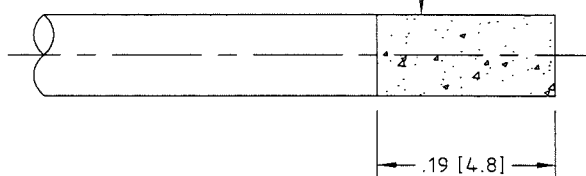
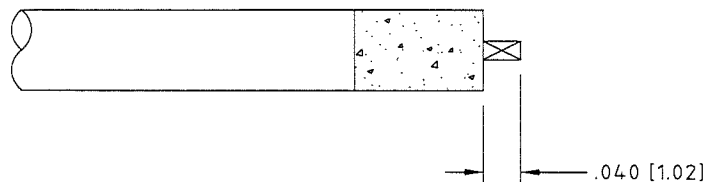


SOLDER COAT
OUTER COND.

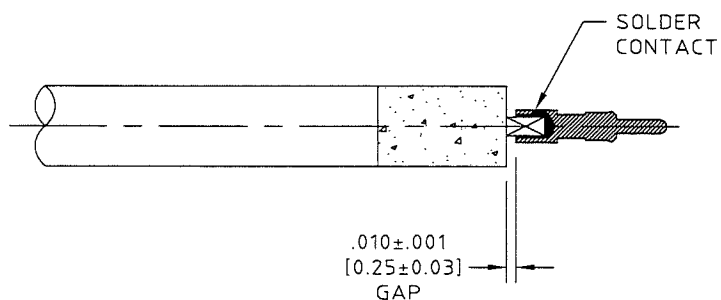
STEP 1

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

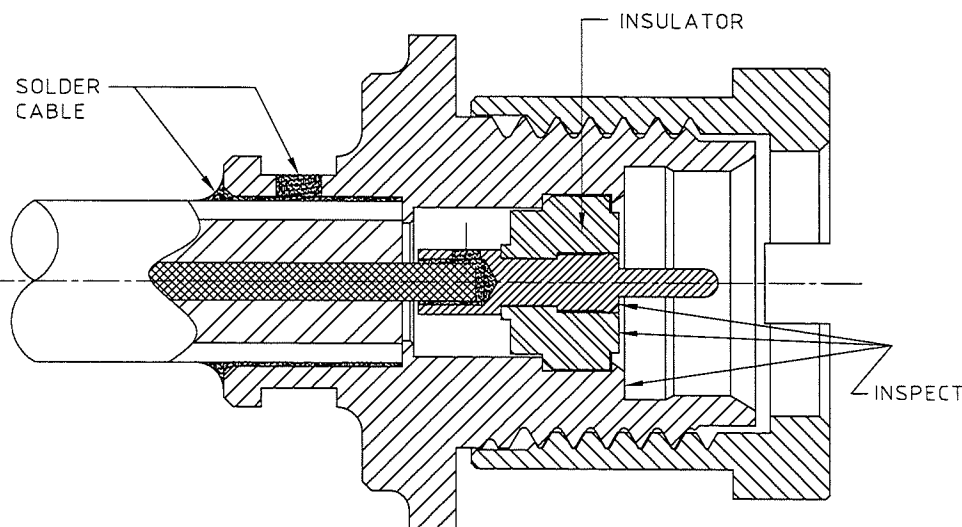
1. TRIM CABLE END AS SHOWN.



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			
	ELEC.				
	MECH. GSG	09/30/15			
	Q.C.		THIS DRAWING CONTAINS PATENTABLE AND PROPRIETARY INFORMATION. THE DESIGN CANNOT BE USED WITHOUT WRITTEN PERMISSION OF HUBER + SUHNER ASTROLAB.		
FRACTIONS	± 1/32	TITLE	CONNECTOR, SMP MALE TO H+S ASTROLAB 38000 & .086 DIA. S/R CABLE		
X	± .015				
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	CODE IDENT.	DWG NO.
			5:1	16301	14_SMP-50-2-x2

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