

TE CONNECTIVITY PART NO.	PREVIOUS PART NO.	MILITARY P/N M39012/55-	CONNECTOR TYPE	CABLE TYPE	DIM. A (I.D.)	DIM. B (I.D.)	DIM. C (I.D.)
1051788-1	2031-8052-92	-3502	SMA Straight Cable Plug	RG 142/U	3.10 mm	1.04 mm	5.59 mm
1051817-1	2031-8162-92	-3602 <sup>†</sup>		RG/400/U	[.122 in.]	[.041 in.]	[.220 in.]

<sup>†</sup> No Safety Wire Holes

Figure 1

## 1. INTRODUCTION

This instruction sheet describes the use of the crimp-type SMA Straight Cable Plugs listed in Figure 1. These connectors can be used with the cable types listed in Figure 1. This figure also cross-references the previous part numbers, as well as the Military Part Numbers for these plugs.

Tooling required for these applications is listed in Figure 2.

TE PART NO.	MILITARY PART NO.	DESCRIPTION
601967-1	M22520/1-01	Center Contact Crimp Tool
--	M22520/1-15	Center Contact Crimp Die
--	M22520/5-01	Ferrule Crimp Tool
--	M22520/5-57 (Closure A)	Ferrule Crimp Die
1055454-1	--	Center Contact Holder

Figure 2

Reasons for revision can be found in Section 3, REVISION SUMMARY.

## 2. ASSEMBLY

### 2.1. Preparing the Cable End (Figure 3)

1. Place the outer sleeve (ferrule) on the cable.
2. Remove the end portion of the cable jacket to expose the cable braid.
3. Trim the cable braid to length.
4. Trim the Dielectric to length.
5. Trim the inner conductor to length.
6. Flare the cable braid.

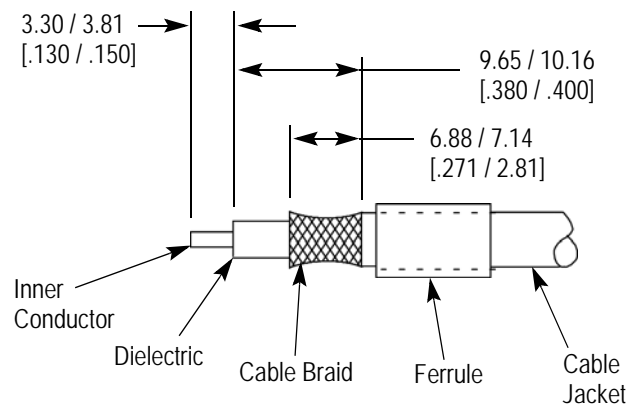


Figure 3

### 2.2. Crimping the Center Contact to the Cable Inner Conductor (Figure 4)

1. Set the selector knob on the tool to "3."
2. Bottom the center contact in the center contact positioner tool.
3. Bottom the cable inner conductor in the center contact.
4. Hold the cable firmly and crimp the center contact to the cable inner conductor.

### 2.3. Optional Soldering of the Center Contact

1. Tin the inner conductor of the cable.



*Be sure to follow appropriate local regulations -- including wearing gloves -- when using soldering equipment.*

2. Bottom the center contact in the center contact holder.
3. Push the center contact over the inner conductor (until it seats against the dielectric) and heat the center contact.
4. Remove excess solder.

### 2.4. Crimping the Cable Subassembly to the Housing Subassembly

1. Position and secure the housing subassembly in a small, bench vise.
2. Insert the cable subassembly into the housing and seat it firmly.
3. Slide the ferrule over the flared portion of the cable braid.
4. Hold the cable firmly and crimp the ferrule in place.
5. Trim and remove the excess cable braid.
6. Adherence to these procedures should yield the dimensions in M39012/55, Figure 2.

### 3. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Added dual dimensions to the table in Figure 1.
- Changed tool part number in Figure 2.
- Updated document to corporate requirements.

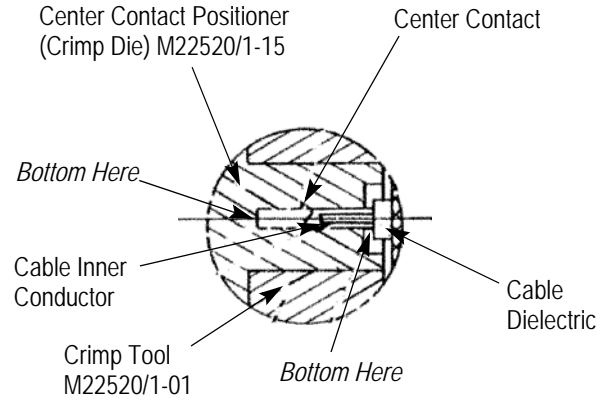


Figure 4

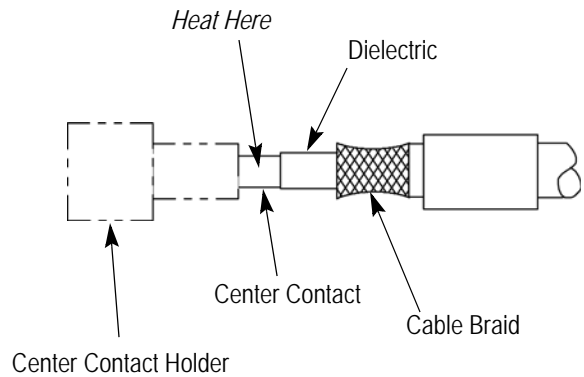


Figure 5

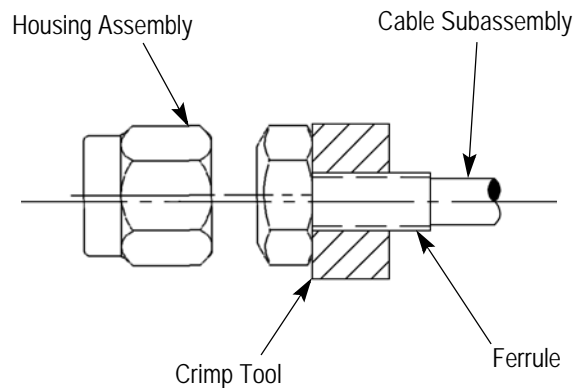


Figure 6