

PLUG PART NUMBER		MILITARY PART NUMBER M39012/79-
CURRENT	PREVIOUS	
1050803-1	2001-8311-92	3311

Figure 1

1. INTRODUCTION

The SMA straight cable plug (compression crimp attachment) shown in Figure 1 is designed to be crimped to semi-rigid coaxial cable size RG 405/U with a diameter of 2.16 mm [.085 in.] using the following tool:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Compression Crimp Tool kit (408-8536)	1055835-1	2598-5200-54

The following tool is optional:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Hand Trim and Point Tool	1055815-1	2598-5120-54

NOTE Production tooling is available upon request.



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 a connector assembly with an internal contact, coupling nut, and rear bushing. See Figure 1.

3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

1. Strip the cable within the dimension given in Figure 2.

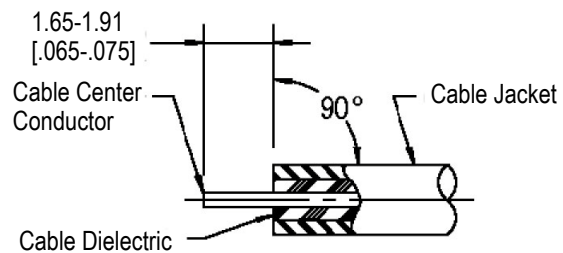


Figure 2

File the blunt end of the cable center conductor to an 85° to 90° cone. Refer to Figure 3.

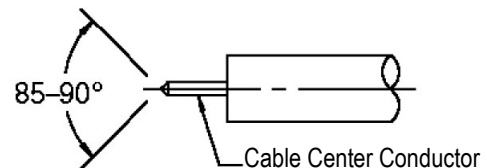


Figure 3

1. Install the .085 S.R. lower cable support and the SMA/M anvil into the crimp tool. Set the tool crimp length to .278.

2. Carefully insert the cable center conductor into the connector assembly (making sure to enter the contact) until the cable bottoms on the internal shoulder of the connector assembly.

3. Place the connector assembly in the crimp tool so that the connector reference plane (shown in Figure 1) of the connector assembly is against the anvil and the cable sits in the lower cable support. See Figure 4.



To prevent the rear bushing from hitting the coupling nut during crimping, pull the coupling nut toward the crimp tool, and hold the crimp tool in a slightly vertical position (so that the coupling nut does not slide back).

4. Actuate the crimp tool according to the instructions packaged with the crimp tool.

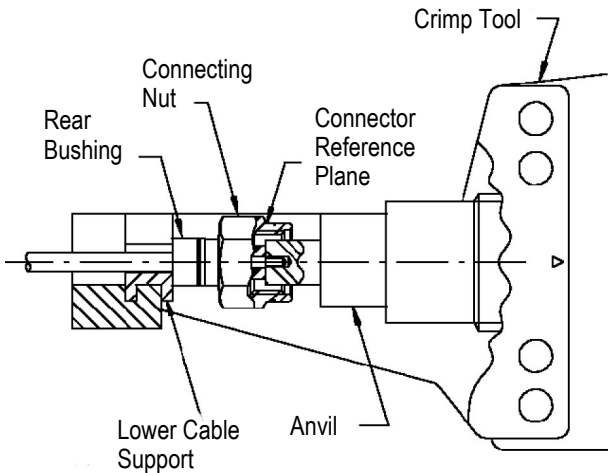


Figure 4

5. Remove the plug from the crimp tool, and inspect the plug according to Figure 5



Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/79.

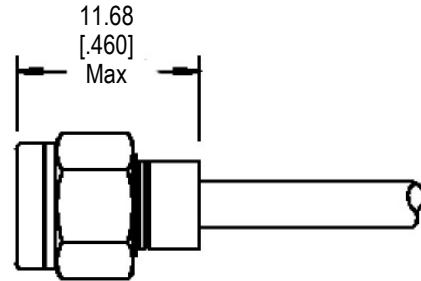


Figure 5

4. REPLACEMENT AND REPAIR

DO NOT re-use a crimped plug by removing the cable. The plug is not repairable. DO NOT use any defective or damaged plugs.

5. REVISION SUMMARY

Since the previous release of this document, the TE logo has been applied