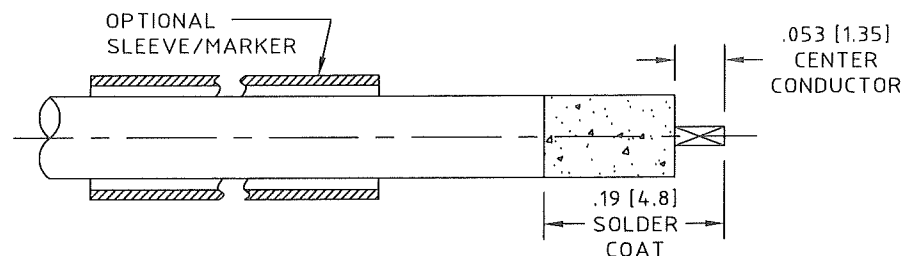


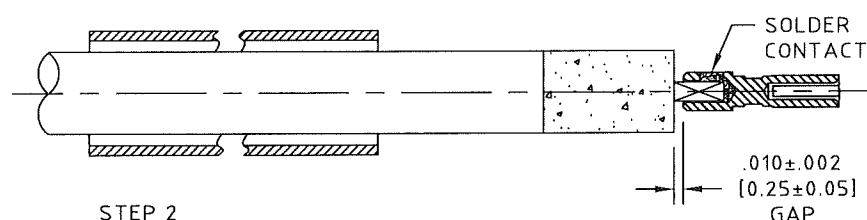
STEP 1

1. IDENTIFY THE COMPONENTS OF THE CONNECTOR.
2. CUT CABLE LENGTH.
3. IDENTIFY END OF CABLE RECEIVING CONNECTOR 21_SMP-50-2-1.
4. PASS OPTIONAL SLEEVES/MARKERS ONTO CABLE.

.086 SEMI-RIGID (REF: RG405)



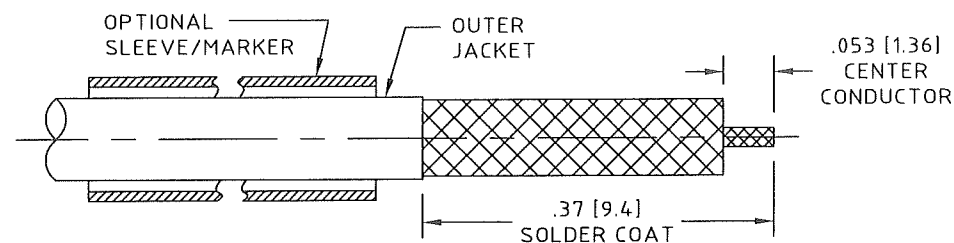
TRIM CABLE AND SOLDER COAT AS SHOWN



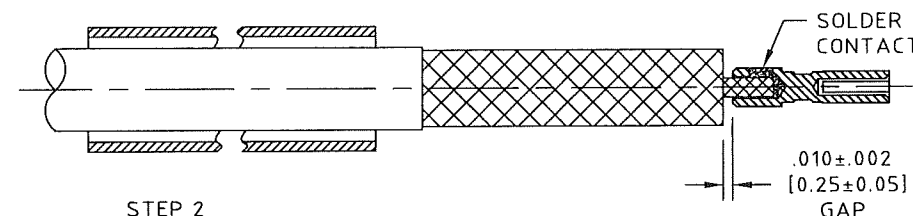
STEP 2

1. INSTALL CONTACT ONTO CABLE CENTER CONDUCTOR AND SOLDER WITH GAP SHOWN.

MULTIFLEX_86



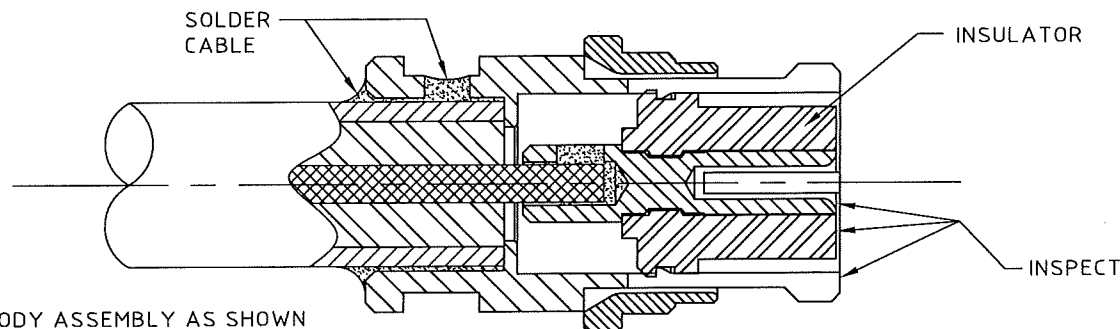
TRIM CABLE AND SOLDER COAT AS SHOWN



STEP 2

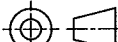
1. INSTALL CONTACT ONTO CABLE CENTER CONDUCTOR AND SOLDER WITH GAP SHOWN.

SCALE: 10:1



STEP 3

1. INSERT CABLE/CONTACT INTO BODY ASSEMBLY AS SHOWN AND VERIFY THAT CONTACT ENTERS INSULATOR HOLE.
2. PUSH CABLE/CONTACT UNTIL CABLE OUTER CONDUCTOR BOTTOMS OUT.
3. INSPECT SMP FEMALE INTERFACE.
4. SOLDER CABLE AND BODY AS SHOWN. VERIFY A CLEAN SOLDER JOINT WITHOUT ANY SPATTER ON CONNECTOR OUTER DIAMETER.
5. INSPECT SMP FEMALE INTERFACE.
6. ELECTRICAL TEST.
7. HEAT SHRINK SLEEVE/MARKER IN PLACE.

USED ON		NAME	DATE		 HUBER+SUHRNER Astrolab	THIS DRAWING CONTAINS PATENTABLE AND PROPRIETARY INFORMATION. THE DESIGN CANNOT BE USED WITHOUT WRITTEN PERMISSION OF HUBER + SUHRNER ASTROLAB.	
UNLESS OTHERWISE SPECIFIED CONCENTRICITY .004 T.I.R. CORNERS AND FILLETS .005 MAX. RADIUS OR CHAMFER. SURFACE FINISH 63 RMS MICROINCHES OR BETTER.		PREP. GS	08/04/15				SCALE
		MECH. GSG	08/06/15	5:1			
		Q.C.		ANSI A			
		TITLE					
X	±.015 [±0.381]	CONNECTOR, SMP FEMALE TO H+S ASTROLAB 38000 & .086 DIA. S/R CABLE					
XX	±.010 [±0.254]						
XXX	±.005 [±0.127]						
XXXX	±.0005 [±0.013]						
ANGLES	± 1°	THDS. TO BE IN ACCORD WITH U.S. DEPT. OF COMM. SCREW THD. STDS. FOR FEDERAL SERVICES 1950 SUPL. TO HANDBOOK H 28.		CODE IDENT.	DWG NO.	REV.	SHEET
DO NOT SCALE DRAWING				16301	21 SMP-50-2-1	E	1/1