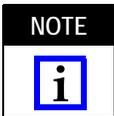


Figure 1

### 1. INTRODUCTION

FAKRA SMB 50-Ohm Inline Jack Kit 638831-[ ] (shown in Figure 1) is designed to be crimped onto flexible coaxial cable. Cable sizes and applicable tooling are listed in Figure 2. For detail procedures on using the tooling, refer to the instructions packaged with the hand tool.



*Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.*

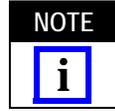
Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

### 2. DESCRIPTION

The jack kit consists of a housing, lock, subassembly, pin contact, and ferrule. The subassembly contains a press-fit dielectric.

When assembled, the lock secures the terminated subassembly to the housing. The housing features a locking tab used to ensure full mating. The jack assembly is available with or without keying ribs. Keying ribs are used for inadvertent mating of similar assemblies.

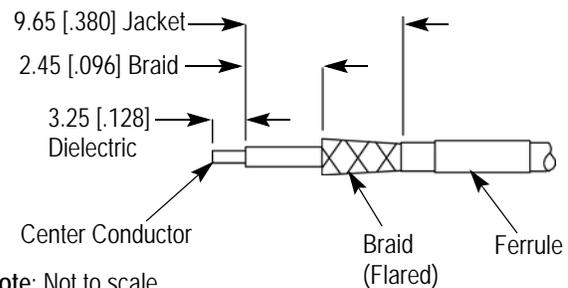
### 3. ASSEMBLY PROCEDURE



*For detailed application requirements, refer to Application Specification 114-13069.*

1. Slide the ferrule onto the cable.
2. Strip the cable to the dimensions shown in Figure 3.
3. Be careful not to nick or cut the center conductor or cable braid. Flare the braid.

#### Recommended Stripping Dimensions ±0.25 [±.010]



Note: Not to scale

Figure 3

3. Slide the pin contact onto the cable center conductor until the contact butts against the cable dielectric. Refer to Figure 4. Crimp the contact. Check the crimp to make sure that there is no gap between the contact and the cable dielectric.

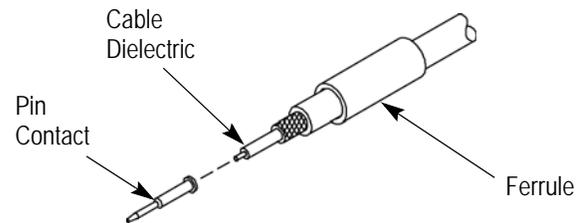


Figure 4

CABLE SIZE (RG/U)	TOOLING					
	CONTACT CRIMP		FERRULE CRIMP			
	DANIELS AFM8 Tool Military M22520/2-01		PRO-CRIMPER <sup>*</sup> III Frame Assembly 354940-1		DANIELS Tool HX4 Military M22520/5-01	
	Positioner	Selector Setting	Die Assembly	Crimping Chamber	Hex Die Set	Position
174 <sup>‡</sup> , 316	K1041	4 <sup>‡</sup>	58483-1	.128 (B)	Y-1637	.128

<sup>†</sup> DIN Standardization Committee of Motor Vehicles (FAKRA) 70010

<sup>‡</sup> CHEMINAX Coaxial Cable 5024P1309 (equivalent to cable size RG 174/U) can be used. Selector setting should be "2" when using this cable. To obtain this cable, contact Raychem, a Division of TEI Connectivity, (1-800-272-9243)

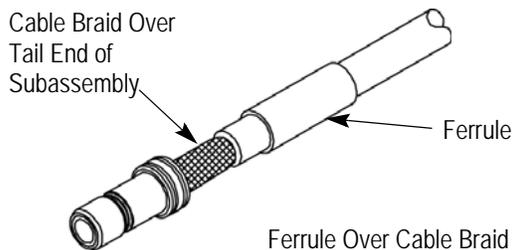
Figure 2

4. Insert the crimped contact into the subassembly, then firmly push it into the subassembly until it is fully seated in the dielectric. Make sure that the cable braid is positioned over the tail end of the subassembly. See Figure 5, Detail A.

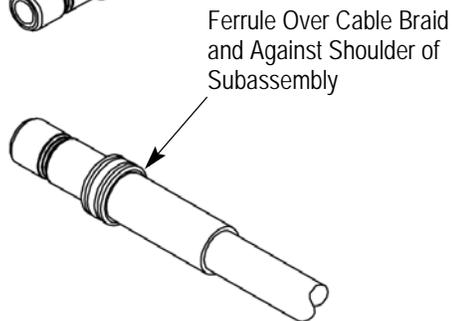
5. Slide the ferrule over the cable braid until the ferrule butts against the shoulder of the subassembly. See Figure 5, Detail B.

6. Crimp the ferrule. Visually inspect the crimped ferrule according to Figure 5, Detail C.

*Detail A*



*Detail B*



*Detail C*

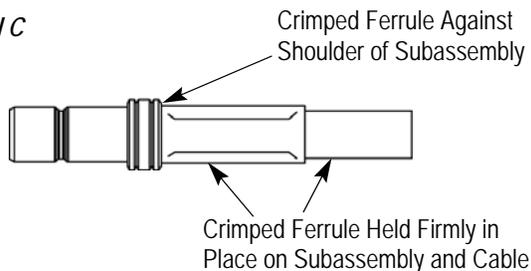


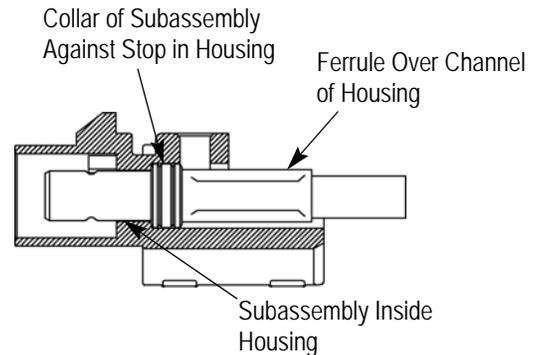
Figure 5

7. Slide the subassembly into the housing until the collar bottoms on the stop. The full length of the subassembly should be inside the housing and the ferrule over, but not touching, the channel of the housing. See Figure 6, Detail A.

8. Align the locking windows of the lock with the latches of the housing. See Figure 6, Detail B. Push the lock onto the housing until it 'snaps' into place. Check that all latches are fully engaged. If any latch is not fully engaged, press down on the top of the lock while pressing inward on the sides of the lock.

9. Make sure that all parts of the lock are flush to the housing. Refer to Figure 7 for a properly assembled jack kit.

*Detail A*



*Detail B*

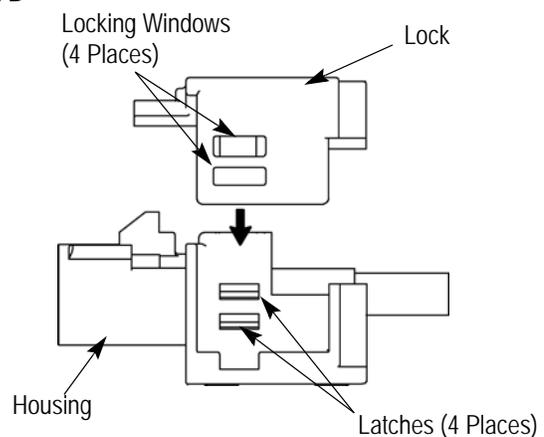


Figure 6

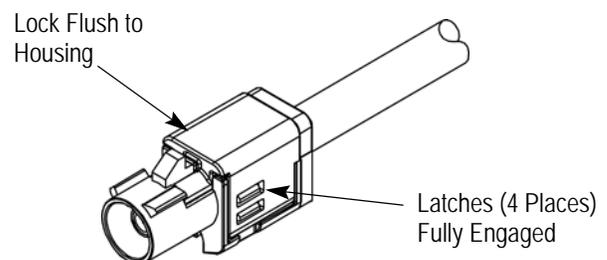


Figure 7

#### 4. REPLACEMENT AND REPAIR

Kit components are not repairable. Replace any damaged components. **DO NOT** re-use terminated pin contacts, ferrules, or subassemblies by removing the cable.

#### 5. REVISION SUMMARY

Latest revisions to this instruction sheet include:

- Updated document to corporate requirements