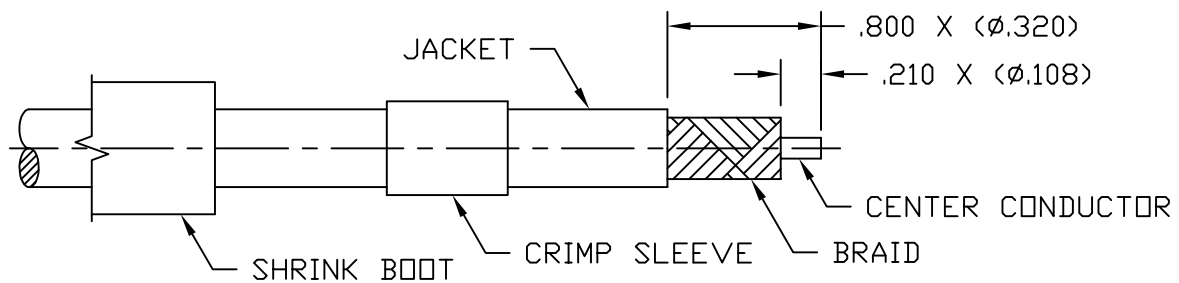


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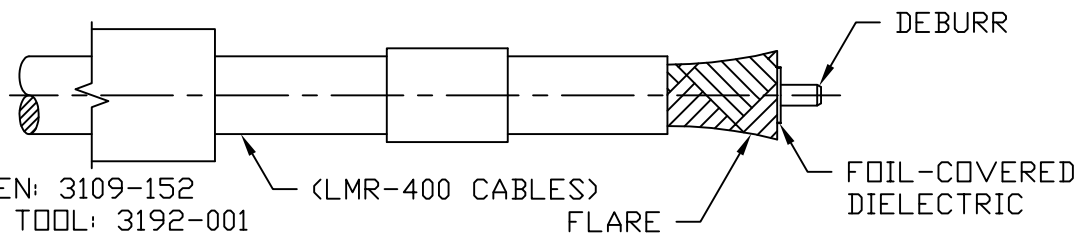
| SYM | REVISION DESCRIPTION    | DFTM     | DATE     | APPD     | DATE    |
|-----|-------------------------|----------|----------|----------|---------|
| A   | RELEASED FOR PRODUCTION | D. J. H. | 10/24/11 | E. J. P. | 11/4/11 |
| B   | CHANGED PER CDC #51078  | D. J. H. | 3/4/19   | D. A. R. | 3/7/19  |

USE FOR LMR-400 & TCOM-400 CABLES.  
NOTE THAT EACH CONNECTOR ADDS .776" TO CABLE LENGTH.

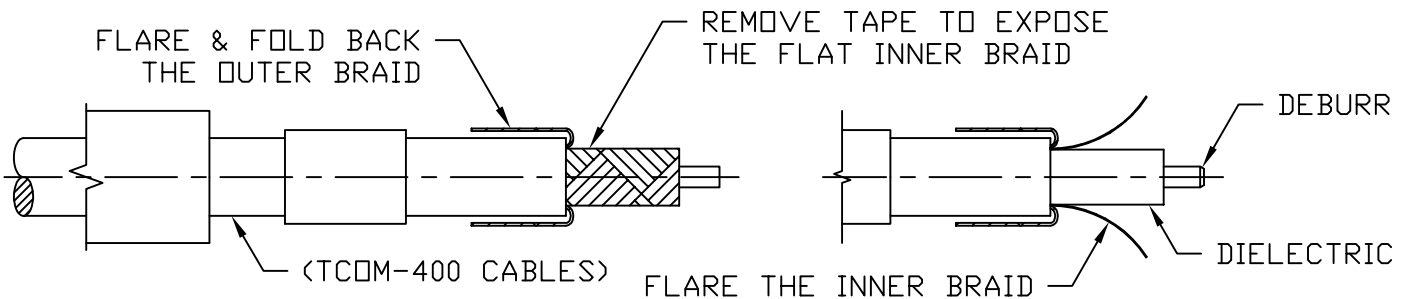
1. FLUSH CUT END OF CABLE USING A FINE SAW BLADE. CUT CABLE SO THAT END REMAINS ROUND AND FACE OF CABLE IS PERPENDICULAR TO ITS LENGTH. SLIDE ON SHRINK BOOT AND CRIMP SLEEVE. TRIM JACKET, BRAID AND DIELECTRIC BACK .210" TO EXPOSE CENTER CONDUCTOR. DO NOT NICK CENTER CONDUCTOR. TRIM JACKET BACK .800" TO EXPOSE BRAID. DO NOT NICK BRAID. CABLE STRIP TOOL 3192-004 CAN BE USED.



2. FOR LMR-400 CABLES: FLARE OUT BRAID AWAY FROM FOIL BACK TO JACKET. DIP SOLDER THE CENTER CONDUCTOR IN 60/40 SOLDER PER SI345. DEBURR CENTER CONDUCTOR USING TOOL, 3192-001. CLEAN PER SI313.

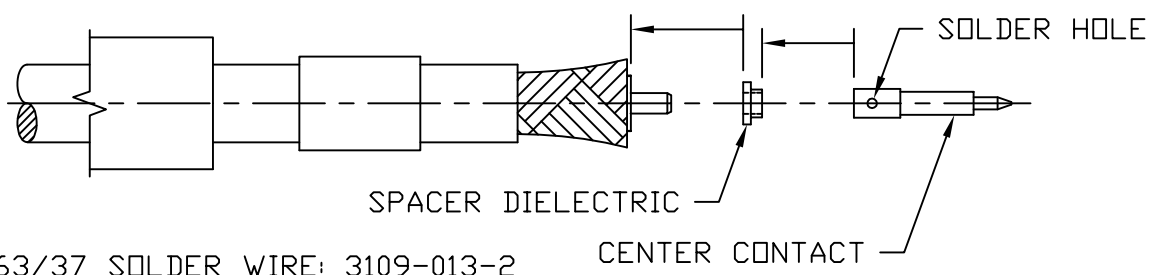


2. FOR TCOM-400 (55015) CABLES: FLARE OUTER BRAID BACK TO AND OVER JACKET. REMOVE EXPOSED TAPE BETWEEN BRAIDS. FLARE FLAT BRAID AWAY FROM DIELECTRIC. DIP SOLDER THE CENTER CONDUCTOR IN 60/40 SOLDER PER SI345. DEBURR CENTER CONDUCTOR USING TOOL, 3192-001. CLEAN PER SI313.



|                         |                  |  |                  |                   |  |               |              |          |
|-------------------------|------------------|--|------------------|-------------------|--|---------------|--------------|----------|
| TIMES MICROWAVE SYSTEMS |                  | DIMENSION TOLERANCES (INCHES)<br>UNLESS OTHERWISE SPECIFIED<br>.XX ± .03 .XXX ± .015<br>FRACTIONS ± 1/16 |                  |                   | CONNECTOR ASSEMBLY PROCEDURE<br>"N" MALE FOR LMR-400 CABLE<br>SOLDER/CRIMP/NO BRAID TRIM |               |              |          |
| DFTM.<br>D. J. H.       | DATE<br>10/24/11 | CHKD.<br>J. D. B.  | DATE<br>10/28/11 | APPD.<br>E. J. P. | DATE<br>11/4/11  | SHT<br>1 of 2 | CAP3190-2626 | REV<br>B |

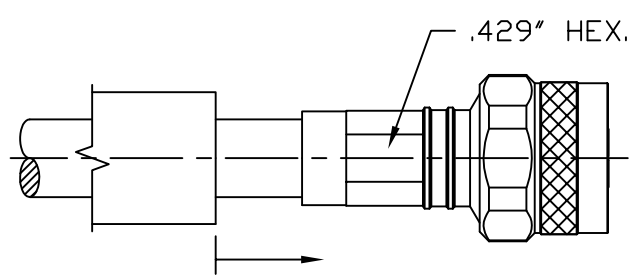
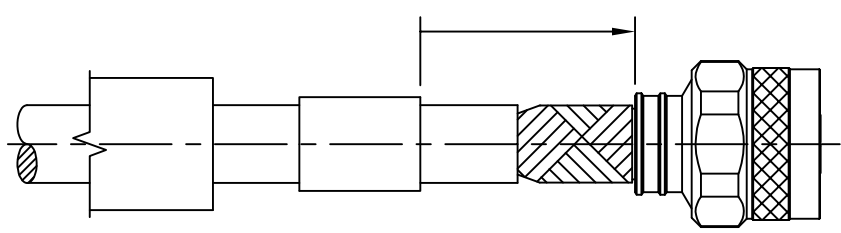
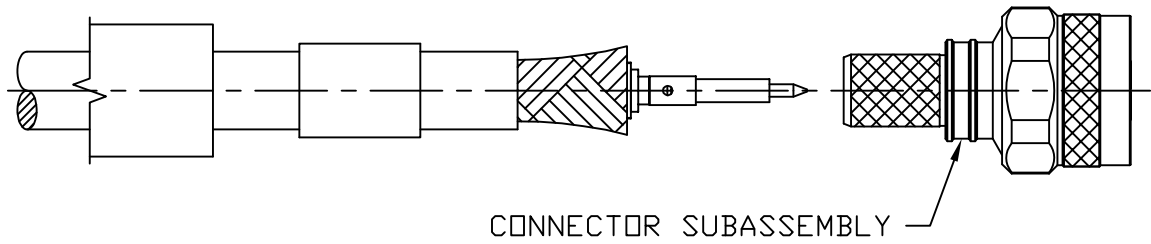
3. SLIDE SPACER DIELECTRIC, LARGER END FIRST, ONTO CABLE CENTER CONDUCTOR AND AGAINST CABLE DIELECTRIC. USING FLUX PEN, 3109-152, APPLY FLUX TO CENTER CONDUCTOR. INSTALL CENTER CONTACT ONTO CENTER CONDUCTOR AND AGAINST SPACER DIELECTRIC. SOLDER CONTACT IN POSITION BY FEEDING 63/37 SOLDER WIRE, 3109-013-2, THROUGH SOLDER HOLE. BE CAREFUL TO NOT DAMAGE CABLE DIELECTRIC. GIVE CONTACT A LIGHT PULL TO MAKE SURE IT HAS BEEN SOLDERED PROPERLY. REMOVE ANY EXCESS SOLDER. CLEAN PER SI313.



∅.025 63/37 SOLDER WIRE: 3109-013-2

4. INSTALL END OF CONNECTOR SUBASSEMBLY OVER CENTER CONTACT AND CABLE DIELECTRIC (REMINDER: LMR CABLE DIELECTRIC HAS FOIL BONDED TO IT), AND UNDER FLARED BRAID(S). MAKE SURE CENTER CONTACT SHOULDER IS SEATED FIRMLY AGAINST INTERFACE DIELECTRIC IN BODY. SLIDE CRIMP SLEEVE OVER BRAID(S) AND AGAINST CONNECTOR BODY SHOULDER. IF NECESSARY, TRIM AWAY EXCESS BRAID(S). CRIMP THE SLEEVE USING .429" HEX DIE, TN-2777-12 OR DANIELS Y1719.

LOCATE SHRINK BOOT PER MI AND SHRINK IN POSITION.



.429" HEX. CRIMP DIE: TN-2777-12 or DANIELS Y1719

DIMENSION TOLERANCES (INCHES) UNLESS OTHERWISE SPECIFIED .XX ± .03 .XXX ± .015 FRACTIONS ± 1/16