

TE PART NO.	PREVIOUS PART NO.	MIL PART NO. M39012/5B	CABLE TYPE	DIM. "A"	DIM. "B"	DIM. "C"	DIM. "D"
1052037-1	2036-8006-92	-3006	RG178/U	0.559 [.022]	0.559 [.022]	0.94 [.037]	2.57 [.101]
1052038-1	2036-8007-92	-3007	RG174/U RG316/U	0.559 [.022]	0.559 [.022]	1.7 [.067]	3.25 [.128]

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for SMA Straight Cable Jacks 1052037-1 and 1052038-1, shown in Figure 1. These connectors are solder attachment type connectors that attach to the cable types listed in Figure 1. Refer to Figure 1 for the "A," "B," "C," and "D" dimensions.

NOTE
 Dimensions on this sheet are in millimeters [with inches in brackets], unless otherwise specified. Figures are not drawn to scale.

Reasons for re-issue can be found in Section 3, REVISION SUMMARY.

2. ASSEMBLY PROCEDURES

2.1. Preparing the Cable

- Place the outer sleeve on the cable as shown in Figure 2.

DANGER
 To prevent personal injury, be sure to follow all local safety practices when cutting the cable.

- Cut and remove end portion of the cable jacket to expose the cable braid.
- Trim the cable braid to length, as shown in Figure 2.

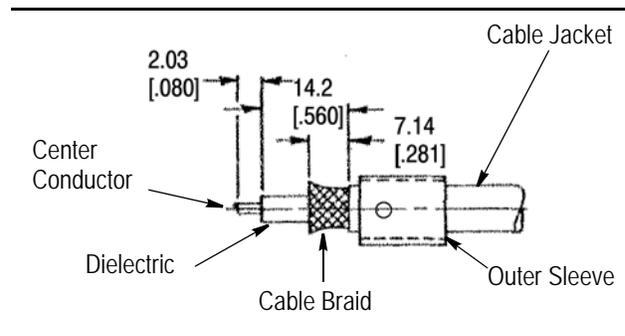


Figure 2

- Trim the dielectric to length, as shown in Figure 2.

- Trim the center conductor to length, as shown in Figure 2.

- Flare the cable braid.

2.2. Soldering Cable to Inner Sleeve Assembly

DANGER
 To prevent personal injury, be sure to exercise caution when using soldering equipment.

- Tin the inner conductor.
- Position and secure the inner sleeve sub-assembly in a small bench vise.
- Insert the cable into the inner sleeve sub-assembly and seat it firmly.

4. Slide the outer sleeve over the flared portion of the cable braid.
5. Hold the cable firmly seated, and solder the outer sleeve in place. See Figure 3.
6. Trim and remove excess outer conductor strands.

2.3. Soldering Center Contact to Cable Center Conductor



To prevent personal injury, be sure to exercise caution when using soldering equipment.

1. Place center contact in optional center contact holder 1055454-1 (T-4578).
2. Heat the center contact and push it over the center conductor of the cable to rest firmly against the rear dielectric. See Figure 4.
3. Remove excess solder.

2.4. Securing Housing to Inner Sleeve Subassembly

1. Assemble the dielectric over the center contact.
2. Engage the threads of the inner sleeve subassembly to the housing.
3. Tighten to 12 to 15 inch-pounds.

3. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo

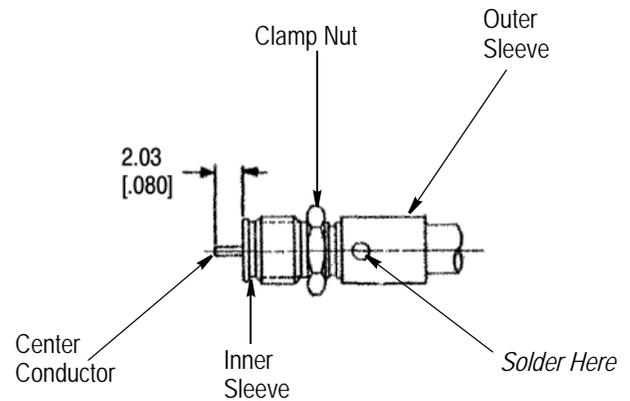


Figure 3

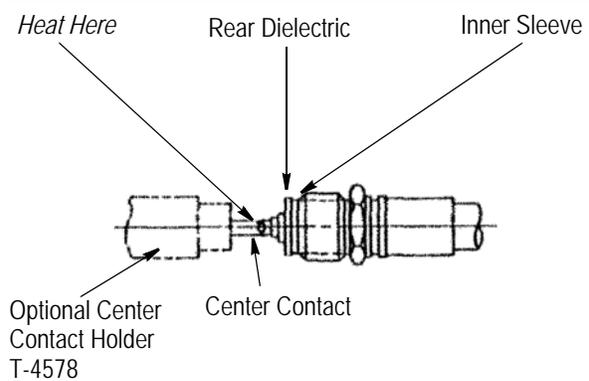


Figure 4