

Figure 1

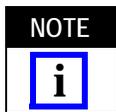
1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Straight Cable Plug Solder Clamp Attachments 1050779-1, 1050788-1, 1050783-1, and 1050790-1, which are applied onto RG 402/U (.141) semi-rigid coaxial cable.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the previous part number to the TE Connectivity part number.

TOOL DESCRIPTION	TE PART NO.	PREVIOUS PART NO.
Fixture Base	1055439-1	2098-5206-54
Clamp Insert	1055440-1	2098-5207-54
Center Contact Holder	1055454-1	2098-5221-10
Locator Tool (Optional)	1055508-1	2098-5606-02

Figure 2



Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue of this document are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The SMA straight cable plug solder clamp attachments consist of a housing sub-assembly, dielectric, center contact, rear dielectric, inner sleeve, and clamp nut.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Cable (Figure 3)

1. Insert squared cable end into fixture base hole pattern No. 2.
2. Place saw in saw slot and cut through outer conductor and into dielectric while rotating cable.
3. Remove cable from fixture and finish cutting dielectric with cutting blade.
4. Bare inner conductor by prying cut outer conductor and dielectric from cable.
5. Complete trimming of cable inner conductor to dimension shown in Figure 3.

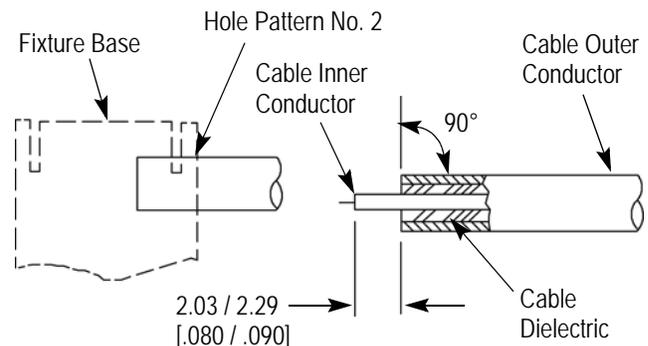


Figure 3

3.2. Soldering of Inner Sleeve to Cable (Figure 4)

1. Place clamp nut and inner sleeve on end of cable.
2. Place loose assembly in fixture base as shown in Figure 4. (Slide clamp nut back out of way.)
 - a. Nest cable in locator tool.
 - b. Tighten clamp screw to secure cable.

c. Tighten locator tool to seat cable firmly.

3. Slide inner sleeve against locator tool.

4. Maintain position of inner sleeve firmly against locator tool and solder.

NOTE *Fixture base should be clamped vertically in vise to keep inner sleeve seated against locator tool.*

CAUTION *Damaged components must not be used. They must be replaced with new components.*

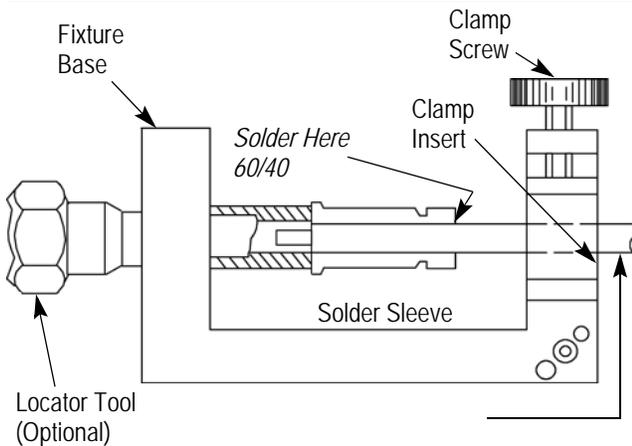


Figure 4

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

1. Tin inner conductor of cable.
2. Place rear dielectric onto cable inner conductor.
3. Place center contact in holder. Heat center contact and push it over inner conductor of cable with the large diameter of contact resting firmly against rear dielectric.
4. Remove excess solder.

3.4. Secure Inner Sleeve Sub-Assembly to Housing (Figure 6)

1. Assemble front dielectric onto center contact.
2. Slide clamp nut over inner sleeve and engage threads of clamp to housing. Torque to 2.83 - 3.39 N•m [25 - 30 in-lb].
3. Assembly is now complete.

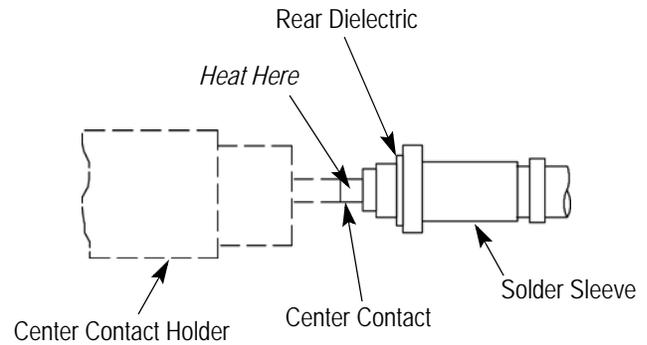


Figure 5

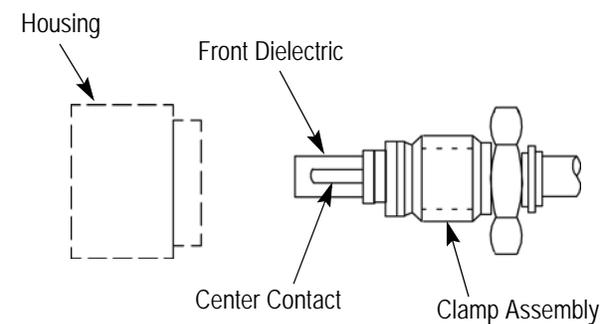


Figure 6

4. MILITARY INFORMATION

TE PART NUMBER	MILITARY P/N M39012/79	PREVIOUS PART NUMBER
1050779-1	B3004	2001-8004-92
1050788-1	B3104†	2001-8104-92
1050783-1	-3008	2001-8008-92
1050790-1	-3108†	2001-8108-92

† No safety wire holes

5. REVISION SUMMARY

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

- Updated document to corporate requirements.