

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Straight Cable Jack (Compression Crimp Attachments) 1050934-1 and 1051097-1, which are applied onto RG 405/U and .085 semi-rigid coaxial cable.

The table below represents tool numbers applicable to this instruction sheet. The table references the description, and the previous part number to the TE part number.

TOOL DESCRIPTION	JACK PART NUMBER	
	TE NUMBER	PREVIOUS NUMBER
Crimp Tool Kit	1055835-1	2598-5200-54
Optional Hand Trim and Point Tool	1055815-1	2598-5120-54



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

## 2. DESCRIPTION (Figure 1)

The cable jack compression crimp attachment consists of a connector assembly.

## 3. ASSEMBLY PROCEDURES

### 3.1. Preparing the Cable (Figure 2)

Trim cable to the dimensions shown in Figure 2.

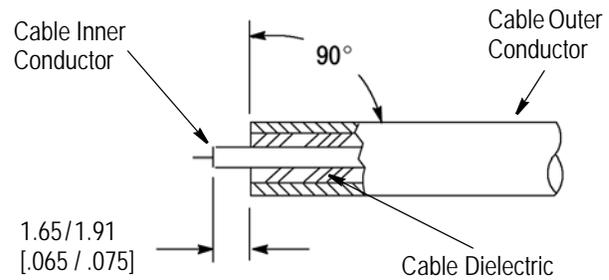


Figure 2

### 3.2. Shaping Inner Conductor of Cable

1. Trim inner conductor to length as shown in Figure 3.
2. File blunt end of inner conductor to an 85° to 90° cone as shown in Figure 3.

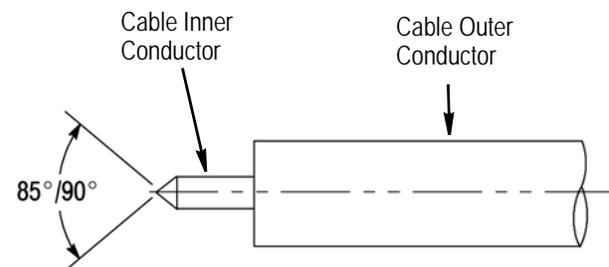


Figure 3

**3.3. Installing Cable into Connector Assembly (Figure 4)**

1. Install lower cable support (for .085 cable) and anvil (SMA/F) into crimp tool.
2. Set crimp length on crimp tool to 13.46 [.530].
3. Carefully insert cable inner conductor into pre-assembled center contact of connector assembly until cable bottoms on shoulder in connector assembly.
4. Place assembly into crimp tool, bottoming the connector reference plane against anvil and allowing the cable to settle in the lower cable support.
5. Squeeze handles of crimp tool until ratchet releases.
6. Assembly is now complete.



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

**3.4. MILITARY INFORMATION**

MILITARY MAINTENANCE TOOLS	
Crimp Tool:	M/22520/36-01
Positioning Dies:	M22520/36-02
Locator Tool:	M22520/36-17 (Previous No. 2098-0728-54) (TE No. 1055300-1)

**4. REVISION SUMMARY**

This instruction sheet has been updated to contain the latest company logo.

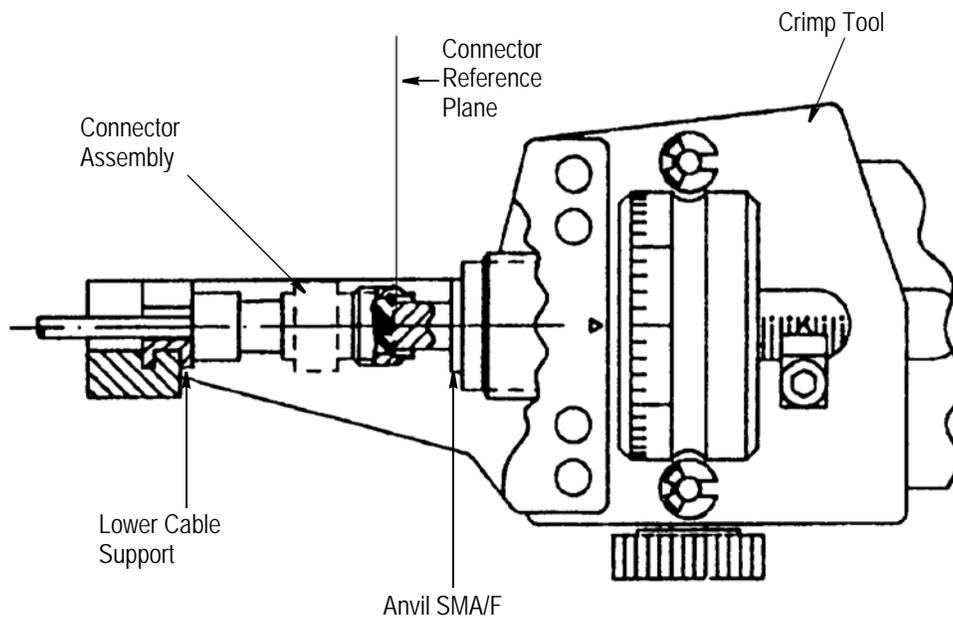


Figure 4