

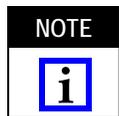
Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Bulkhead Feedthrough Cable Jack (Direct Solder Attachments) 1051023-1 and 1051027-1, which are applied onto RG 402/U (.141) semi-rigid coaxial cable.

The table below represents tool numbers applicable to this instruction sheet. The table references the tool description, the previous part number, and the TE part number.

TOOLING		
DESCRIPTION	TE PART NUMBER	PREVIOUS PART NUMBER
Fixture Base	1055439-1	2098-5206-54
Clamp Insert	1055440-1	2098-5207-54
Center Contact Holder	1055454-1	2098-5221-10
Solder Gage	91362-6	2098-5516-02
Locator Tool	1055443-1	2098-5210-02
Dielectric Insert Tool	1055448-1	2098-5215-02



Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue of this document are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The SMA bulkhead feedthrough cable jack direct solder attachments consist of a mounting nut, lockwasher, "O" ring, dielectric, housing, and center contact.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Cable (Figure 2)

1. Insert squared cable end into fixture base hole pattern No. 2.
2. Place saw in saw slot and cut through outer conductor and into dielectric while rotating cable.
3. Remove cable from fixture and finish cutting dielectric with cutting blade.
4. Bare inner conductor by prying cut outer conductor and dielectric from cable.
5. Complete trimming of cable inner conductor to dimension shown in Figure 2.

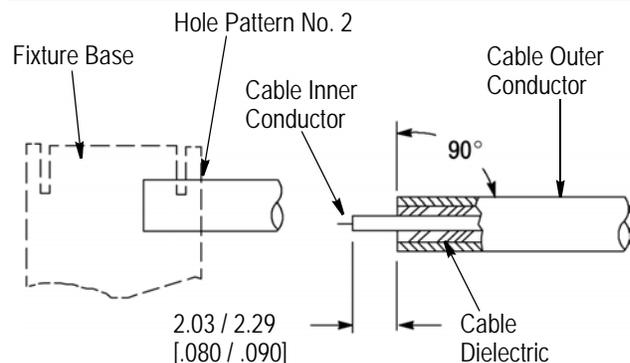


Figure 2

3.2. Soldering of Center Contact to Cable Inner Conductor (Figure 3)

1. Tin inner conductor of cable.
2. Place solder gage on inner conductor flush with end of outer conductor.

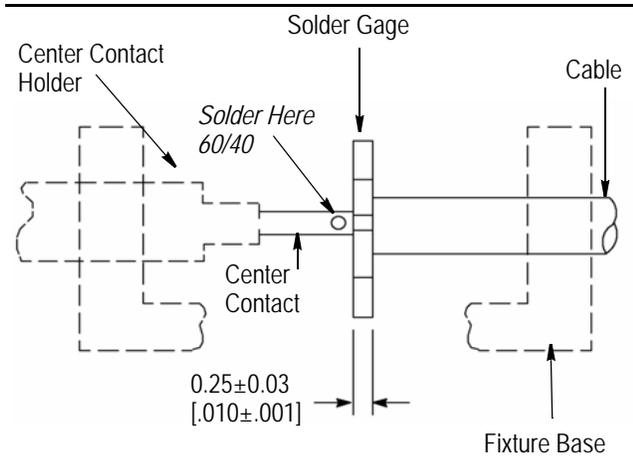


Figure 3

3. Place center contact in holder, heat center contact, and push it over inner conductor of cable to rest firmly against solder gage.
4. Remove solder gage and excess solder.

3.3. Soldering of Cable Sub-Assembly to Housing (Figure 4)

1. Place connector housing on end of cable sub-assembly.
2. Place loose assembly in fixture base as shown in Figure 4.
 - a. Nest center contact in locator tool.
 - b. Tighten clamp screw to secure cable.
 - c. Tighten locator tool to seat cable firmly.

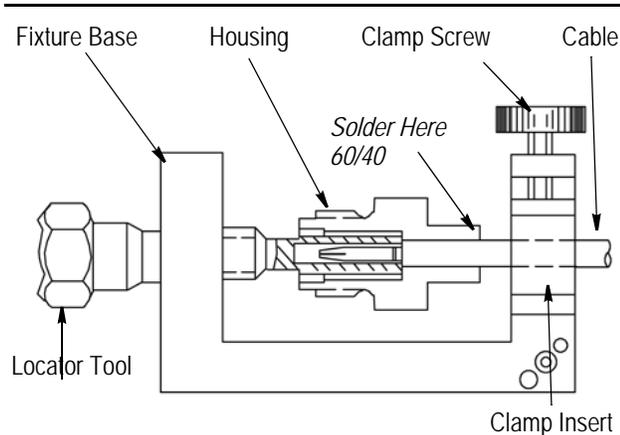


Figure 4

3. Slide housing over locator tool.
4. Maintain position of housing firmly against locator tool and solder.

NOTE *Fixture should be clamped vertically in vise to keep housing seated against locator tool.*

3.4. Pressing of Dielectric Bushing into Housing Sub-Assembly (Figure 5)

1. Thread insert tool onto housing sub-assembly.
2. Insert dielectric into insert tool housing.
3. Place insert tool plunger into position and press until flange bottoms on tool housing.
4. Assembly is now complete.

CAUTION *Damaged components must not be used. They must be replaced with new components.*

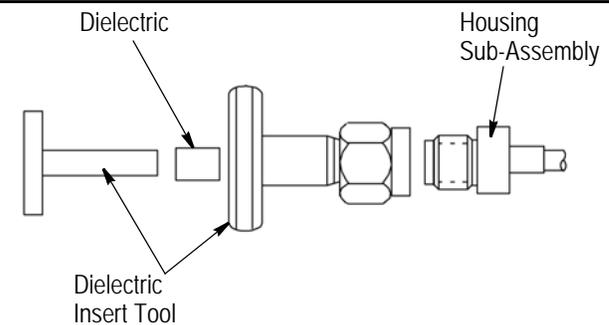


Figure 5

4. MILITARY INFORMATION

MILITARY PART NUMBER (M39012/83)	TE PART NUMBER	PREVIOUS PART NUMBER
B3002	1051023-1	2004-8002-90
-3006	1051027-1	2004-8006-90

5. REVISION SUMMARY

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