

CURRENT PLUG PART NUMBER	PREVIOUS PLUG PART NUMBER
1051120-1	2007-5116-02

Figure 1

1. INTRODUCTION

SMA right-angle cable plug (solder 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	CURRENT (TE) PART NUMBER	PREVIOUS PART NUMBER
Locator Tool	1055451-1	2098-5218-02

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 housing subassembly, disc, and bullet center contact. See Figure 1.

3. ASSEMBLY PROCEDURE

NOTE *Follow safety precautions included with the tools used for assembly.*

- Strip the cable to the dimensions shown in Figure 2.
- Tin the cable center conductor.
- Insert the center conductor into the bullet center contact until it rests firmly against the cable dielectric. Solder the bullet center contact. Remove excess solder. See Figure 3.

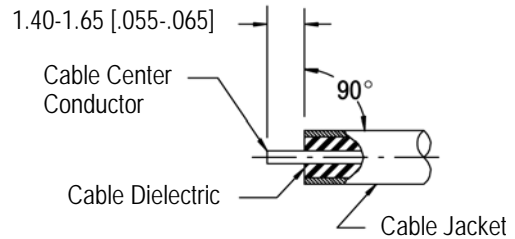


Figure 2

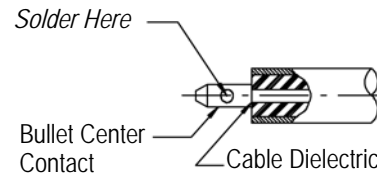


Figure 3

4. Secure the housing subassembly to the locator tool as shown in Figure 4. Secure the housing subassembly in a small bench vise.

5. Insert the bullet center contact into the housing subassembly, making sure that the bullet center contact sits in the contact slot. See Figure 4, View A. Place the soldering iron on the tip of the bullet center contact, and solder.

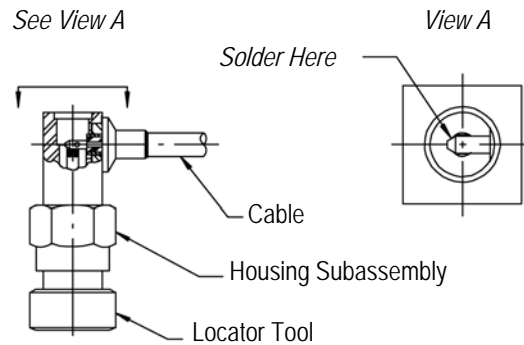


Figure 4

6. Solder the housing subassembly to the cable at the location shown in Figure 5. A protrusion of the cable dielectric as a result of the heat is acceptable. See Figure 5, View A.

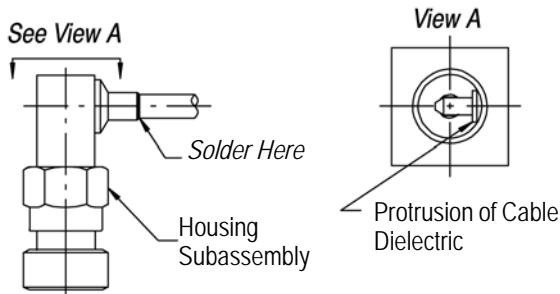


Figure 5

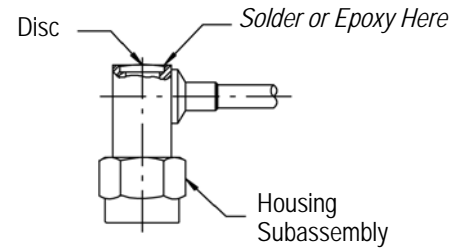


Figure 6

7. Press the disc into the opening at the back of the housing subassembly. Refer to Figure 6, and seal the opening as follows:

Option 1: Tin the perimeter of the opening, and press the disc into position. Apply heat to the disc. **DO NOT** allow the solder to penetrate the housing subassembly.

Option 2: Epoxy the disc into place. **DO NOT** allow the epoxy to penetrate the housing subassembly.

4. REPLACEMENT AND REPAIR

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

Components of the plug are not repairable. Replace any defective or damaged components.

5. REVISION SUMMARY

Since the previous release of these instructions, the new company logo was applied.