

CABLE JACK PART NUMBER			DIAMETER (mm [in.])				CABLE SIZE RG/U
CURRENT	PREVIOUS	MILITARY M39012/59-	A	B	C	D	
1051981-1	2034-8006-92	3006	0.56 [.022]	0.56 [.022]	0.94 [.037]	2.57 [.101]	178
1051982-1	2034-8007-92	3007			1.70 [.067]	3.25 [.128]	174, 316

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedure for SMA Bulkhead Feedthrough Cable Jack Solder Attachments 1051981-1 and 1051982-1, which are designed to be applied onto coaxial cable sizes listed in Figure 1.

An optional tool applicable to these cable jacks is given in Figure 2.

DESCRIPTION	PART NUMBER	
	CURRENT	PREVIOUS
Center Contact Holder	1055454-1	2098-5221-10

Figure 2



*Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets].
Figures are not drawn to scale.*

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

Each cable jack consists of a mounting nut, lockwasher, "O" ring, housing subassembly, dielectric, center contact, back-up bushing, inner sleeve, retaining nut, and outer sleeve.

3. ASSEMBLY PROCEDURE

3.1. Preparing Coaxial Cable

1. Slide the outer sleeve onto the cable.

2. Remove the end portion of the cable jacket to expose the outer conductor.

3. Trim the cable outer conductor, dielectric, and inner conductor to the dimensions given in Figure 3.

4. Flare the cable outer conductor.

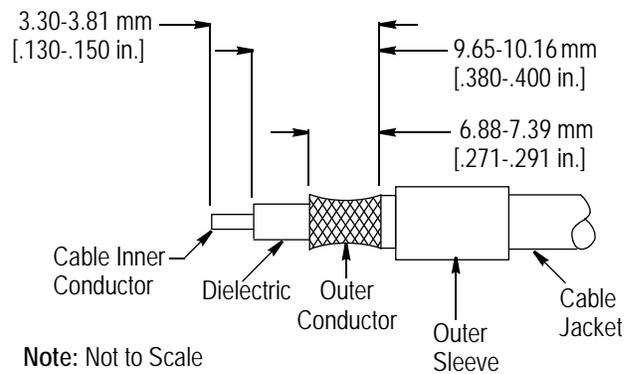


Figure 3

3.2. Soldering Cable to Inner Sleeve (Figure 4)

1. Tin the cable inner conductor.
2. Position and secure the inner sleeve in a small bench vise.
3. Insert the cable into the inner sleeve and seat firmly.
4. Slide the outer sleeve over the flared portion of the cable outer conductor.
5. Hold the cable firmly seated, and solder the outer sleeve in place.

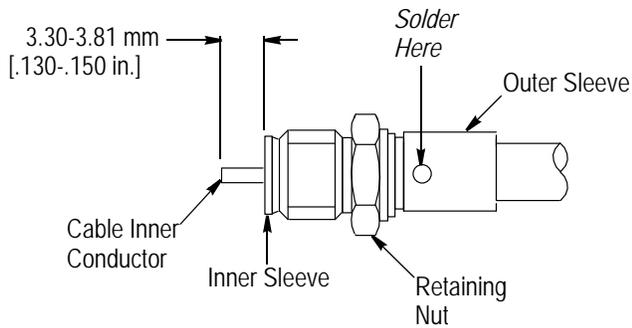


Figure 4

6. Trim and remove the excess cable outer conductor strands.

3.3. Soldering Center Contact to Cable Inner Conductor
(Figure 5)

1. Place the center contact in the holder, heat the center contact and push it over the inner conductor of the cable to rest firmly against the back-up bushing.
2. Remove excess solder.

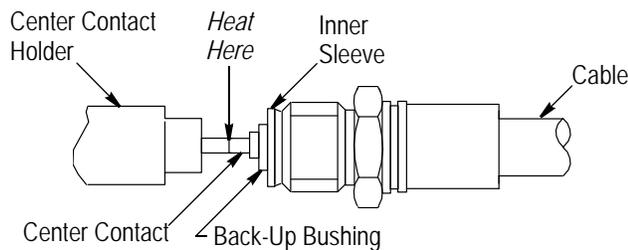


Figure 5

3.4. Securing Housing Subassembly to Inner Sleeve
(Figure 6)

1. Assemble the dielectric over the center contact.
2. Engage the threads of the inner sleeve to the housing subassembly, and tighten to a torque from 1.36 to 1.70 Nm [12 to 15 in-lb].

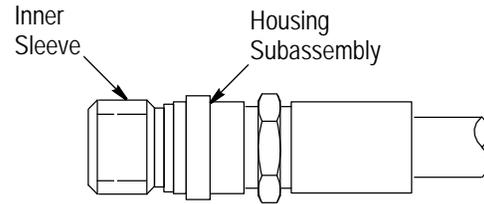


Figure 6



Do not use damaged or defective components. Replace them with new components.

3.5. Mounting Cable Jack

Mount the cable jack onto the panel using the “O” ring, lockwasher, and mounting nut.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo
- Added dielectric to Figure 1
- Changed “clamp nut” to “retaining nut” in Figure 4
- Changed “rear dielectric” to “back-up bushing” in Step 1 of Paragraph 3.3 and Figure 5
- Added Paragraph 3.5