

Figure 1

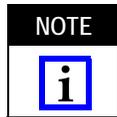
1. INTRODUCTION

SMA right-angle cable plugs (crimp attachment) 1051137-1, 1051139-1, and 1051144-1 are designed to be attached to flexible cable sizes RG 141/U, 180, 188, and 190 using the following tools:

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

Figure 2

In addition, a small bench vice and soldering iron will be needed for assembly of the cable plug.



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 4, REVISION SUMMARY.

2. DESCRIPTION

Each cable plug consists of the components shown in Figure 1.

3. ASSEMBLY PROCEDURE

3.1. Prepare Cable End

1. Place the clamp nut onto the cable.
2. To expose the cable outer conductor, remove the end portion of the cable jacket to the dimension given in Figure 3.
3. Trim the cable outer conductor, dielectric, and inner conductor to the dimensions given in Figure 3.
4. Flare the cable outer conductor.

3.2. Assemble Collar

1. Slide the collar between the cable outer conductor and the cable dielectric. See Figure 4.

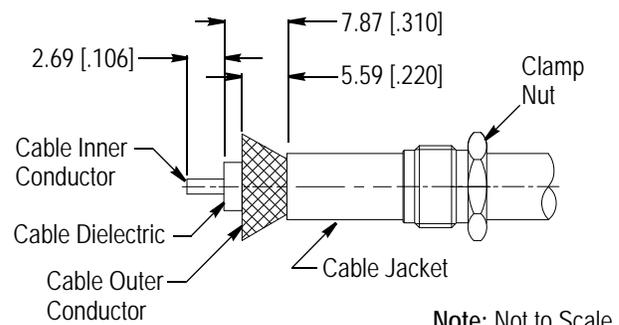
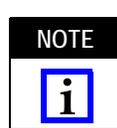


Figure 3



If desired, two 3.17 [.125] long slits can be cut in the cable jacket to ease assembly.

2. Trim the cable outer conductor flush with the shoulder of the collar.

3.3. Solder Housing Subassembly to Cable

1. Secure the threads of the housing subassembly to the locator tool. See Figure 4.
2. Secure the housing subassembly in a small bench vice.
3. Tin the cable inner conductor.
4. Insert the cable inner conductor into the contact slot of the housing subassembly.
5. Hold the cable dielectric and inner conductor flush as shown in Figure 4.
6. Slide the clamp nut over the collar, and thread it onto the housing subassembly. Tighten the clamp nut to a torque of 2.82 Nm [25 in.-lbs].
7. Place the soldering iron on the tip of the contact, then solder. Remove excess solder and splatter.

3.4. Install Cap onto Housing Subassembly

1. *Manually* press the cap into the opening at the back of the housing subassembly. See Figure 5.



The cap and housing subassembly are not made of solderable material. Do NOT solder or epoxy the cap to the housing subassembly.

2. Remove the locator tool.

Assembly is now complete.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo
- Updated instruction sheet to corporate requirements
- Changed OSM to SMA
- Added cable sizes to Section 1
- Removed obsolete cable jacks
- Corrected Step 1 of Paragraph 3.1
- Clarified Step 1 of Paragraph 3.4 (previous Step 4.1 and removed Options 1 and 2)
- Removed solder from Figure 5

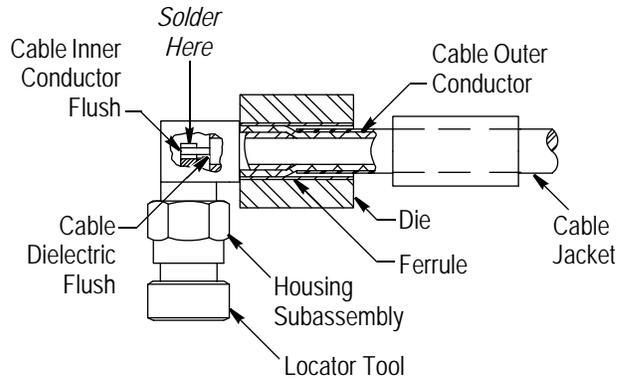


Figure 4

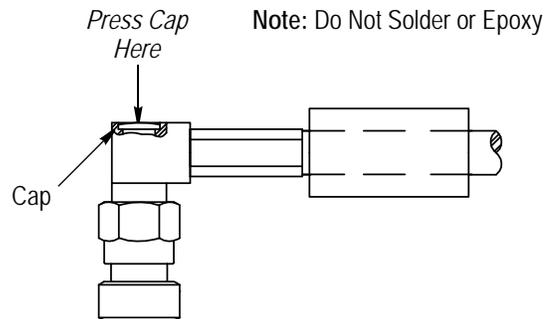


Figure 5

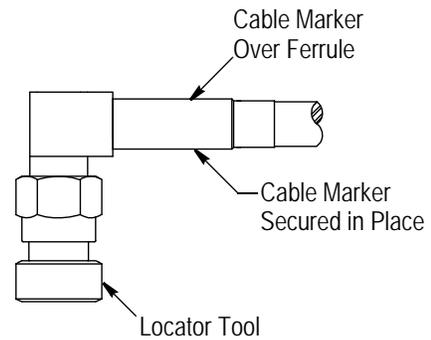


Figure 6