

PLUG PART NUMBER		MILITARY PART NUMBER M39012/56-	CABLE (RG/U)	PLUG DIMENSION mm [In.]		CABLE STRIP LENGTH mm [In.] (Refer to Figure 2)		
CURRENT	PREVIOUS			A	B	C	D	E
1052151-1	2037-8007-92	3007	174, 316	1.70 [.067]	3.25 [.128]	6.35 [.250]	8.26 [.325]	2.79 [.110]
1052181-1	2037-8107-92	3107♦						
1052154-1	2037-8009-92	3009	58, 142, 223	3.10 [.122]	5.56 [.219]	6.35 [.250]	10.67 [.420]	2.79 [.110]
1328196-1								
1052184-1	2037-8109-92	3109♦	58, 142, 223	3.10 [.122]	5.56 [.219]	6.35 [.250]	10.67 [.420]	2.79 [.110]
1052155-1	2037-8010-92	3010	303	3.10 [.122]	5.56 [.219]	6.35 [.250]	10.67 [.420]	2.79 [.110]
1052185-1	2037-8110-92	3010♦						
--	2037-8030-92	3030	316 (Double Braid)	1.70 [.067]	3.78 [.149]	6.35 [.250]	8.26 [.325]	2.79 [.110]
--	2037-8130-92	3030♦						

♦ No Safety Wires

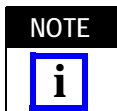
Figure 1

1. INTRODUCTION

SMA right-angle cable plugs listed in Figure 1 are designed to be soldered to the corresponding cable sizes.

The following tool is optional:

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



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

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

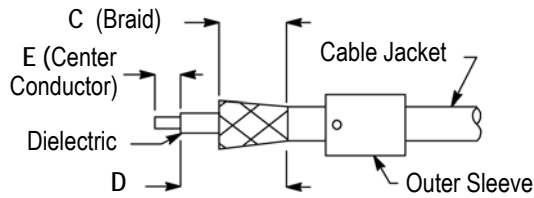
3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

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

Refer to Figure 1 for Dimensions



Note: Not to Scale

Figure 2

5. Insert the center conductor into the housing subassembly making sure that the center conductor sits in the contact slot and the dielectric is against the contact. See Figure 3.

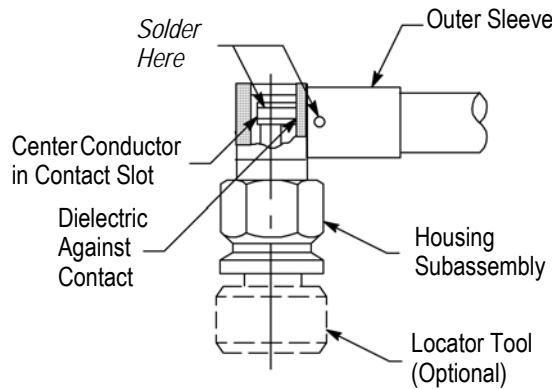


Figure 3

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 solder the hole in the outer sleeve. See Figure 3. Trim excess braid strands.

8. Press the disc into the opening at the back of the housing subassembly. See Figure 4. Remove the assembly from the locator tool. If preferred, apply epoxy to the disc to hold it in place. DO NOT allow epoxy to penetrate the housing subassembly.

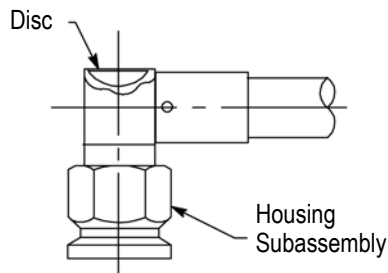
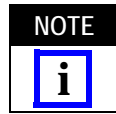


Figure 4



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 plug.

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

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo