

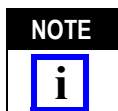
Note: All Components Must Be Ordered Separately

COMPONENT		CABLE TYPE AND SIZE				
DESCRIPTION	PART NUMBER	Solid Wire RG/U				Stranded Wire 1.5CS-QEHV (TA)
		62	62 Modified	71	71 Modified	
Spacer	1274233-1	—	✓	—	✓	—
	1274233-2	✓	—	✓	—	—
Jack Body	1274236-1	✓	✓	✓	✓	—
	1326947-1	✓	✓	✓	✓	—
	1326948-1	—	—	—	—	✓
	1488798-1	—	—	—	—	✓
Jack (Male) Contact	1274239-2	✓	—	✓	—	—
	1274239-4	—	✓	—	✓	✓
	1438808-2	✓	—	✓	—	—
	1438808-4	—	✓	—	✓	✓
Right-Angle Ferrule	1326510-1	✓	✓	—	—	—
	1326510-3	—	—	✓	✓	—
Straight Ferrule	1326646-1	✓	✓	—	—	—
	1488922-2	—	—	✓	✓	—
	1-413889-3	—	—	—	—	✓

Figure 1

1. INTRODUCTION

Coaxial snap-lock cable jack connectors are designed to be crimped onto the cable type and size given in Figure 1 using the tooling listed in Figure 2.



Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Read these instructions carefully before assembling the connectors.

For detailed application requirements, refer to Application Specification 114-13125.

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION

Each connector consists of a jack body, spacer, jack (male) contact, and straight or right-angle ferrule. See Figure 1.

WIRE SIZE	CRIMP TOOLING FOR CONTACT (Instruction Sheet)	
	HAND TOOL (408-8547)	APPLICATOR (408-8040)
62, 71 RG/U	1752690-1	680900-1 or 1385623-3
62, 71 RG/U Modified		680901-1 or 1385624-3
1.5 CS-QEHV (TA)	—	1385674-3

Figure 2

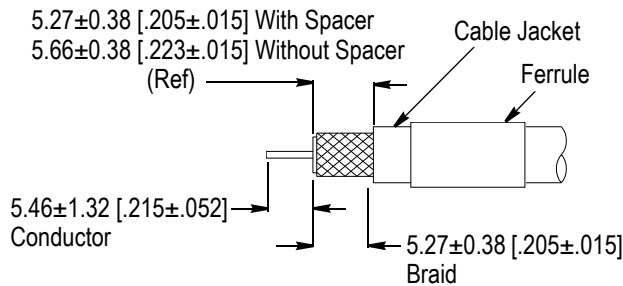
WIRE SIZE	DIE ASSEMBLY FOR FERRULE (Instruction Sheet)
RG-62/U, RG-62/U Modified	1338120-1● (408-8589)
1.5 CS-QEHV (TA)	58483-1■ (408-9830)
RG-71/U, RG-71/U Modified	NA

●Creates "O" crimp. ■Creates hex crimp.

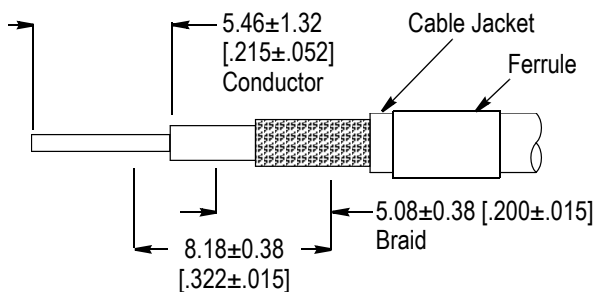
3. ASSEMBLY PROCEDURE

- Slide the ferrule onto the unstripped cable.
- Strip the cable using the dimensions provided in Figure 3. DO NOT nick or cut the cable braid or center conductor. The center conductor must be straight and free of burrs.

Recommended Stripping Dimensions For RG/U Cable



Recommended Stripping Dimensions For 1.5CS-QEHV (TA) Cable



Note: Not to Scale

Figure 3

- Slide the spacer (if required) over the cable center conductor until it bottoms against the cable dielectric. See Figure 4. No spacer is required if using 1.5CS-QEHV (TA) cable.
- Crimp the contact onto the cable center conductor using the tooling listed in Figure 2. Refer to the referenced instruction sheet for information on using the tooling.

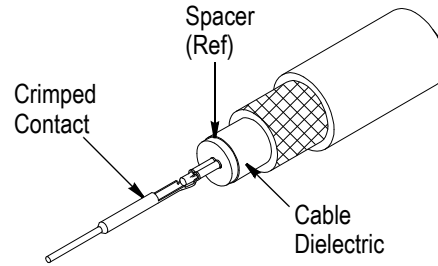
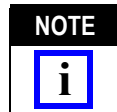


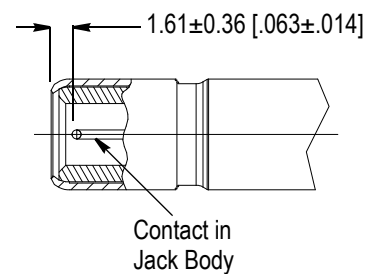
Figure 4



During crimping, make sure that the spacer (if used) remains against the cable dielectric and the end of the contact wire barrel is no more than 0.38 [.015] from the spacer or, if spacer is not used, from the cable dielectric.

- Flare, but do not deform, the cable braid, and insert the contact into the jack body until the contact is located within the dimension provided in Figure 5, Detail A. Make sure that the cable braid is positioned over the support sleeve of the jack body. See Figure 5, Detail B.

Detail A



Detail B

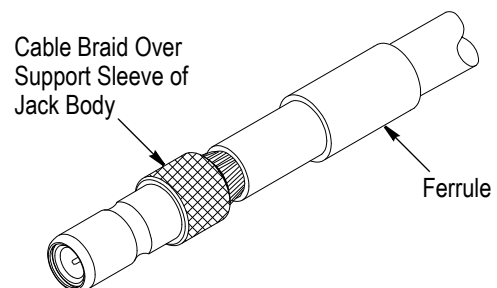


Figure 5

6. Slide the ferrule over the cable braid and support sleeve of the jack body until it is positioned against the shoulder of the jack body. Be careful not to move the crimped center contact and cable out of position while sliding the ferrule into position. See Figure 6.

7. Crimp the ferrule using the tooling listed in Figure 2. Refer to the referenced instruction sheet for information on using the tooling. See Figure 6.

8. Inspect the ferrule crimp according to 114-13125.

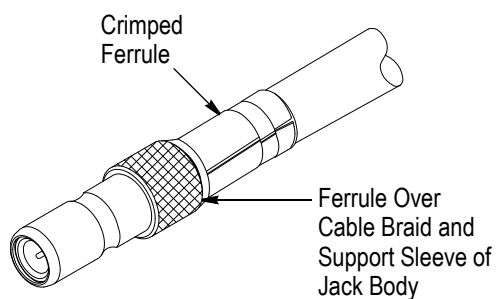


Figure 6

4. REPLACEMENT AND REPAIR

DO NOT use defective or damaged components. DO NOT re-use a crimped contact or ferrule by removing the cable.

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Removed non-orderable part numbers from Section 1
- Added ferrule to Figure 3
- Added Section 4