

JACK PART NUMBER		MILITARY PART NUMBER M39012/59-	CABLE (RG/U)	CRIMP DIE		JACK DIMENSION (mm [in.])			
CURRENT	PREVIOUS			MILITARY PART NUMBER M22520/5-	CLOSURE	A	B	C	D
1051986-1	2034-8012-92	3012 (Category B)	174, 316	03	A	0.56 [.022]	0.56 [.022]	1.70 [.067]	3.25 [.128]
				35	B				
1051987-1	2034-8018-92	3018 (Category B)	178	03	B	0.56 [.022]	0.56 [.022]	0.94 [.037]	2.57 [.101]
				33	B				
1051988-1	2034-8019-92	3019 (Category B)	174, 316	03	A	0.56 [.022]	0.56 [.022]	1.70 [.067]	3.25 [.128]
				35	B				
1051992-1	2034-8025-92	3025 (Category C)	178	03	B	0.56 [.022]	0.56 [.022]	0.94 [.037]	2.57 [.101]
				33	B				
1051994-1	2034-8026-92	3026 (Category C)	174, 316	03	A	0.56 [.022]	0.56 [.022]	0.94 [.037]	3.25 [.128]
				35	B				

Figure 1

## 1. INTRODUCTION

SMA bulkhead feed-through cable jacks (crimp attachment) listed in Figure 1 are designed to be terminated to the corresponding coaxial cable using the corresponding crimp die and the following tools:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Center Contact Holder	1055454-1	2098-5221-10 (T-4578)

TOOL DESCRIPTION	MILITARY PART NUMBER M22520/5-
Crimp Tool	01

**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 6, REVISION SUMMARY.

## 2. DESCRIPTION

The jack consists of the components shown in Figure 1. Jack 1051986-1 does not include a bushing.

## 3. ASSEMBLY PROCEDURE

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

1. Slide the ferrule onto the cable.
2. Strip the cable to the dimensions shown in Figure 2. Take care not to nick any part of the cable. Flare the braid.

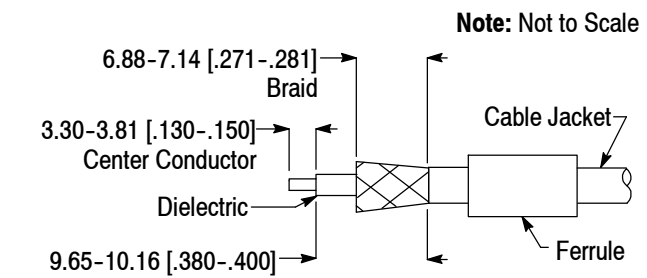


Figure 2

3. Tin the cable center conductor.
4. Assemble the inner sleeve onto the clamp nut. Secure the inner sleeve to a small bench vise.
5. Insert the cable dielectric into the inner sleeve until it is firmly seated.

6. Slide the ferrule over the cable braid. Hold the cable in position, and crimp the ferrule. Trim excess braid strands. If necessary, trim the cable dielectric so that it is flush with the inner sleeve. See Figure 3.

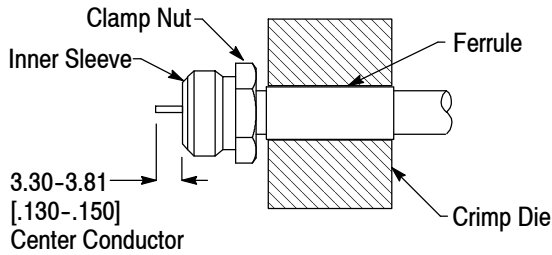
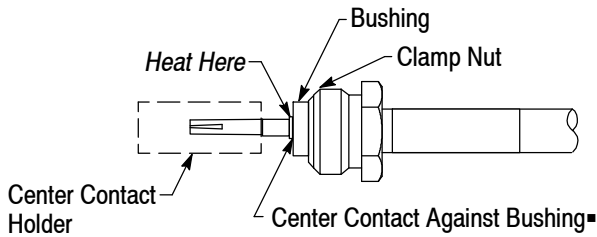


Figure 3

7. Slide the bushing over the center conductor. This step is not necessary for Jack 1051986-1.

8. Place the center contact in the center contact holder. Heat the center contact with a soldering iron, then carefully push the center contact over the center conductor until it rests firmly against the bushing or, for Jack 1051986-1, the cable dielectric. See Figure 4. Remove excess solder.



▪ Center Contact Against Cable Dielectric for Jack 1051986-1

Figure 4

9. Carefully insert the center contact into the dielectric. Insert the dielectric into the housing.

10. Thread the housing onto the clamp nut. Tighten to a torque between 1.4 and 1.7 N•m [12 and 15 in.-lbs]. See Figure 5.



**NOTE** Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/59.

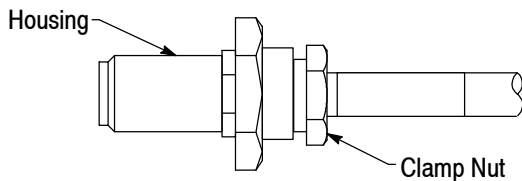


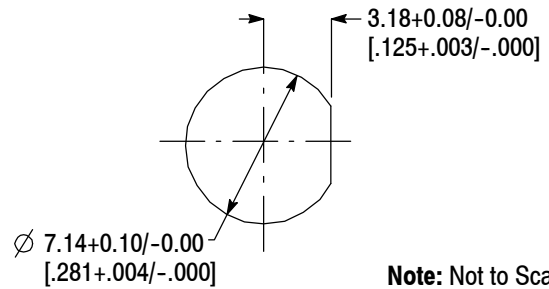
Figure 5

#### 4. PANEL MOUNTING

1. Cut the panel using the dimensions provided in Figure 6.

2. Install the O-ring onto the front of the housing. Insert the housing through the panel cutout until the O-ring is flat against the panel. Install the lockwasher and mounting nut onto the front of the housing. Tighten the mounting nut. Refer to Figure 6.

##### Recommended Panel Cutout



Note: Not to Scale

##### Mounting the Jack

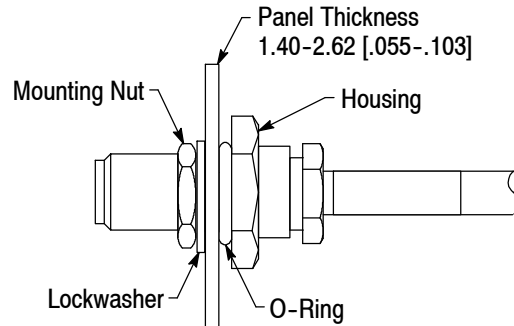


Figure 6

#### 5. REPLACEMENT AND REPAIR

DO NOT re-use any soldered or crimped components by removing the cable.

Components of the jack are not repairable. Remove and replace any defective or damaged components.

#### 6. REVISION SUMMARY

- Updated document to corporate requirements
- New logo