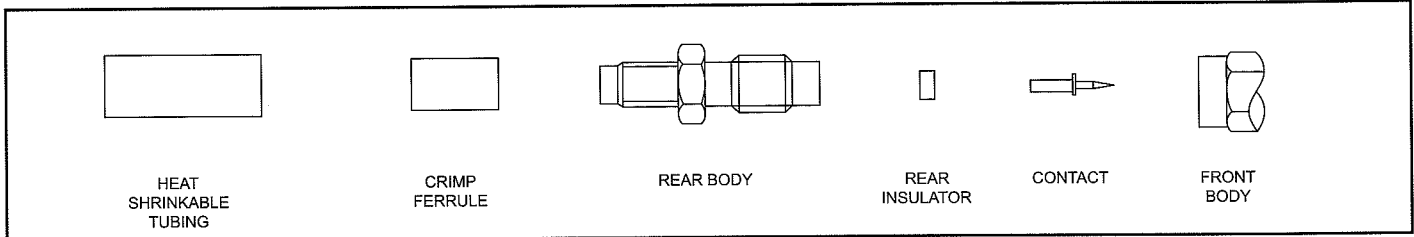


ASSEMBLY INSTRUCTIONS

AI-128 & AI-663

SSMB / SSMC Straight Connectors, Crimp Type for Braided Cable

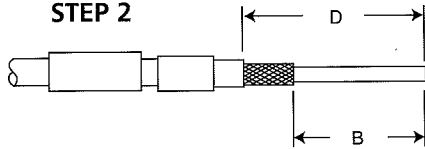


STEP 1



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

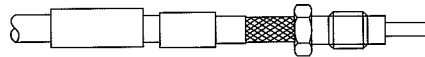
STEP 2



2. Trim cable to dimensions shown:

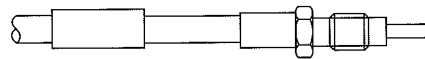
Assembly Instruction No.	B	C	D
AI-663	6,86 (.270)	2,29 (.090)	10,41 (.410)
AI-128 for center conductors \varnothing 0.51 (.020)	6,76 (.266)	2,29 (.090)	9,53 (.375)
AI-128 for all other conductor sizes	7,54 (.297)	3,05 (.120)	10,31 (.406)

STEP 3



3. Slide rear body over dielectric and under the braid until braid is flush with flange. N.B. When using cable with inflexible jackets it is permissible to make two 3,00 (.118) long longitudinal slits in the outer jacket.

STEP 4



4. Slide ferrule over exposed braid up to hex. flange.

STEP 7

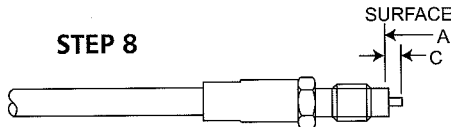


5. Crimp using Cannon's Crimp Tool and suitable Die Set (see table). Ensure ferrule is held close to hex. flange.

6. Slide heat shrinkable tubing over crimp and heat shrink into place using hot air gun. Air temperature should be approximately 125°C.

7. Trim dielectric flush with surface "A" on body using a sharp knife. Take care not to nick center conductor.

STEP 8

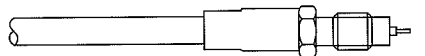


8. Trim center conductor as shown.

9. Tin center conductor (do not allow solder to touch end of body or dielectric).

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

STEP 12



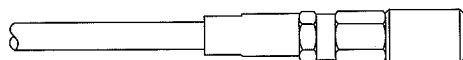
11. Place rear insulator over center conductor. When insulator has counterbore, the contact fits into the counterbore.

12. Assemble contact onto center conductor, heat to make solder connection. Do not allow solder to protrude outside spill hole.

13. Solder should be visible at inspection hole, if excess solder runs from inspection hole, remove with sharp blade taking care not to damage plating.

14. Screw on the front body and tighten to a torque of 0.14Nm (20 in. ozs)

STEP 14



Only common cable retention features are shown in detail. Various body configurations can apply.

Cable Numbers	Cable Code	Die Size	Die Set
RG196/U	3196	2,67 (.105)	K29263
RG316/U	3188	3,25 (.128)	K29263
RD316	3875	3,84 (.151)	T1025/9

Dimensions are shown: mm (inch)
Specifications and dimensions subject to change