

PLUG PART NUMBER		MILITARY PART NUMBER M39012/56-	CABLE (RG/U)	PLUG DIMENSION (mm [in.])	
CURRENT	PREVIOUS			A	B
1052149-1	2037-8006-92	3006	178	0.94 [.037]	2.57 [.101]
1052179-1	2037-8106-92	3106■			
1052152-1	2037-8008-92	3008	122	2.54 [.100]	4.45 [.175]
1052182-1	2037-8108-92	3108■			

■ No Safety Wire Holes

Figure 1

## 1. INTRODUCTION

SMA right-angle cable plugs (solder attachment) listed in Figure 1 are designed to be soldered to the corresponding cable sizes.

The following tool is optional:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Locator Tool	1055451-1	2098-5218-02 (T-2367)

### NOTE

Dimensions in this instruction sheet are in millimeters [with inches 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 plug consists of the components shown in Figure 1. The housing subassembly contains a contact.

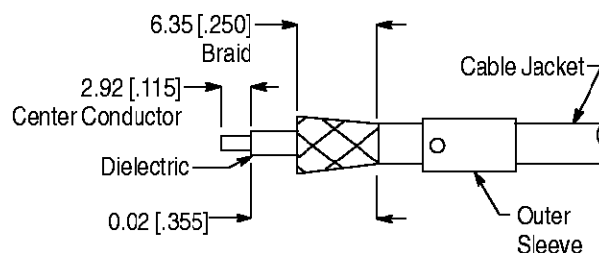
## 3. ASSEMBLY PROCEDURE

### DANGER

Follow safety precautions included with the tools used for assembly.

1. Slide the outer sleeve onto the cable.

2. Strip the cable to the dimensions shown in Figure 2. Flare the cable braid.



Note: Not to Scale

Figure 2

3. Secure the housing subassembly to the locator tool as shown in Figure 3. Secure the housing subassembly in a small bench vise.

4. Tin the cable center conductor.

5. Insert the center conductor into the housing subassembly making sure that the center conductor sits in the contact slot and the dielectric is against the contact. See Figure 3.

6. Place the soldering iron on the tip of the contact, and solder. Refer to Figure 3.

7. Slide the outer sleeve over the cable braid, and solder the hole in the outer sleeve. See Figure 3. Trim excess braid strands.

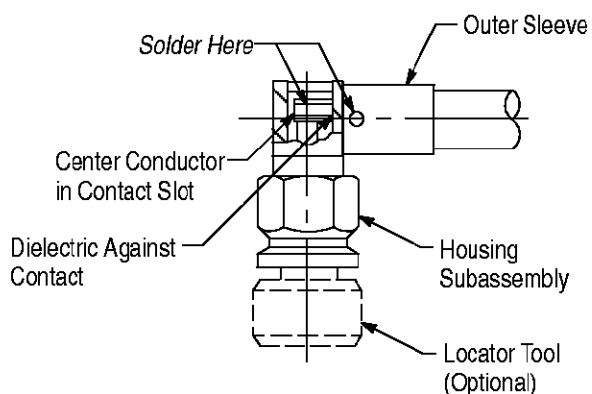


Figure 3

8. Press the disc into the opening at the back of the housing subassembly. See Figure 4. Remove the assembly from the locator tool. If preferred, apply epoxy to the disc to hold it in place. DO NOT allow epoxy to penetrate the housing subassembly.

**NOTE**

*Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/56.*

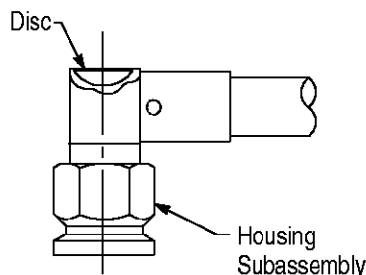


Figure 4

#### 4. REPLACEMENT AND REPAIR

DO NOT re-use any soldered components by removing the cable. DO NOT re-use the disc after it has been assembled to the plug.

Components of the plug are not repairable. DO NOT use any defective or damaged components.

#### 5. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0470-03 include:

- Updated document to corporate requirements