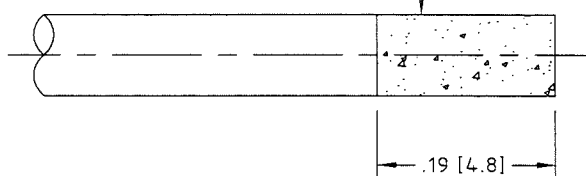
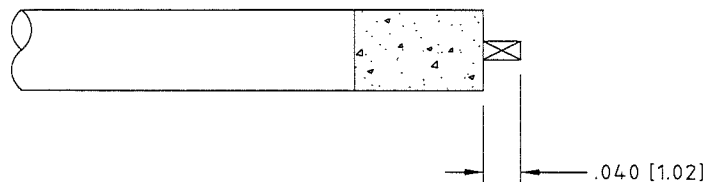


SOLDER COAT
OUTER COND.

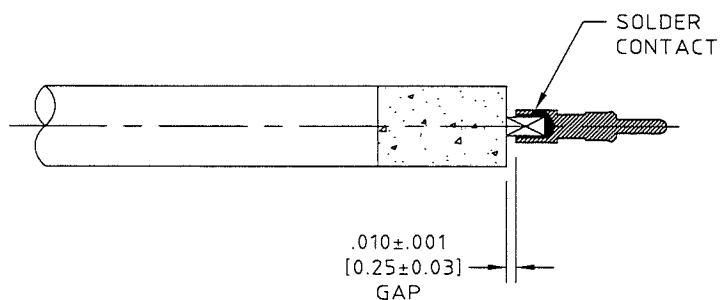
STEP 1

1. IDENTIFY THE COMPONENTS OF THE CONNECTOR.
2. CUT CABLE LENGTH.
3. IDENTIFY END OF CABLE RECEIVING CONNECTOR 29474-x-086CH.
4. SOLDER COAT CABLE END TO DIMENSION SHOWN.



STEP 2

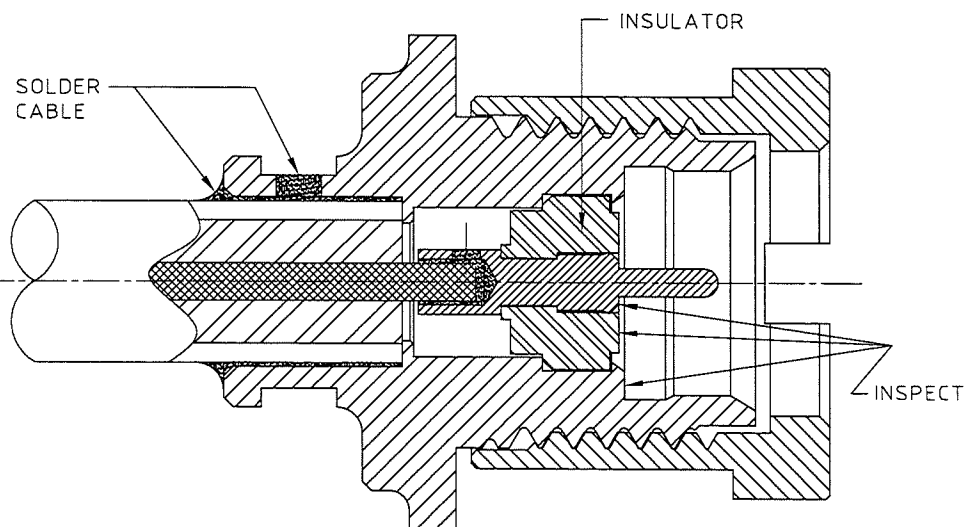
1. TRIM CABLE END AS SHOWN.



STEP 3

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

METRIC TOLERANCE			
DIMENSION		TOLERANCE	
INCHES	MM	INCHES	MM
.X	[X.]	±.015	[±0.5]
.XX	[X.X]	±.010	[±0.3]
.XXX	[X.XX]	±.002	[±0.05]
.XXXX	[X.XXX]	±.0005	[±0.013]



SCALE: 10:1

STEP 4

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 MALE INTERFACE.
6. ELECTRICAL TEST.

USED ON		NAME	DATE			
		PREP. SO	09/04/15			
UNLESS OTHERWISE SPECIFIED CONCENTRICITY .004 T.I.R. CORNERS AND FILLETS .005 MAX. RADIUS OR CHAMFER. SURFACE FINISH 63 RMS MICROINCHES OR BETTER.		ELEC.				
		MECH. GSG	09/30/15			
		Q.C.				
FRACTIONS	± 1/32	TITLE				
X	± .015	CONNECTOR, SMP MALE TO H+S ASTROLAB 38000 & .086 DIA. S/R CABLE				
XX	± .010					
XXX	± .005					
ANGLES	± 1°					
DO NOT SCALE DRAWING		THDS. TO BE IN ACCORD WITH U.S. DEPT. OF COMM. SCREW THD. STDS. FOR FEDERAL SERVICES 1950 SUPPL. TO HANDBOOK H 28.	SCALE 5:1	CODE IDENT. 16301	DWG NO. 14 SMP-50-2-x2	REV B

B	ECN No. 18011	03/29/16	SO	
REV.	DESCRIPTION	DATE	BY	APPROVED