

PLUG					CABLE (RG/U)	CRIMP DIE For Military Tool Frame M22520/5-01	
PART NUMBER		MILITARY M39012/56-	DIMENSION (mm [in.])			M22520/5-	CLOSURE
CURRENT	PREVIOUS		A	B			
1052171-1	2037-8025-92	3025	0.94 [.037]	2.57 [.101]	178	03	B
1052201-1	2037-8125-92	3125†			178	33	
1052173-1	2037-8026-92	3026	1.70 [.067]	3.25 [.128]	174	03	A
1052203-1	2037-8126-92	3126			316	35	B
1052174-1	2037-8027-92	3027	2.54 [.100]	4.45 [.175]	122	05	B
1052204-1	2037-8127-92	3127†			122	09	A
1052176-1	2037-8028-92	3028	3.10 [.122]	5.56 [.219]	142	05	A
1052206-1	2037-8128-92	3128			223	11	
1052177-1	2037-8029-92	3029	3.10 [.122]	5.21 [.205]	58	19	B
1052207-1	2037-8129-92	3129			303	57	A

† No Safety Wire Holes

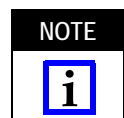
Figure 1

1. INTRODUCTION

SMA right-angle cable plugs (crimp attachment) listed in Figure 1 are designed to be attached to the coaxial cable type and size listed using the corresponding tooling listed. The following tool is optional:

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

In addition, a small bench vice and soldering iron will be needed for assembly of the cable plug.



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

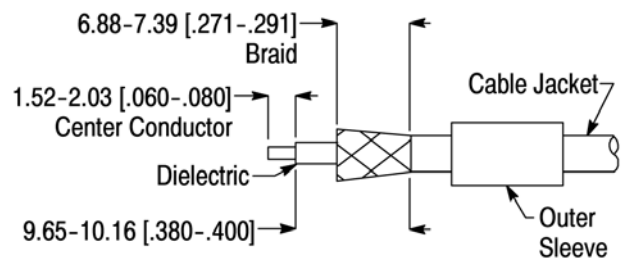
Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION

Each cable plug consists of the components shown in Figure 1. The housing subassembly contains a contact.

3. ASSEMBLY PROCEDURE

- Slide the outer sleeve onto the cable.
- Strip the cable to the dimensions given in Figure 2. Flare the cable braid.



Note: Not to Scale

Figure 2

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

- 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 is flush to below 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 crimp the outer sleeve in place. Trim excess braid strands. Refer to Figure 3. Remove the assembly from the crimp tool.
8. *Manually* press the disc into the opening at the back of the housing subassembly. See Figure 4.



The disc and housing subassembly are not made of solderable material. DO NOT solder or epoxy the disc to the housing subassembly.

9. Remove the locator tool.

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

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 to the cable plug.

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

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Removed instruction to epoxy disc from, and added manually and CAUTION to Step 8 of Section 2

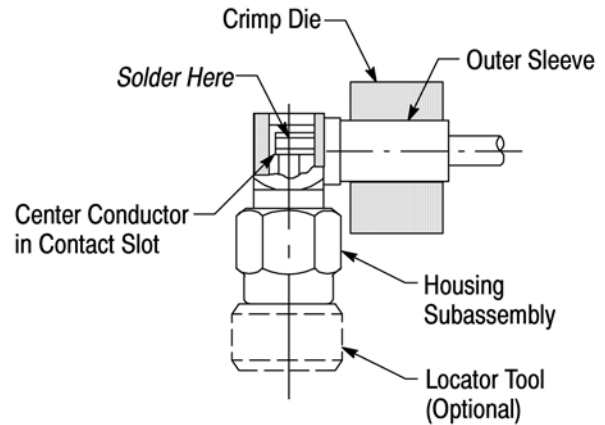


Figure 3

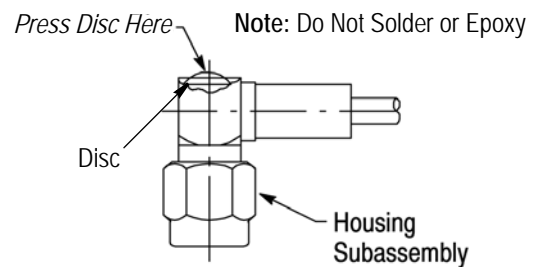


Figure 4