

4					3					2					1									
DWG. NO. SD44088															ASSEMBLY COMPONENTS FOR OUTER CONTACTS					NOTES: 1. FOR PLATING TYPES, REFER TO INDIVIDUAL SALES DRAWINGS AS LISTED. 2. FOR COMMONING BLOCK APPLICATIONS, THE YOC110L-6 REPLACES THE YOC110. (SC49453). FOR DIRECTION OF BLUE MARKING SEE SHEET 2 (VIEW 2) 3. THE CONTACTS LISTED ARE RECOMMENDED FOR USE WITH THE FOLLOWING SOURIAU CONNECTORS: ME6MX13 P/R____ ME12MX P/R____ MD12MX P/R____ MC8MX13 P/R____ PD21MX P/R____ RSCMXT110-2 RSCMXT110-3 RSMMXT110-2 RSMMXT110-3 RSMME-X-1 M18TBX____ M22T10X____ MA28C19____ MA28C96____ REFERENCE: SC48873-RMMX110-1 SC48870-RCMX110-1 DS101 DS104 DS110 SC49453-YOC126L-6				
RECOMMENDATION NUMBER	CABLE TYPE				INNER CONDUCTOR CONTACTS				OUTER CONDUCTOR (BRAID) CONTACTS						ASSEMBLY PROCEDURE SHEET NO.									
		INNER PIN		INNER SOCKET		OUTER PIN		OUTER SOCKET		RCMXB	YOC													
		DIA OVER JACKET	DIA OVER DIELEC.	INNER COND SIZE	CATALOG NO. DRAWING NO.	TOOL INDEX NUMBER	CATALOG NO. DRAWING NO.	TOOL INDEX NUMBER	CATALOG NO. DRAWING NO.	TOOL INDEX NUMBER	CATALOG NO. DRAWING NO.	CATALOG NO. DRAWING NO.												
1	#24 SHIELDED PHILCO TYPE SC-12	.108 MAX.	.046	7/32	RMM22W-1____ SC48876	CT-442	RFM22W-1____ SC48877	CT-441	RMMX110-1____ SC48873	CT-423	RCMX110-1____ SC48870	CT-425	YORX110-2 RCMXB053	SA46549 SA46546	5									
2	SURPRENANT *9872	.140	.100	7/.0056	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
3	SURPRENANT *4029	.136	.092	#29 SOLID	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
4	RG161/U	.090	.057	7/38	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX143-1____ SC48875	CT-444	RCMX143-1____ SC48872	CT-443	YIRX069	SC43377	3									
5	RG174/U	.100	.060	7/34	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-446	RCMX110-1____ SC48870	CT-445	YORX110-2	SA46549	6									
6	RG187/U	.110 MAX.	.060	7/.004	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-446	RCMX110-1____ SC48870	CT-445	YORX110-2	SA46549	6									
7	RG188/U	.110 MAX.	.060	7/.0067	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-440	RMMX110-1____ SC48873	CT-696	RCMX110-1____ SC48870	CT-697	YORX110-2 RCMXB-067	SA46549 SA51449	4									
8	RG195/U	.155 MAX.	.102	7/.004	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
9	AMPHENOL #21-597	.150	.100	7/.0056	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
10	AMPHENOL #21-598	.105	.060	7/.0063	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-446	RCMX110-1____ SC48870	CT-445	YORX110-1	SA46549	6									
11	MICRODOT #93-3902	-	-	-	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
12	TWISTED PAIR #24AWG PER MIL-W-16878C TYPE B	-	.046	7/.008	RMM22W-1____ SC48876	CT-442	RFM22W-1____ SC48877	CT-441	RMMX110-1____ SC48873	CT-423	RCMX110-1____ SC48870	CT-425	YORX110-2 RCMXB-053	SA46549 SA46546	5									
13	RESISTOR- CAPACITOR TERMINATION	-	-	.032	RMM20W-1____ SC48876	CT-448	RFM20W-1____ SC48877	CT-447	RMMX110-1____ SC48873	CT-582	RCMX110-1____ SC48870	CT-583	YOC110 RCMXB-053	SA25594 SA46546	7									
14	RG180B/U	.145 MAX.	.102	7/.004	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT424	YOC110	SA25594	2									
17	MICRO DOT # 93-3913	.132	.090	#.29 SOLID	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
18	RG 196/U SEE SHEET 4	.080	.034	7/.004	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-423	RCMX110-1____ SC48870	CT-425	YORX110-2 RCMXB053	SA46549 SA46546	4									
19	RG 180/U	.141	.103	7/.0039	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
20	RG 180A/U	.145	.102	7/.004	RMM26W-1____ SC48876	CT-440	RFM26W-1____ SC48877	CT-439	RMMX110-1____ SC48873	CT-422	RCMX110-1____ SC48870	CT-424	YOC110	SA25594	2									
21	22 TWISTED PAIR (7) STR. PER 18M DWG #5284583	-	.058	7/.010	RMM22W-1____ SC48876	CT-442	RFM22W-1____ SC48877	CT-441	RMMX110-1____ SC48873	CT-423	RCMX110-1____ SC48870	CT-425	YORX110-2 RCMXB-067	SA46549 SA51449	5									
22	#22 SHIELDED MIL-W-16878 TYPE "B" (19STR)	.110	.052	19/.0063	RMM20W-1____ SC48876	CT-448	RFM20W-1____ SC48877	CT-447	RMMX110-1____ SC48873	CT-426	RCMX110-1____ SC48870	CT-445	YORX110-2P1	SA49289	6									

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B

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DWG. NO.

SD44088

FOR NOTES SEE SHEET 1

4

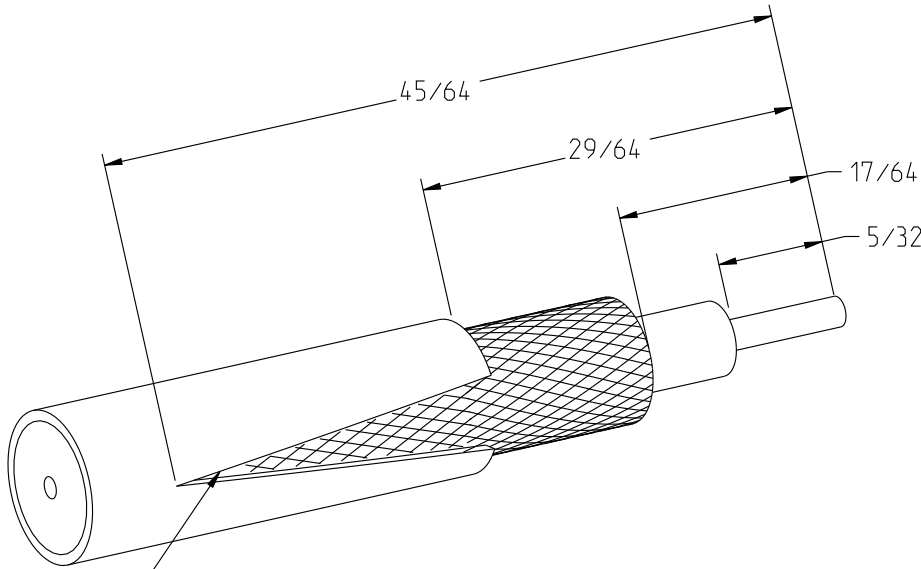
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1

2

2

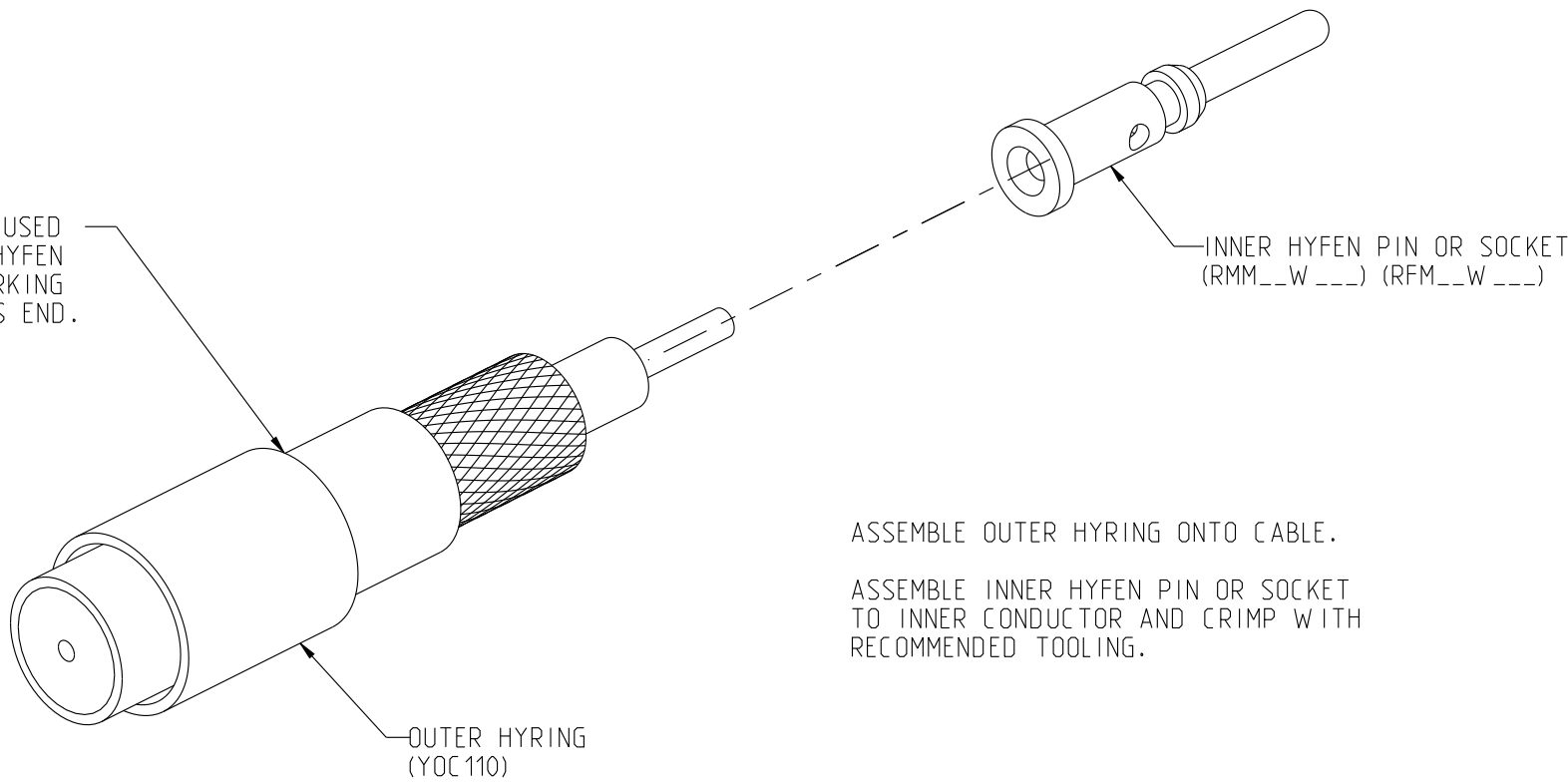
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SLIT TO BE MADE ONLY WHEN JACKET MATERIAL IS NOT ELASTIC

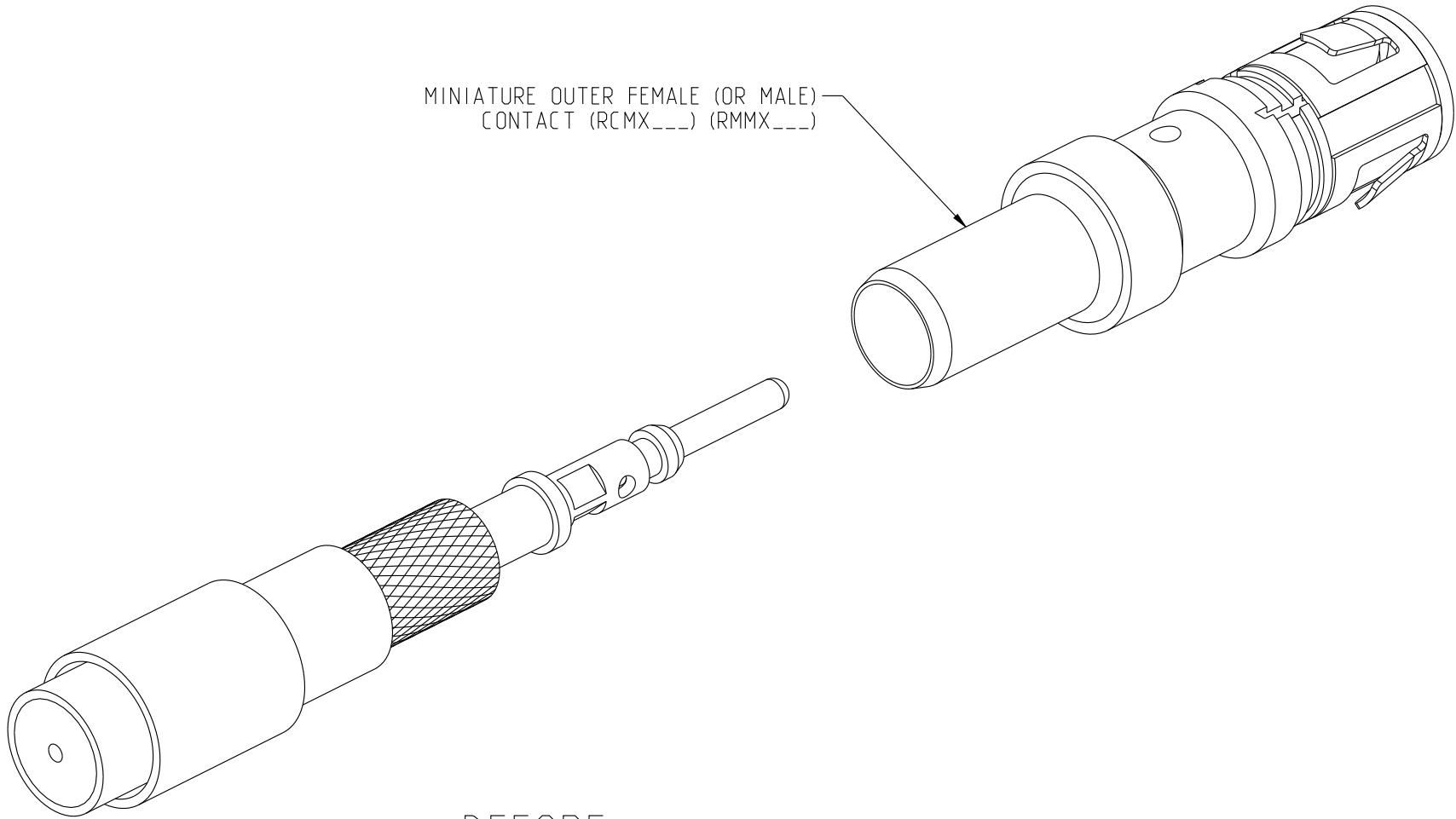
STRIP COAXIAL CABLE TO DIMENSIONS SHOWN (DIMENSION MAY BE ALTERED TO SUIT CHARACTERISTICS OF CABLE)

WHEN THE YOC110L-6 IS USED IN A MINIATURE COAX HYFEN ASSEMBLY, THE BLUE MARKING IS ON THIS END.



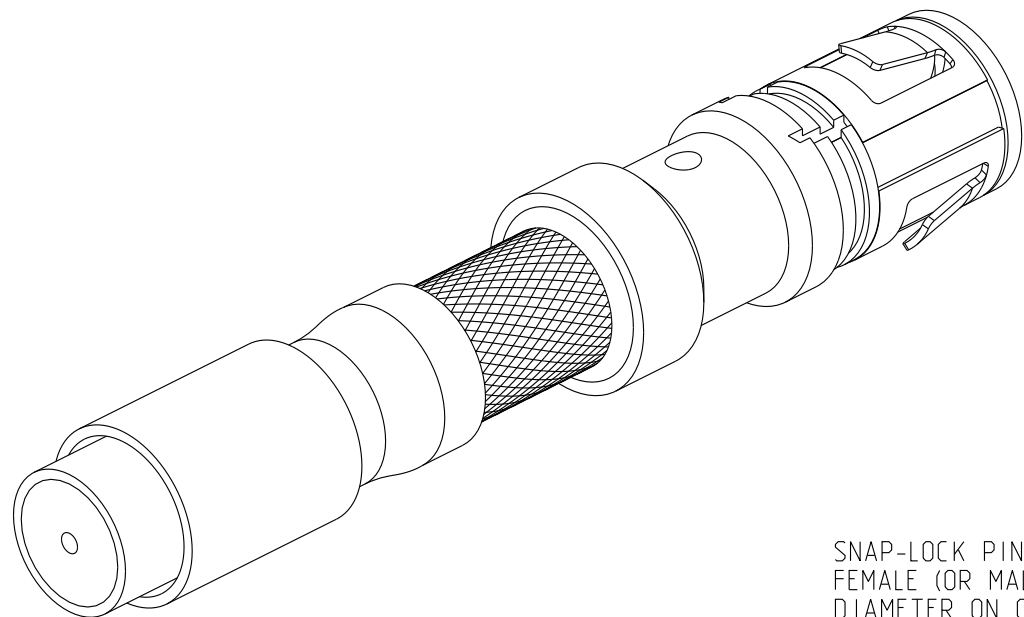
ASSEMBLE OUTER HYRING ONTO CABLE.

ASSEMBLE INNER HYFEN PIN OR SOCKET TO INNER CONDUCTOR AND CRIMP WITH RECOMMENDED TOOLING.



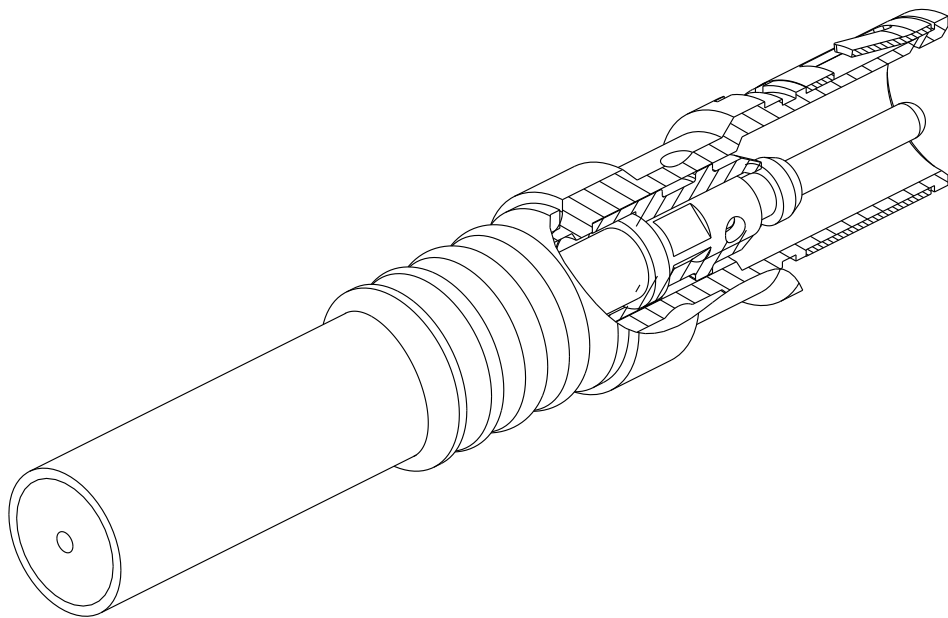
MINIATURE OUTER FEMALE (OR MALE) CONTACT (RCMX__) (RMMX__)

BEFORE



SNAP-LOCK PIN OR SOCKET INTO OUTER FEMALE (OR MALE) CONTACT. SMALL DIAMETER ON OUTER BODY MUST SLIDE UNDER BRAID AND OUTER INSULATION.

AFTER



SLIDE OUTER HYRING OVER EXPOSED BRAID, AND CRIMP HYRING ONTO BRAID AND OUTER INSULATION WITH RECOMMENDED TOOLING.

ASSEMBLY CAN NOW BE SNAP-LOCKED INTO CONNECTOR BLOCK

LINEAR MEASURE:			INCH [mm]
THIRD ANGLE PROJECTION			
TOLERANCES UNLESS OTHERWISE SPECIFIED			
No. OF PLACES	INCH [mm]		
ONE PLACE	±.1 [±.3]		
TWO PLACES	±.02 [±0.5]		
THREE PLACES	±.010 [±0.25]		
ANGLES ±1°			

DRAWING TITLE			
ASSY. PROCEDURE FOR MINIATURE COAX HYFEN			
CAT NO. RCMX__ & RMMX__			
CAGE NO: 09922		SIZE: C	
CUSTOMER		SOURIAU	
INTERPRET THIS DRAWING IN ACCORDANCE WITH ASME Y14.5M - 1994.		WWW.SOURIAU.COM	
DRAWING NO. SD44088		REV AD	
2 OF 7		PRO-E	

A

B

C

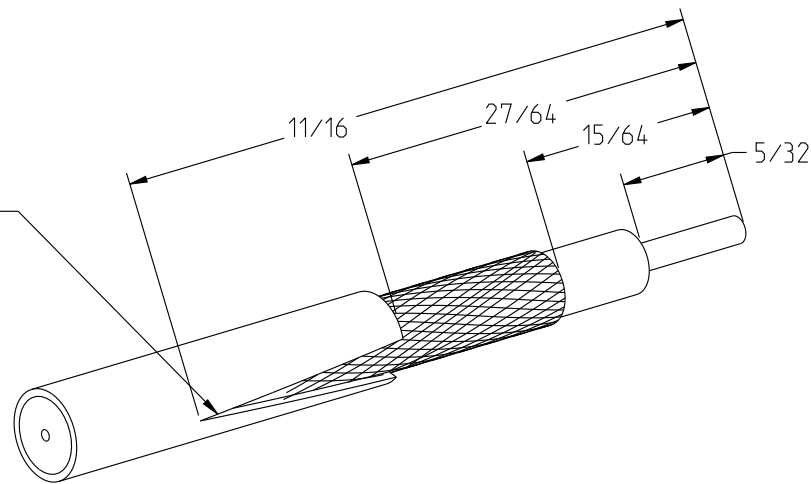
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FOR NOTES SEE SHEET 1

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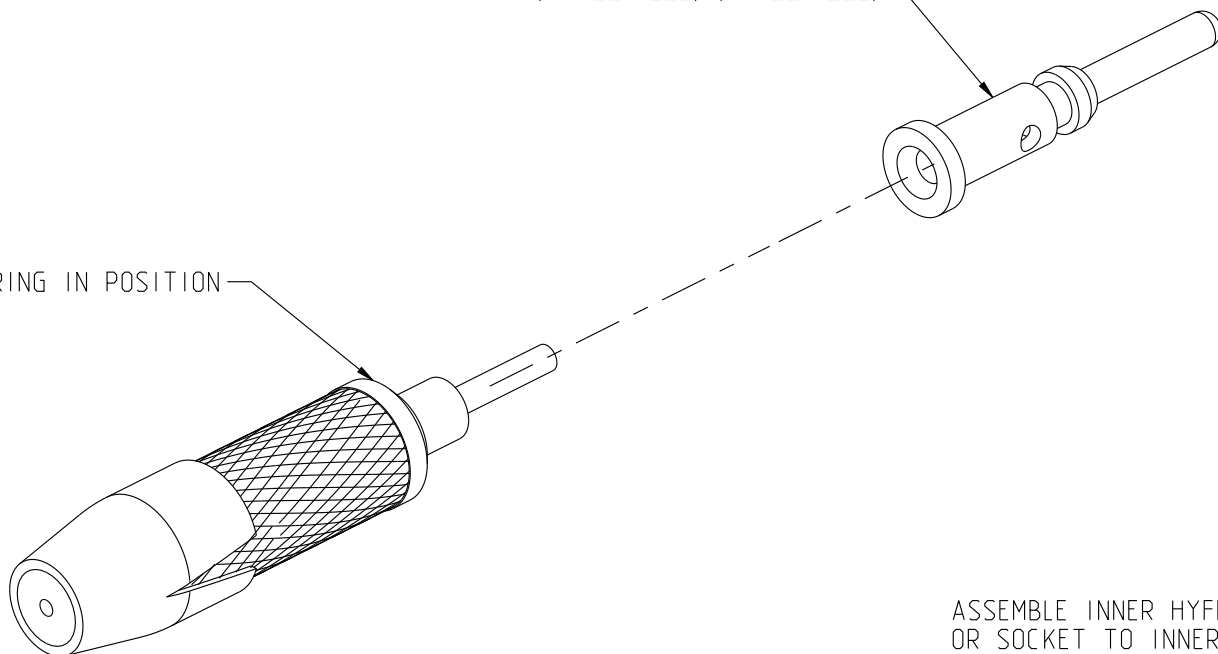


SLIT TO BE MADE ONLY
WHEN JACKET MATERIAL
IS NOT ELASTIC



STRIP COAXIAL CABLE TO
DIMENSIONS SHOWN.
(DIMENSIONS MAY BE
ALTERED TO SUIT
CHARACTERISTICS OF CABLE)

3

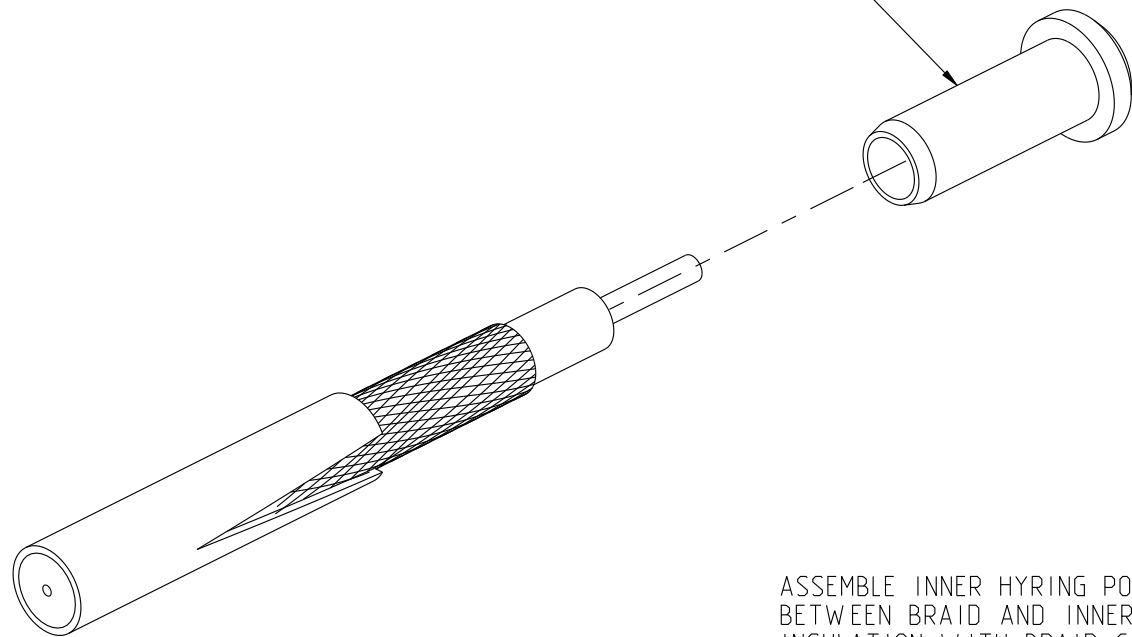
HYFEN PIN OR SOCKET —
(RMM__W___) (RFM__W___)

ASSEMBLE INNER HYFEN PIN
OR SOCKET TO INNER CONDUCTOR
AND CRIMP WITH RECOMMENDED
TOOLING

C

2

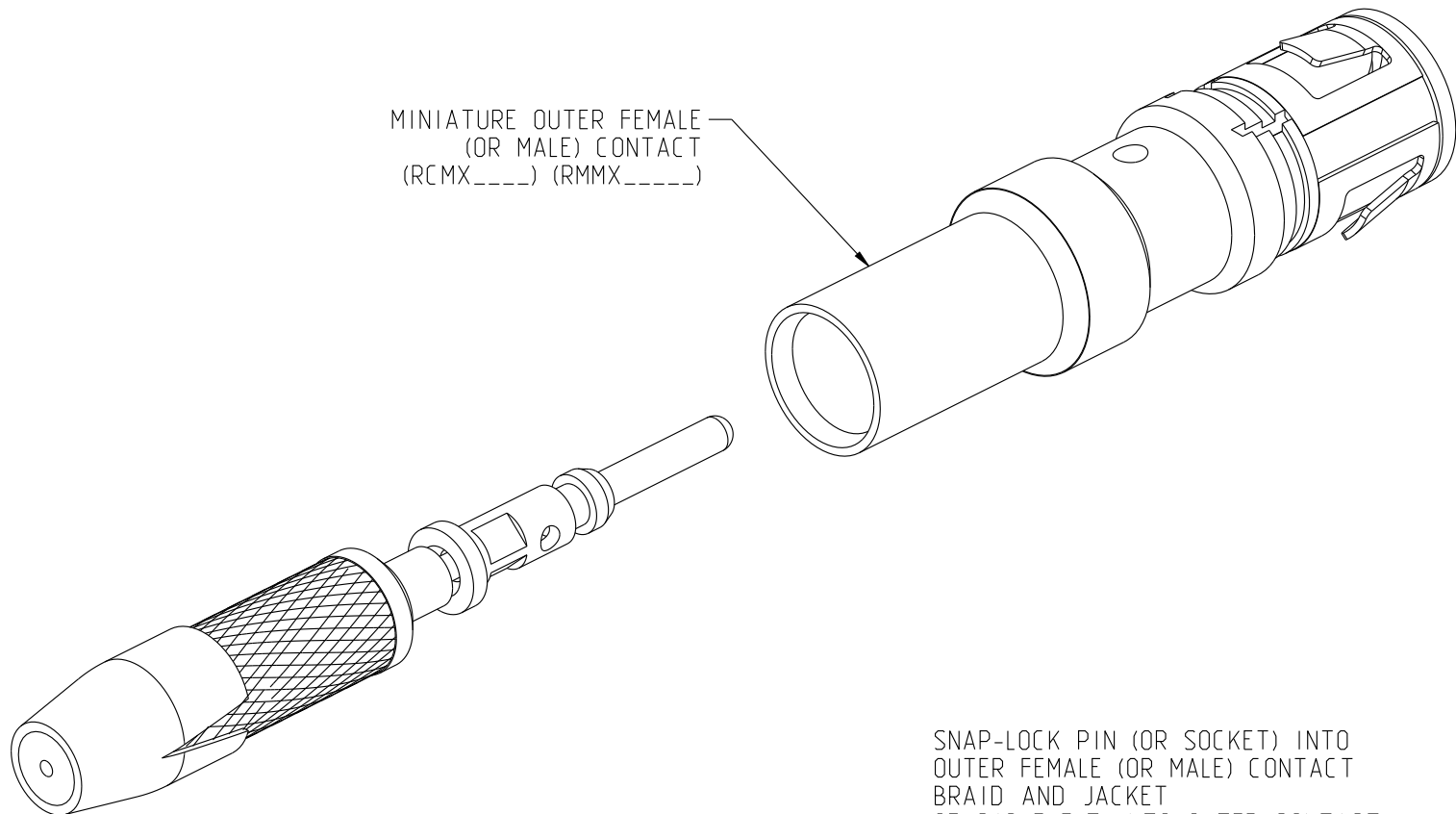
INNER HYRING
(YIRX069)



ASSEMBLE INNER HYRING POSITION
BETWEEN BRAID AND INNER CONDUCTOR
INSULATION WITH BRAID COVERING
COMPLETE HYRING UP TO FLANGE.

4

MINIATURE OUTER FEMALE
(OR MALE) CONTACT
(RCMX____) (RMMX_____)



SNAP-LOCK PIN (OR SOCKET) INTO
OUTER FEMALE (OR MALE) CONTACT
BRAID AND JACKET
OF CABLE FIT INTO OUTER CONTACT

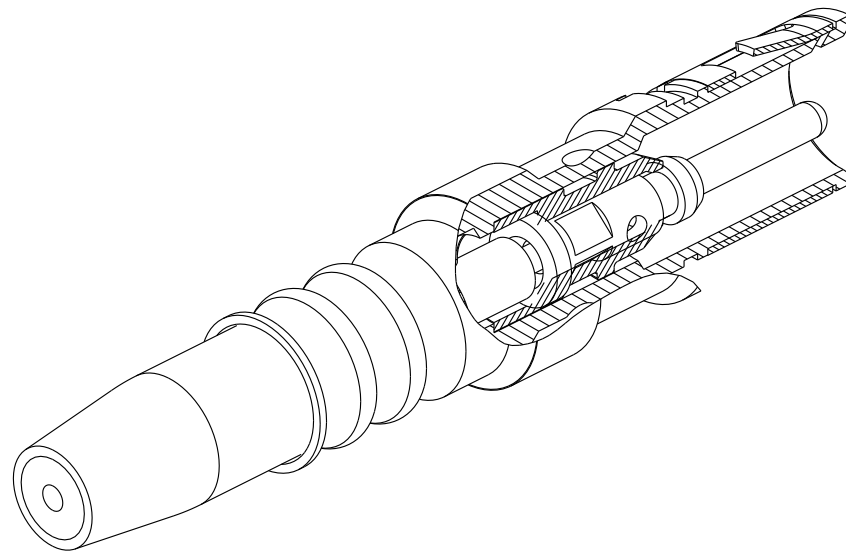
D

C

B

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5



INSPECT FOR BRAID THROUGH PEEP HOLE
(INNER HYRING SHOULD BE CLEAR OF HOLE).
CRIMP REAR PORTION OF OUTER CONTACT
WITH RECOMMENDED TOOLING.

ASSEMBLY CAN NOW BE SNAP-LOCKED INTO
CONNECTOR BLOCK.

-	ALL REVISIONS RECORDED ON SHT 1	-	-
REV	DESCRIPTION	BY DATE	CHKD DATE

LINEAR MEASURE:	 INCH	INCH (mm)
THIRD ANGLE PROJECTION		
		
TOLERANCES		
UNLESS OTHERWISE SPECIFIED		
NO. OF PLACES	INCH (mm)	
ONE PLACE	±.1 [±3]	
TWO PLACES	±.02 [±0.5]	
THREE PLACES	±.010 [±0.25]	
ANGLES ±1°		

DRAWING TITLE					
ASSY. PROCEDURE FOR MINIATURE COAX HYFEN					
CAT NO.					
RCMX _ _ _ & RMMX _ _ _					
CAGE NO: 09922		SIZE: C			
CUSTOMER		SOURIAU			
				APPROVAL	
				DRAWN: SKV 08-16-13	
				CHKD : Tw 08-16-13	
				DSGN : XXX mm-dd-yy	
MFG : DH 08-16-13					
QC : BB 08-16-13					
DRAWING SCALE: 5:1					
DRAWING NO.		REV			
SD44088		AD			
INTERPRET THIS DRAWING IN ACCORDANCE WITH ASME Y14.5M - 1994.		3 OF 7			
WWW.SOURIAU.COM					

A

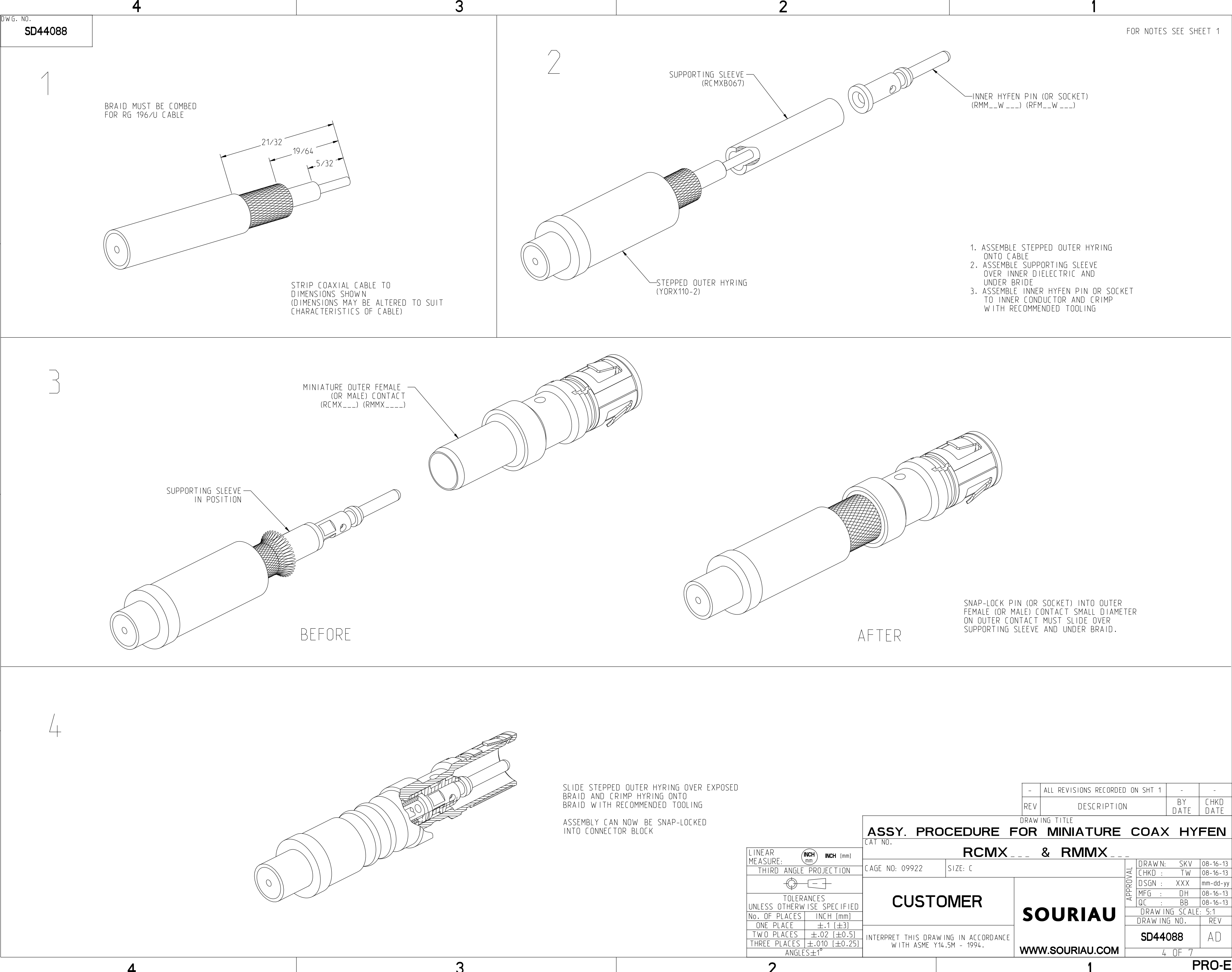
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3

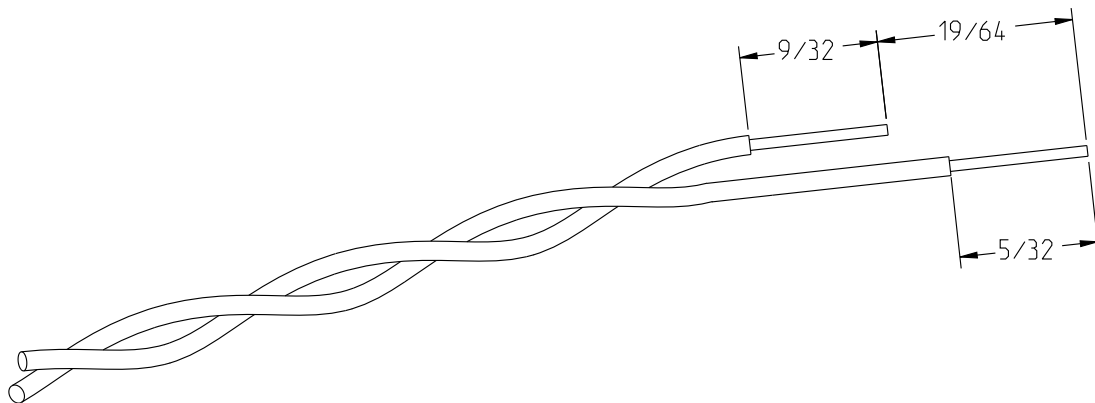
2

1

PRO-E

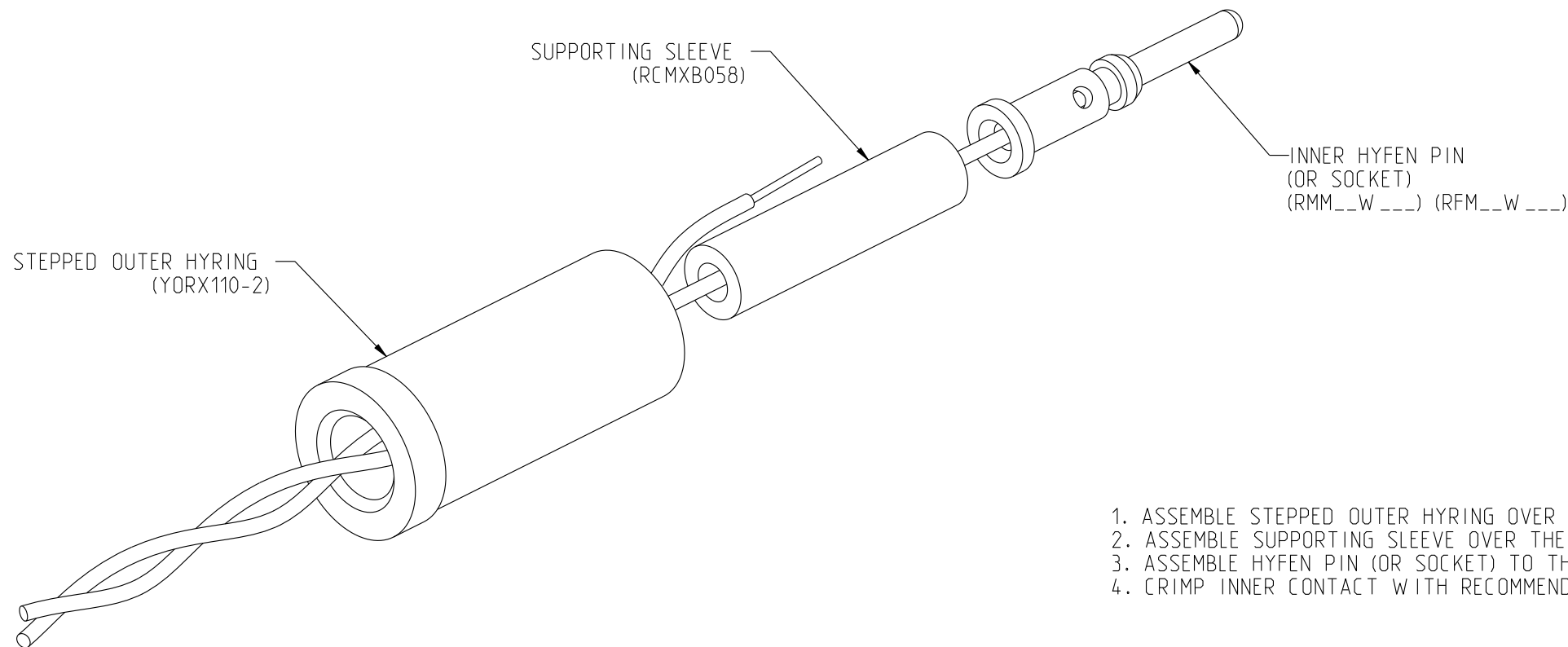


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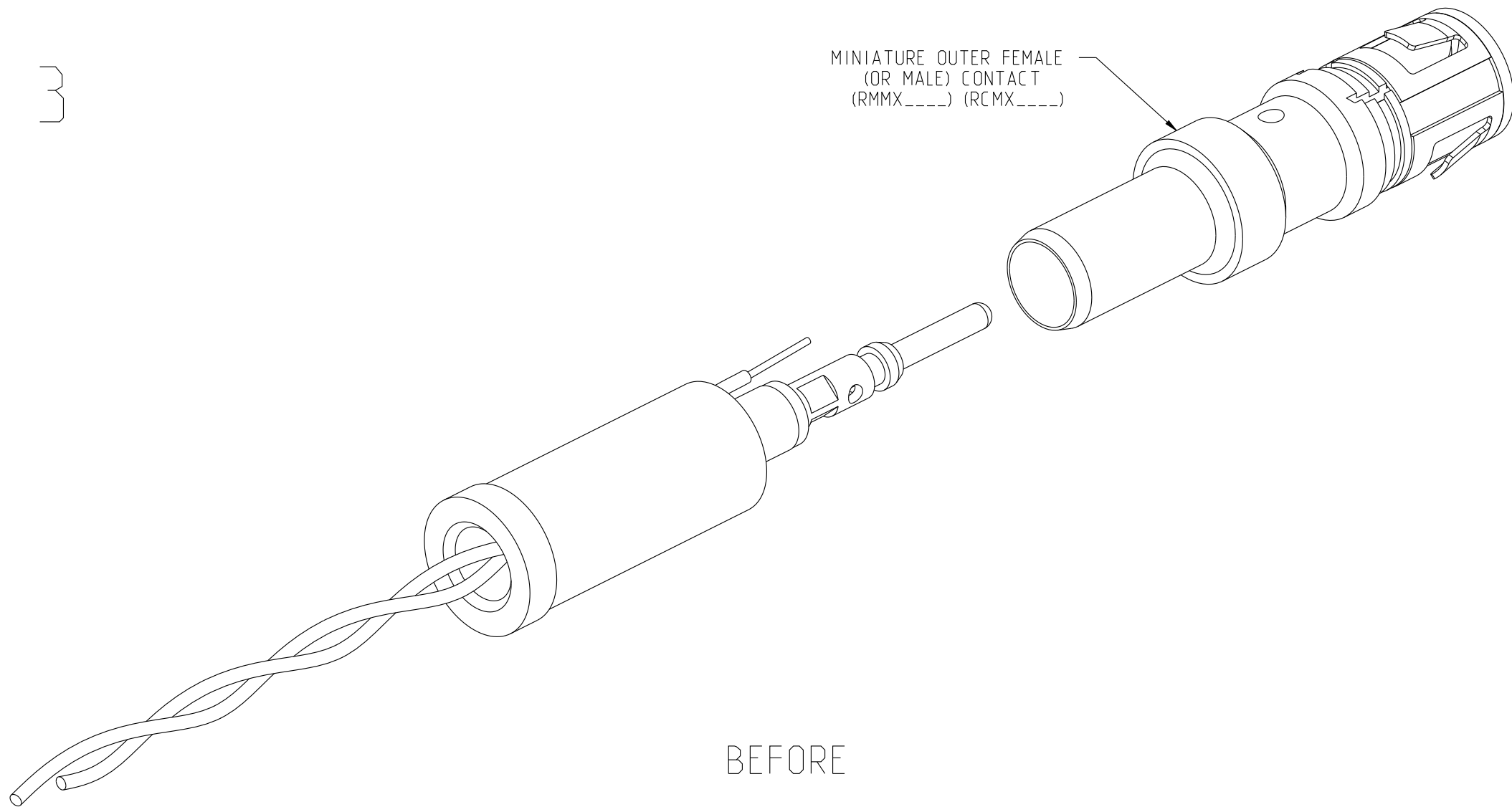
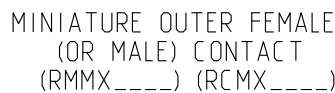
STRIP WIRE TO DIMENSIONS SHOWN

2



1. ASSEMBLE STEPPED OUTER HYRING OVER "TWISTED PAIR"
2. ASSEMBLE SUPPORTING SLEEVE OVER THE LONGER WIRE
3. ASSEMBLE HYFEN PIN (OR SOCKET) TO THE LONGER WIRE.
4. CRIMP INNER CONTACT WITH RECOMMENDED TOOLING.

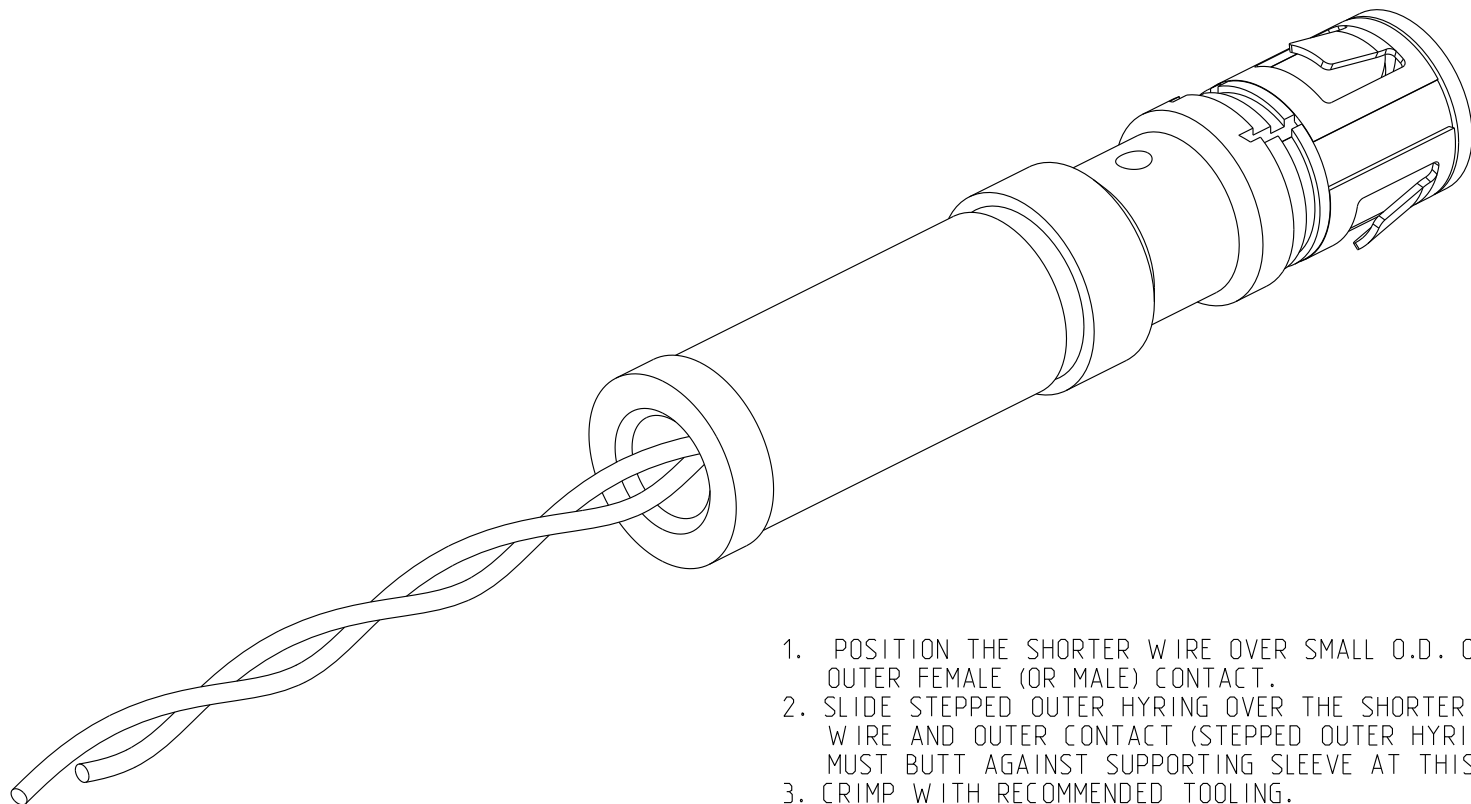
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BEFORE

C

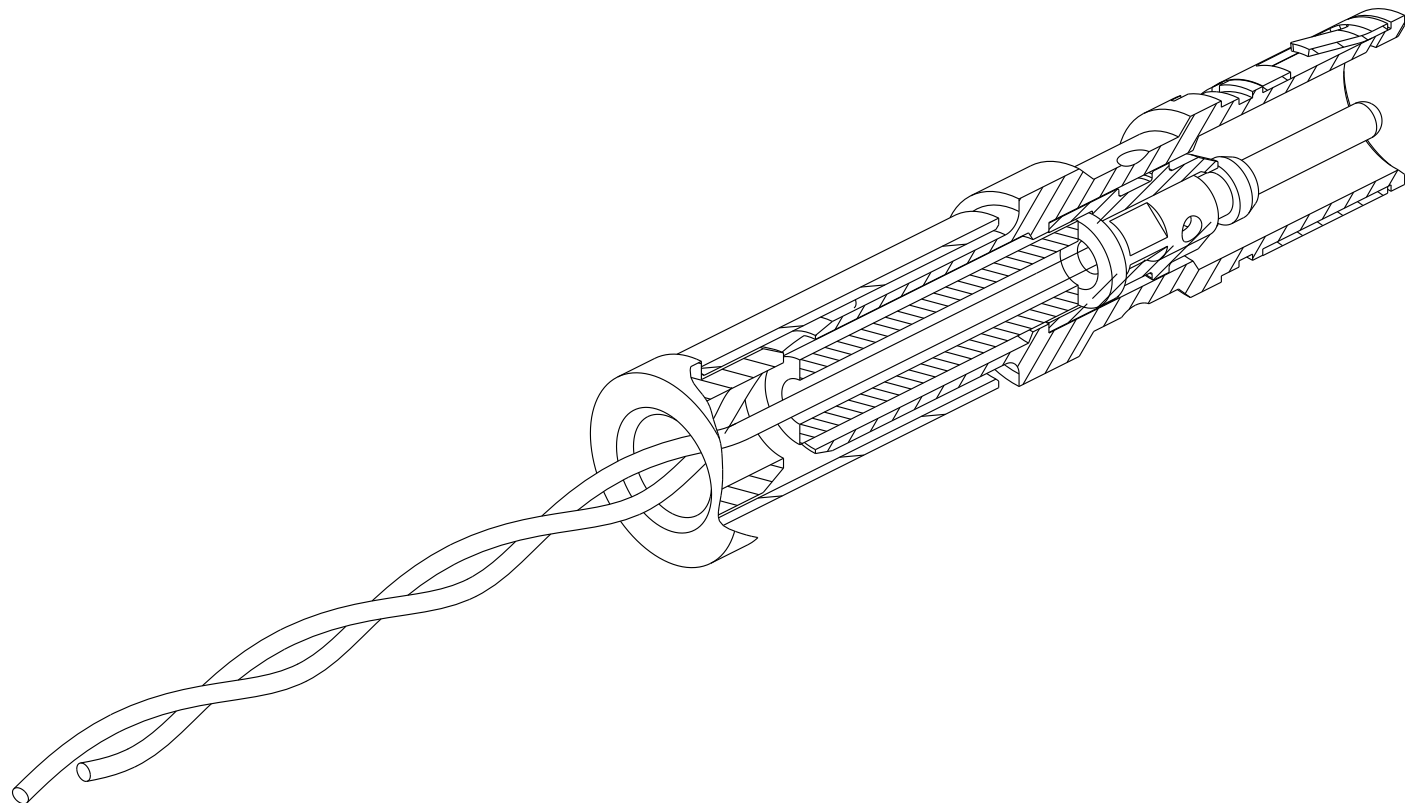
B



1. POSITION THE SHORTER WIRE OVER SMALL O.D. OF OUTER FEMALE (OR MALE) CONTACT.
2. SLIDE STEPPED OUTER HYRING OVER THE SHORTER WIRE AND OUTER CONTACT (STEPPED OUTER HYRING MUST BUTT AGAINST SUPPORTING SLEEVE AT THIS POINT)
3. CRIMP WITH RECOMMENDED TOOLING.

AFTER

4



ASSEMBLY CAN NOW
BE SNAP LOCKED INTO
CONNECTOR BLOCK

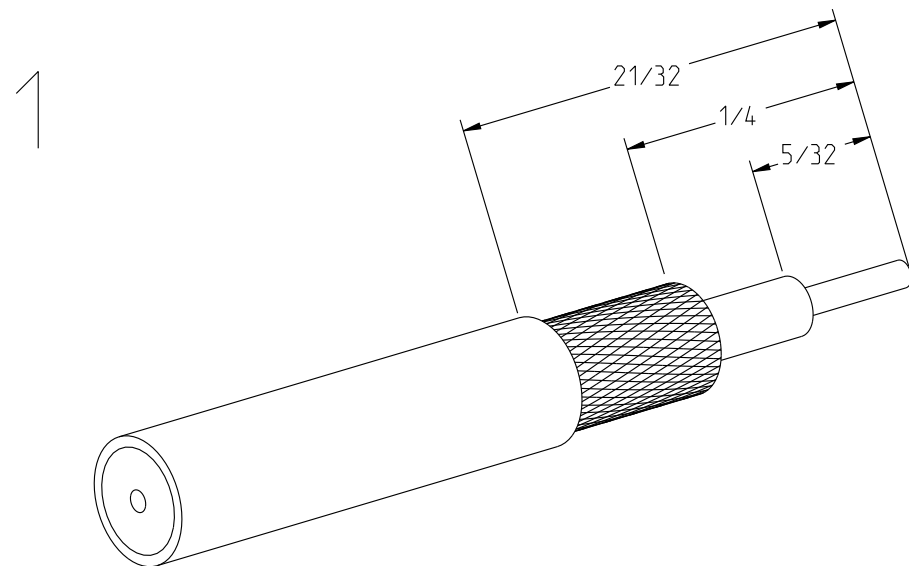
-	ALL REVISIONS RECORDED ON SHT 1	-	-
REV	DESCRIPTION	BY DATE	CHKD DATE

LINEAR MEASURE:			INCH (mm)
THIRD ANGLE PROJECTION			
			
TOLERANCES			
UNLESS OTHERWISE SPECIFIED			
NO. OF PLACES	INCH [mm]		
ONE PLACE	$\pm .1$ [± 3]		
TWO PLACES	$\pm .02$ [± 0.5]		
THREE PLACES	$\pm .010$ [± 0.2]		
ANGLES $\pm 1^\circ$			

DRAWING TITLE			
ASSY. PROCEDURE FOR MINIATURE COAX HYFEN			
CAT NO.			
RCMX _ _ _ & RMMX _ _ _			
CAGE NO: 09922		SIZE: C	
CUSTOMER		SOURIAU	
INTERPRET THIS DRAWING IN ACCORDANCE WITH ASME Y14.5M - 1994.		DRAWN: SKV 08-16-13	
		CHKD : TW 08-16-13	
		DSGN : XXX mm-dd-yy	
		MFG : DH 08-16-13	
		QC : BB 08-16-13	
		DRAWING SCALE: 5:1	
		DRAWING NO.	
		REV	
		SD44088	
		AD	
		5 OF 7	

A

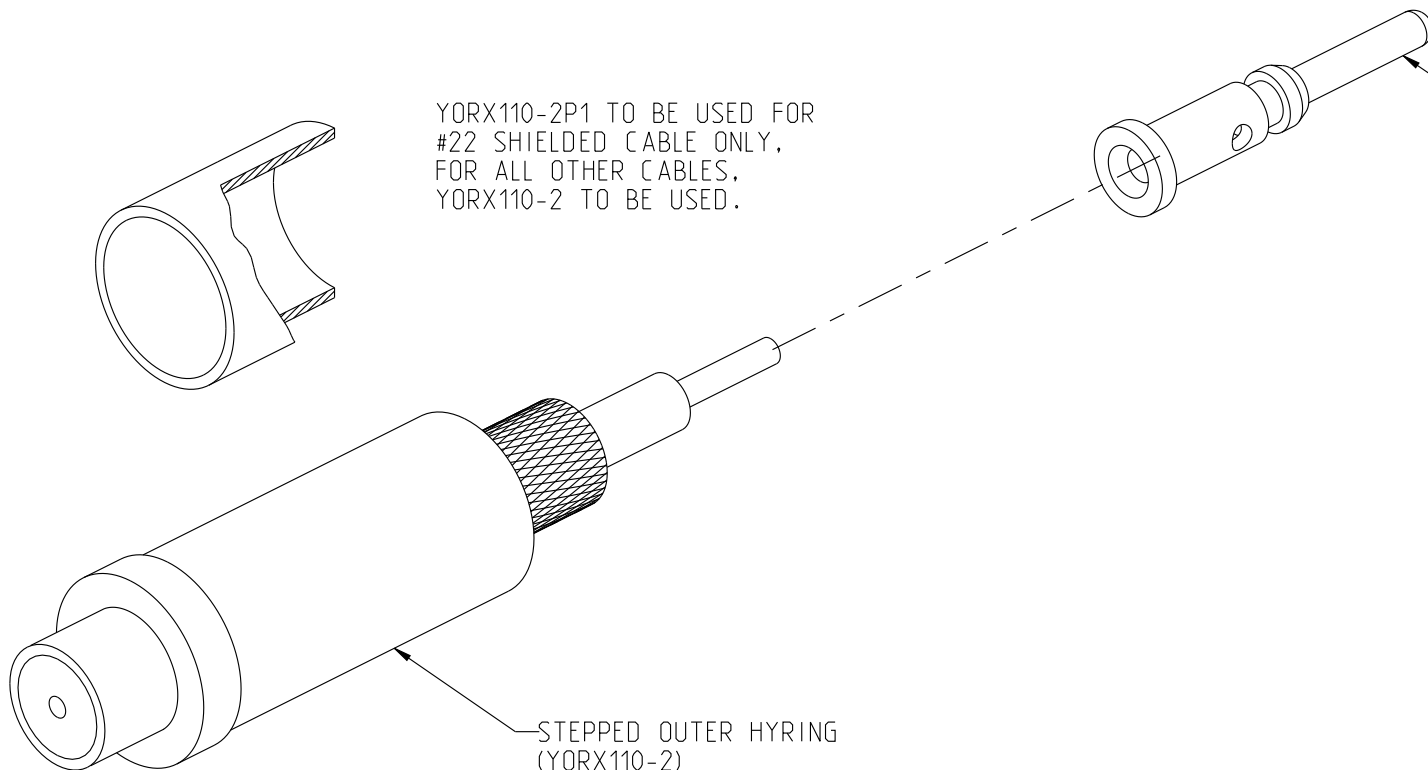
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STRIP COAXIAL CABLE TO
DIMENSIONS SHOWN
(DIMENSIONS MAY BE ALTERED TO SUIT
CHARACTERISTICS OF CABLE)



YORX110-2P1 TO BE USED FOR
#22 SHIELDED CABLE ONLY,
FOR ALL OTHER CABLES,
YORX110-2 TO BE USED.

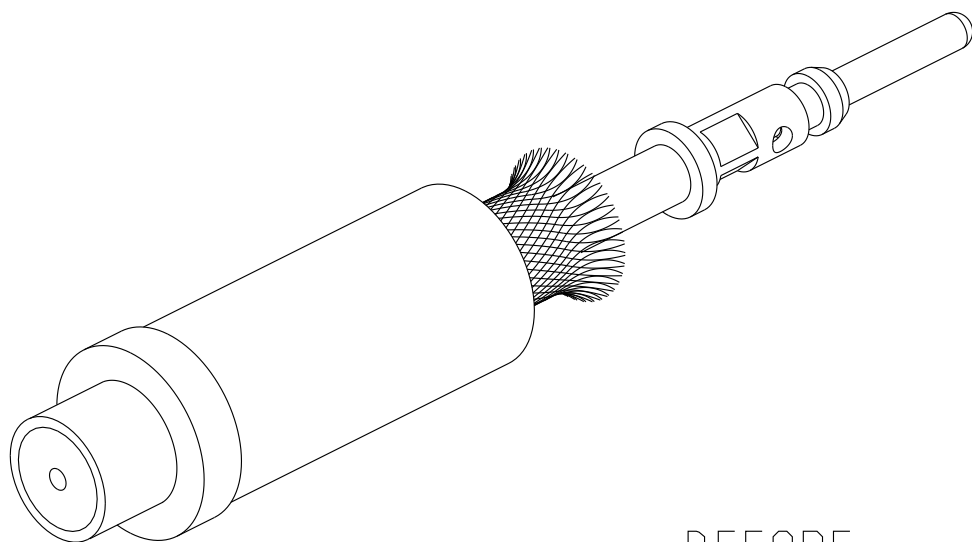
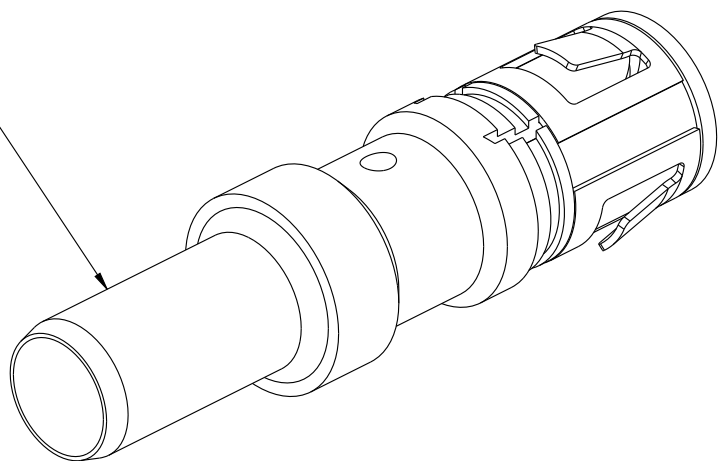
-INNER HYFEN PIN (OR SOCKET)
(RMM__W __) (RFM__W __)

1. ASSEMBLE STEPPED OUTER HYRING ONTO CABLE
2. ASSEMBLE INNER HYFEN PIN OR SOCKET TO INNER CONDUCTOR AND CRIMP WITH RECOMMENDED TOOLING

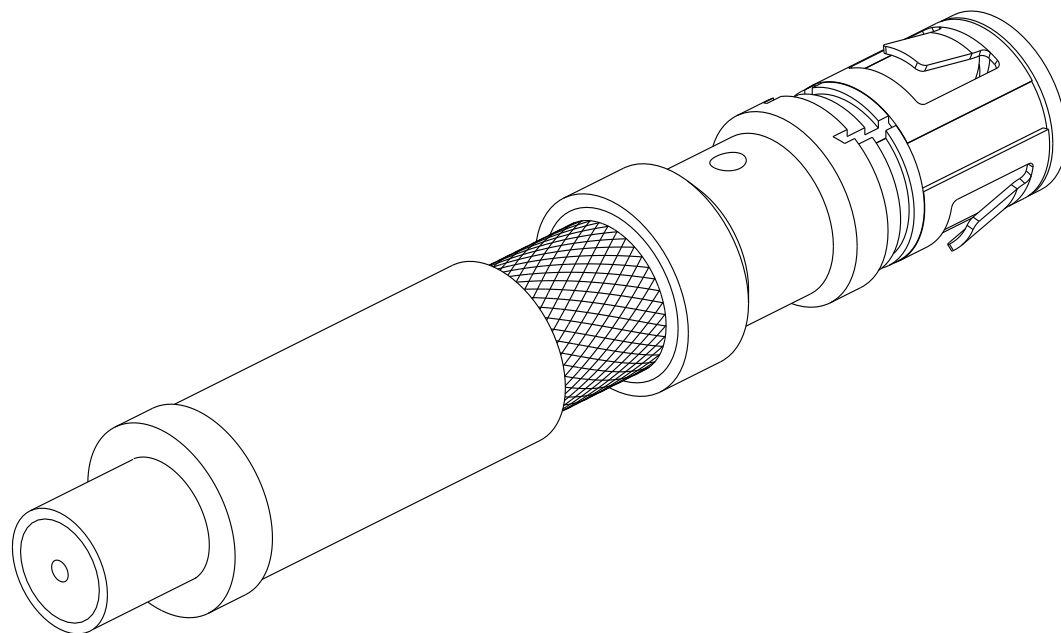
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MINIATURE OUTER FEMALE
(OR MALE) CONTACT
(RCMX__)(RMMX__)



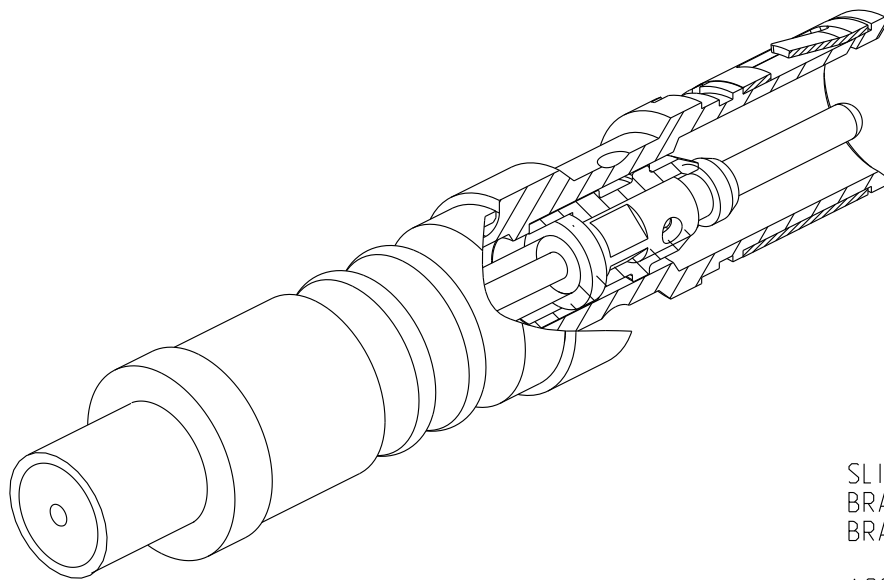
BEFORE



AFTER

SNAP-LOCK INNER HYFEN PIN
(OR SOCKET) IN TO OUTER FEMALE
(OR MALE) CONTACT.
SMALL DIAMETER ON OUTER
CONTACT MUST SLIDE UNDER
BRAID

DISCLOSED WITHOUT WRITTEN CONSENT FROM SOURIAU USA, INC.



SLIDE STEPPED OUTER HYRING OVER EXPOSED
BRAID, AND CRIMP HYRING ONTO
BRAID WITH RECOMMENDED TOOLING

ASSEMBLY CAN NOW BE SNAP-LOCKED
INTO CONNECTOR BLOCK

LINEAR MEASURE:			INCH mm	INCH (mm)
THIRD ANGLE PROJECTION				
				
TOLERANCES				
UNLESS OTHERWISE SPECIFIED				
No. OF PLACES	INCH (mm)			
ONE PLACE	$\pm .1$ (± 3)			
TWO PLACES	$\pm .02$ (± 0.5)			
THREE PLACES	$\pm .010$ (± 0.2)			
ANGLES $\pm 1^\circ$				

DRAWING TITLE				
ASSY. PROCEDURE FOR MINIATURE COAX HYFEN				
CAT NO.				
RCMX _ _ _ & RMMX _ _ _				
CAGE NO: 09922		SIZE: C		
CUSTOMER		SOURIAU		
INTERPRET THIS DRAWING IN ACCORDANCE WITH ASME Y14.5M - 1994.		WWW.SOURIAU.COM		
		APPROVAL	DRAWN: SKV	08-16-13
			CHKD : TW	08-16-13
			DSGN : XXX	mm-dd-yy
			MFGN : DH	08-16-13
			QC : BB	08-16-13
		DRAWING SCALE: 5:1		
		DRAWING NO.	REV	
		SD44088	AD	
		6 OF 7		

A

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C

B

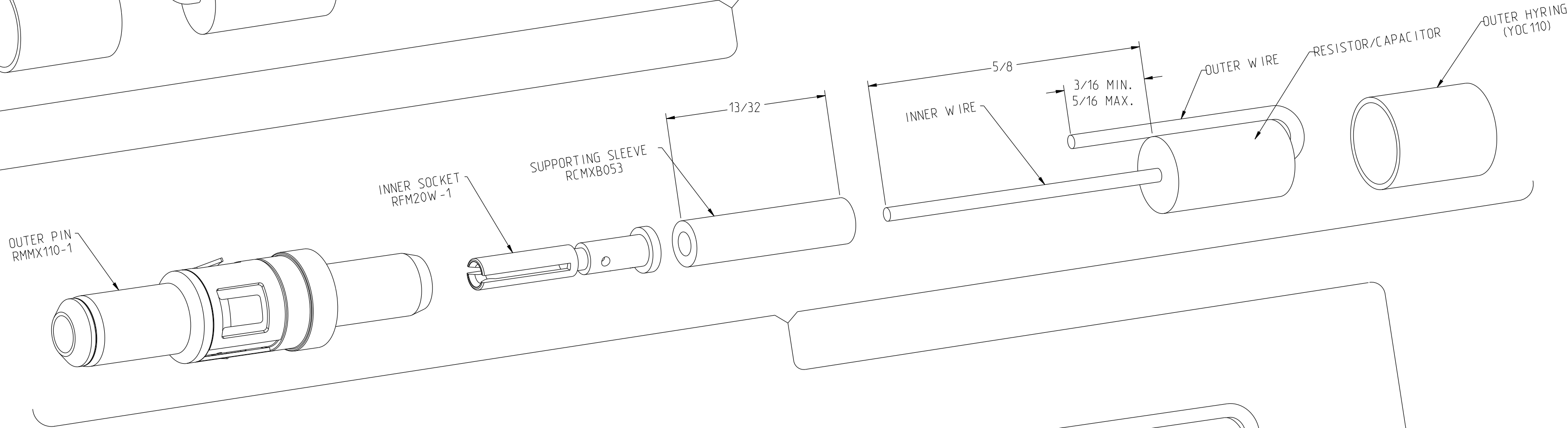
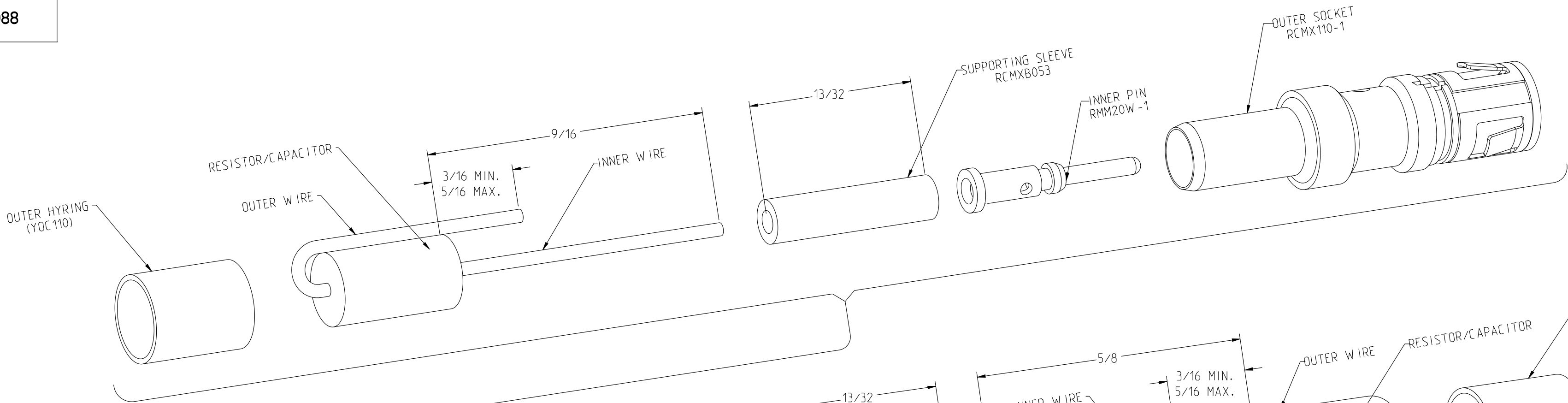
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D

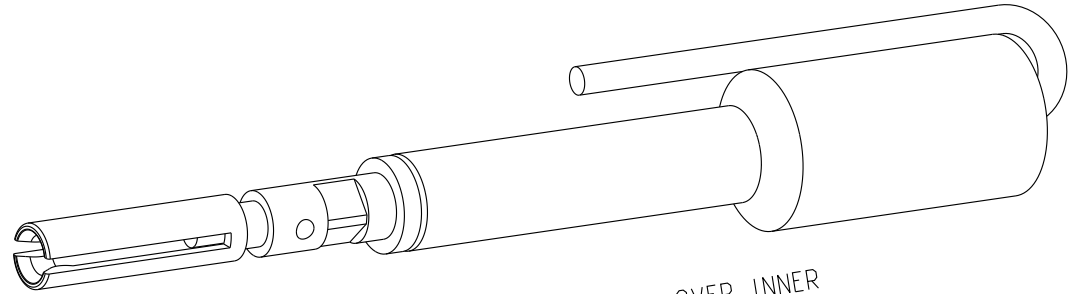
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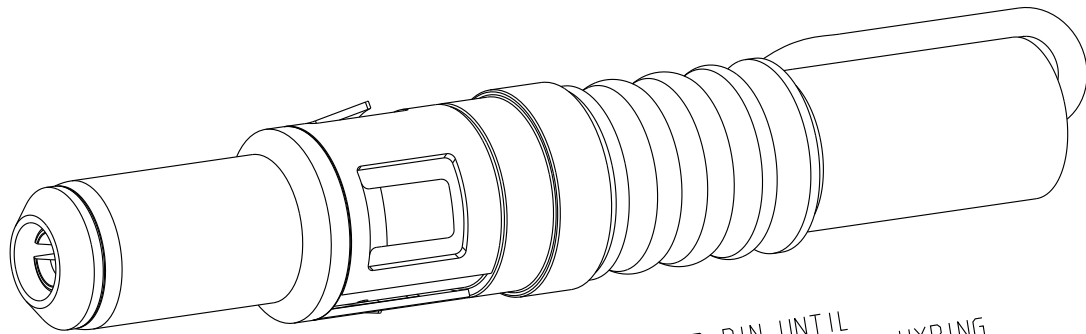
A



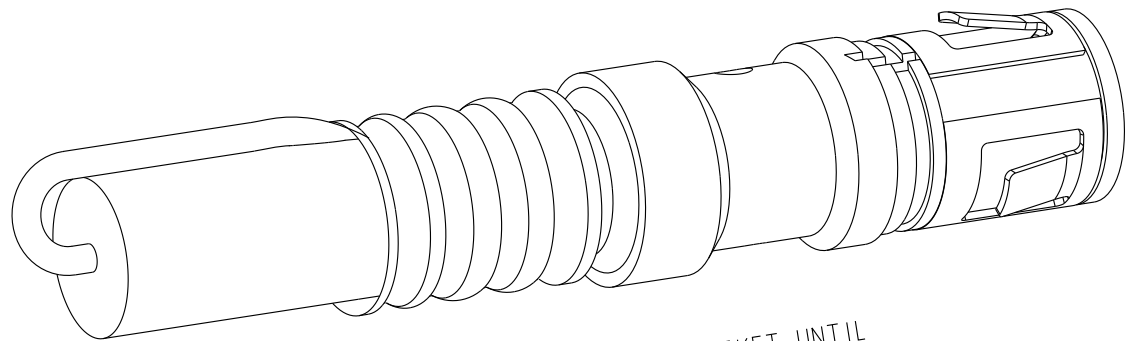
- STEP 1
- A. SLIDE SUPPORTING SLEEVE RCMXB053 OVER INNER WIRE ON RESISTOR/CAPACITOR.
 - B. ASSEMBLE INNER PIN RMM20W-1 TO WIRE AND CRIMP USING N22RVMT-10.



- STEP 1
- A. SLIDE SUPPORTING SLEEVE RCMXB053 OVER INNER WIRE ON RESISTOR/CAPACITOR.
 - B. ASSEMBLE INNER SOCKET RFM20W-1 TO WIRE AND CRIMP USING N22RVMT-10.



- STEP 2
- A. INSERT THE ASSEMBLY INTO THE OUTER PIN UNTIL THE INNER SOCKET SNAPS INTO PLACE. SLIDE OUTER HYRING OVER OUTER WIRE AND PLACE OUTER WIRE ON RESISTOR/CAPACITOR OVER THE BARREL.
 - B. SLIDE OUTER HYRING OVER BARREL OF OUTER PIN. OUTER WIRE SHOULD NOW BE BETWEEN THE BARREL OF THE OUTER PIN AND THE OUTER HYRING.
 - C. CRIMP THE OUTER HYRING USING N22RVMT-10



- STEP 2
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-	ALL REVISIONS RECORDED ON SHT 1	-	-
REV	DESCRIPTION	BY DATE	CHKD DATE

DRAWING TITLE
ASSY. PROCEDURE FOR MINIATURE COAX HYFEN

CAT NO. **RCMX --- & RMMX ---**

CAGE NO: 09922 SIZE: C

CUSTOMER		SOURIAU	
INTERPRET THIS DRAWING IN ACCORDANCE WITH ASME Y14.5M - 1994.		WWW.SOURIAU.COM	
DRAWN: SKV	08-16-13	APPROVAL	
CHKD : TW	08-16-13		
DSGN : XXX	mm-dd-yy		
MFG : DH	08-16-13		
QC : BB	08-16-13		
DRAWING SCALE: 5:1			
DRAWING NO.		REV	
SD44088		AD	
7 OF 7			