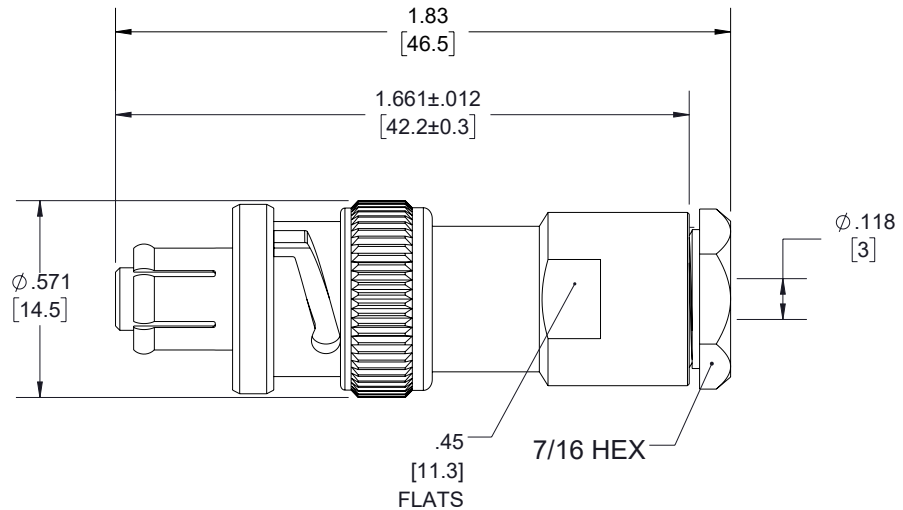
4. a) INSERT PTFE SLEEVE FLUSH AGAINST FLAIRED BRAID (5) BEFORE CONTACT (6). SLIDING OVER CENTER CONDUCTOR & CABLE DIELECTRIC. b) INSTALL CONTACT BY SOLDERING TO CABLE CENTER CONDUCTOR LEAVING NO GAPS.



5. REMOVE EXCESS SOLDER. INSERT ASSEMBLY INTO CONNECTOR BODY AND TIGHTEN NUT WITH RECOMMENDED TORQUE: 16 in-lbs.

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REVISION					
ZONE	REV	DESCRIPTION	DATE	CHANGED BY	APPROVED
	A	INITIAL RELEASE	07/26/2024	DMAY	AGANWANI



UNLESS OTHERWISE SPECIFIED LEADING DIMENSIONS ARE INCHES DIMENSIONS IN [] ARE MILLIMETERS

TOLERANCES:

X = ±.2 [5]	FRACTIONS ± 1/32
.XX = ±.02 [0.5]	ANGLES ± 1°
.XXX = ±.005 [0.13]	

CABLE LENGTH TOLERANCES:

≤12 [305]	= +1 [25] / -0
>12 [305] ≤ 60 [1524]	= +2 [51] / -0
>60 [1524] ≤ 120 [3048]	= +4 [102] / -0
>120 [3048] ≤ 300 [7620]	= +6 [152] / -0
>300 [7620]	= +5% / -0

ALL DIMENSIONS ARE FOR REFERENCE ONLY AND SUBJECT TO CHANGE WITHOUT NOTICE UN-DIMENSIONED/NON-CRITICAL FEATURES MAY VARY IN SIZE AND LOCATION COLORS MAY VARY

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INTERPRET ALL DIMENSIONS AND TOLERANCES PER ASME Y14.5

SCALE	SHEET
NONE	1 OF 1

DESCRIPTION

SHV PLUG CONNECTOR CLAMP/SOLDER ATTACHMENT FOR RG174, RG316, RG188, LMR-100, .100 INCH

SIZE	CAGE CODE	DRAWN BY	ITEM NO.	REV
A	3FKR5	DMAY	FMCN5247	A