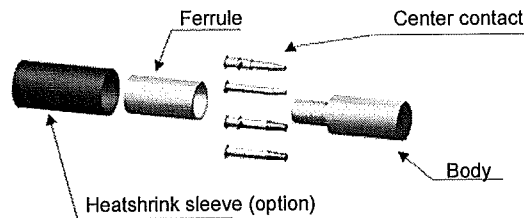


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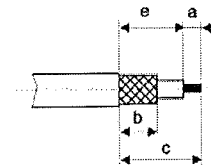
SMB

ASSEMBLY INSTRUCTIONS

M 10

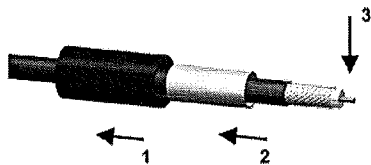


STRIPPING DIMENSIONS

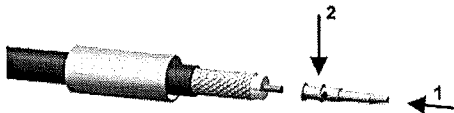


Part number	Stripping length (mm)				Hex.	Ferrule crimp tool		Center contact crimp tool
	a	b	c	e		Dies included	MIL standard R282 293 000 (M22520/5-01) + positioner	MIL standard R282 281 000 (M22520/2-01) + positioner
R114 081 020	2.5	2.5	6					
R114 082 000 R114 238 000		3.1	5.4		3.25	R282 211 000	R282 235 003 (M22520/5-03)	R282 983 000 (position 3) for 50 Ω cables (position 1) for 75 Ω cables
R114 082 020 R114 238 120								
R114 083 000 R114 313 000								
R114 083 020								
R114 313 020	3	4.5						
R117 083 807	3.6	5.4		3.85	R282 271 000	R282 235 037 (M22520/5-37)		
R117 082 807	5.4	11.5	9	3.25	R282 211 000	R282 235 003 (M22520/5-03)	R282 983 000	
R117 086 827 R117 087 827	3	7	11	8	5.41	R282 223 000	R282 235 011 (M22520/5-11)	

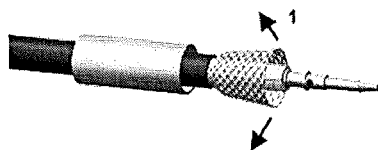
- 1
- Slide the heatshrink sleeve onto the cable (option).
 - Slide the ferrule onto the cable.
 - Strip the cable.



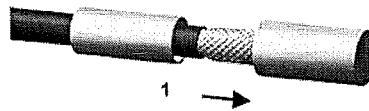
- 2
- Slide the centre contact on until it bottoms against the cable dielectric.
 - For connectors R117 086 827 and R117 087 827 Solder the centre contact.
 - For connectors R117 082 807 Crimp the centre contact with crimping tool.
 - Clean solder area.



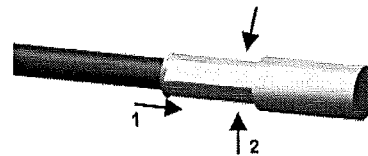
- 3
- Fan the braid.



- 4
- Slide the cable into the body until it bottoms against the insulator.



- 5
- Slide the ferrule over the braid.
 - Crimp the ferrule with crimping tool.



- 6
- Cut the excess of braid if necessary.
 - Slide the sleeve over the ferrule and heatshrink it in place (option).

