

CONNECTOR			CABLE TYPE	CRIMP CLOSURE	DIMENSIONS			
TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	MILITARY PART NUMBER (M39012/57B)			DIM. A (I.D.)	DIM. B (I.D.)	DIM. C (I.D.)	DIM. D (I.D.)
1051904-1	2032-8011-92	3011	RG178/U	A	.022 In.	.022 In.	.037 In.	.101 In.
1051905-1	2032-8012-92	3012	RG174/U RG316/U	C	.022 In.	.022 In.	.067 In.	.128 In.
1051911-1	2032-8018-92	3018	RG178/U	A	.022 In.	.022 In.	.037 In.	.101 In.
1051912-1	2032-8019-92	3019	RG174/U RG316/U	C	.022 In.	.022 In.	.067 In.	.128 In.

Figure 1

1. INTRODUCTION

These instructions cover the assembly of the SMA Straight Cable Jacks listed in Figure 1. Figure 1 also lists the cable types required for the various connectors, as well as the crimp closure, and the dimensions of the various connectors.

All of these connectors are used in crimp type applications.

Tooling required for the application is listed in Figure 2.

TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	DESCRIPTION
1055463-1	2098-5237-10 (T-4579)	Center Contact Holder
1055236-1	2096-0105-54	Crimp Tool

Figure 2

NOTE

Dimensions in this document are in metric units [with U.S. customary units in brackets], unless otherwise specified.

NOTE

Reasons for revision can be found in SECTION 3.

2. ASSEMBLY

2.1. Preparing the Coaxial Cable End (Figure 3)

1. Place the outer sleeve (ferrule) on the cable.
2. Remove the end portion of the cable jacket to expose the the cable braid.
3. Trim the outer conductor to length, as shown in Figure 3.
4. Trim the inner conductor to length, as shown in Figure 3.
5. Flare the cable braid.

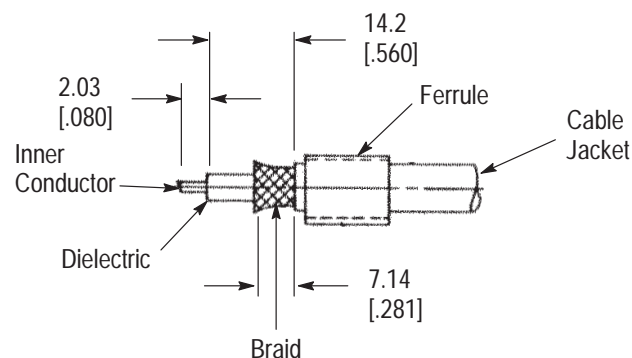


Figure 3

2.2. Crimping Cable to Inner Sleeve (Figure 4)

1. Tin the inner conductor of the cable.
2. Assemble the inner sleeve into the clamp nut.
3. Position and secure the inner sleeve in a bench vise.
4. Insert the dielectric into the inner sleeve and seat firmly.
5. Slide the ferrule over the cable braid.
6. Hold the cable (firmly seated) and crimp the ferrule in place.
7. Trim and remove the excess cable braid.
8. If necessary, trim the cable dielectric flush to the face of the inner sleeve.

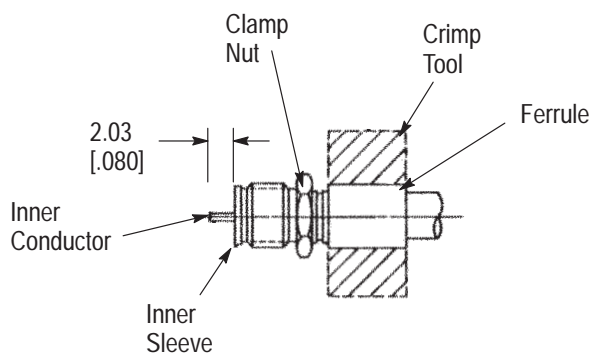


Figure 4

2.3. Soldering Center Contact to Cable Inner Conductor

1. Place the center contact in the center contact holder (see Figure 2) and push it over the the inner conductor of the cable to seat it firmly against the rear of the rear dielectric.
2. Heat as shown in Figure 5.
3. Remove excess solder.

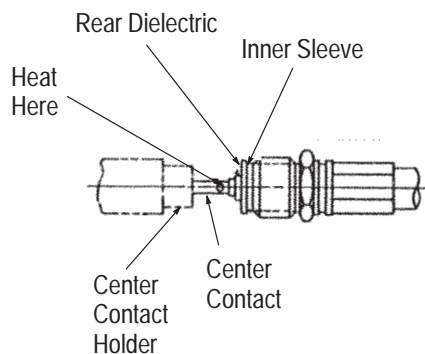


Figure 5

2.4. Securing Housing to Inner Sleeve Subassembly

1. Carefully insert the center contact into the dielectric bushings of the housing subassembly.
2. Engage the threads of the clamp nut to the housing and tighten to approximately 12 to 15 inch-pounds.

Adherence to the steps in these instructions should result in a completed assembly resembling Figure 6.

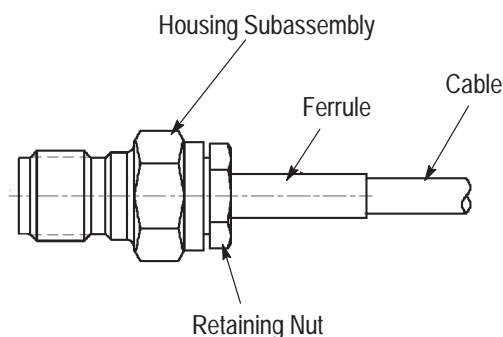


Figure 6

3. REVISION SUMMARY

The following changes were made per EC 0990-0287-04:

- Corrected Figure 2
- The format was updated to the current corporate requirements.