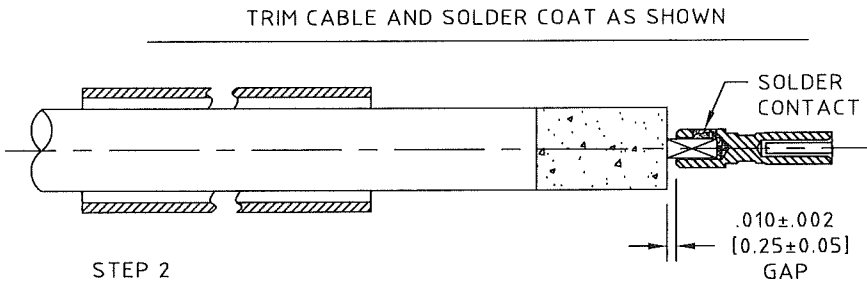
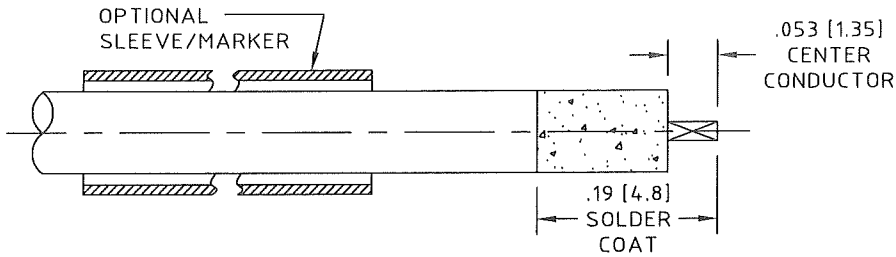


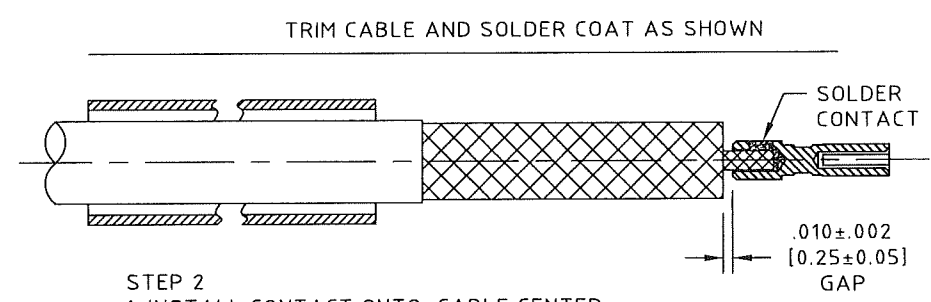
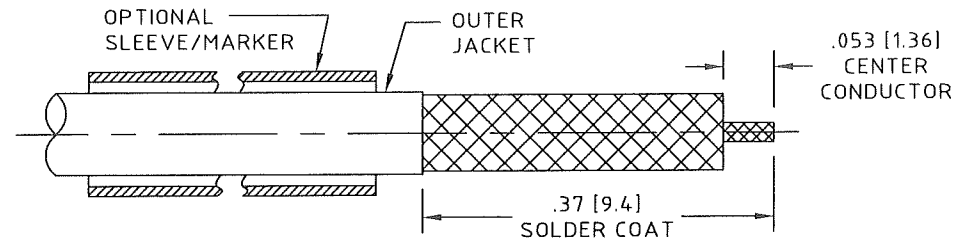
- STEP 1
1. IDENTIFY THE COMPONENTS OF THE CONNECTOR.
 2. CUT CABLE LENGTH.
 3. IDENTIFY END OF CABLE RECEIVING CONNECTOR 21_SMP-50-2-1.
 4. PASS OPTIONAL SLEEVES/MARKERS ONTO CABLE.

.086 SEMI-RIGID (REF: RG405)



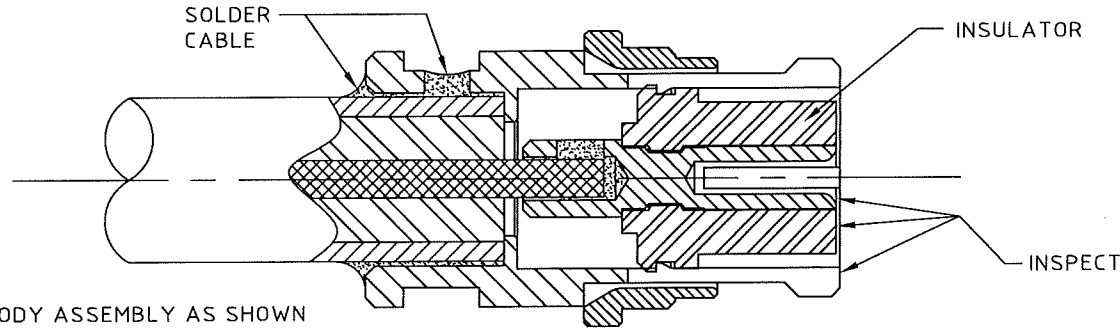
- STEP 2
1. INSTALL CONTACT ONTO CABLE CENTER CONDUCTOR AND SOLDER WITH GAP SHOWN.

MULTIFLEX_86

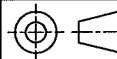



- STEP 2
1. INSTALL CONTACT ONTO CABLE CENTER CONDUCTOR AND SOLDER WITH GAP SHOWN.

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	
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	
X	±.015 [±0.381]	ELEC.		5:1
XX	±.010 [±0.254]	MECH. GSG	08/06/15	ANSI A
XXX	±.005 [±0.127]	Q.C.		
XXXX	±.0005 [±0.013]	TITLE		
ANGLES	± 1°	CONNECTOR, SMP FEMALE TO H+S ASTROLAB 38000 & .086 DIA. S/R CABLE		
DO NOT SCALE DRAWING		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. 16301



HUBER+SUHNER
Astrolab

THIS DRAWING CONTAINS PATENTABLE AND PROPRIETARY INFORMATION. THE DESIGN CANNOT BE USED WITHOUT WRITTEN PERMISSION OF HUBER + SUHNER ASTROLAB.

REV.	DESCRIPTION	DATE	BY	APPROVED	DWG NO.	REV.	SHEET
E	ECN No. 20650	10/24/18	GSG	MT	21_SMP-50-2-1	E	1/1

FileName: 21_SMP-50-2-1_A1.dwg REF. ONLY: DOC-00007508764 ; 29573-1(CH)