

TE PART NUMBER	DESCRIPTION	CABLE
1883239-1	SMA Straight Cable Plug	FA 12 RX Coaxial Cable

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedure for the SMA Straight Cable Plug shown in Figure 1. This connector is a solder attachment type connectors that attaches to the cable listed in Figure 1.

Required tooling can be found in the table in Figure 2.

TE PART NUMBER	DESCRIPTION
1055440-1	Clamp Insert
1055454-1	Center Contact Holder
91362-6	Solder Gage (.010 Thk)
1055443-1	Locator Tool

Figure 2

### NOTE



Dimension on this sheet are in millimeters [with inches in brackets], unless otherwise specified. Drawings are not to scale.

## 2. ASSEMBLY PROCEDURE

### 2.1. Preparing the Coaxial Cable

1. Strip the cable jacket to the dimension shown in Figure 3.

### DANGER



Follow all safety practices when using soldering equipment.

2. Solder dip the braid to the jacket.

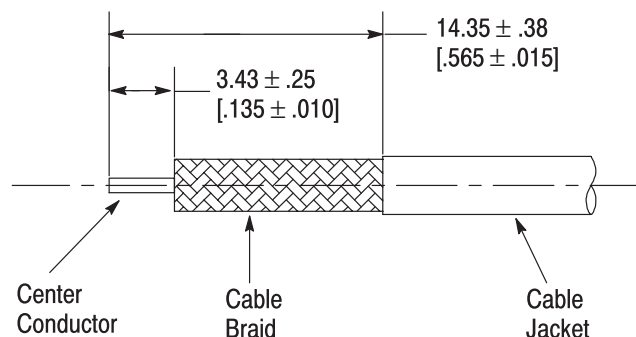


Figure 3

3. Strip the tinned braid and dielectric, exposing the center conductor to the dimension in Figure 3.

### 2.2. Soldering the Center Contact to the Cable Center Conductor

1. Tin the cable center conductor.
2. Place the solder gage (91362-6) on the center conductor, flush with the dielectric and braid.
3. Place the center contact in the center contact holder (1055454-1).
4. Heat the center contact and push it over the center conductor of the cable to rest firmly against the solder gage. See Figure 4.

### NOTE

Add solder as required.

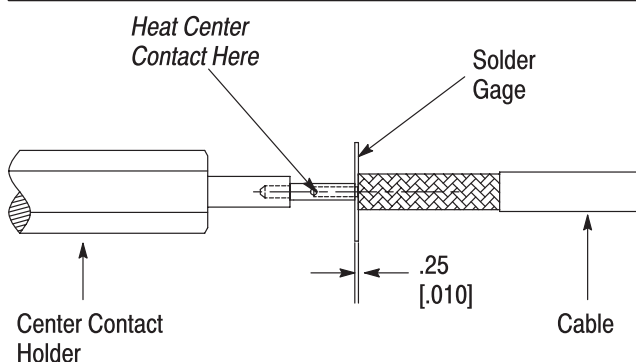


Figure 4

5. Remove the solder gage and the excess solder.

### 2.3. Soldering the Cable to the Housing Subassembly

1. Assemble the solder fixture.
  - a. Screw the locator tool (1055443-1) into the fixture base (1055439-1).

- b. Install the clamp inserts (1055440-1).
2. Carefully insert the cable assembly into the connector housing.
3. Place the loose assembly into the fixture base, as shown in Figure 5.

**NOTE**

*Clamp the fixture vertically in a vise, so that the connector interface is facing down.*

**3. REVISION SUMMARY**

New release

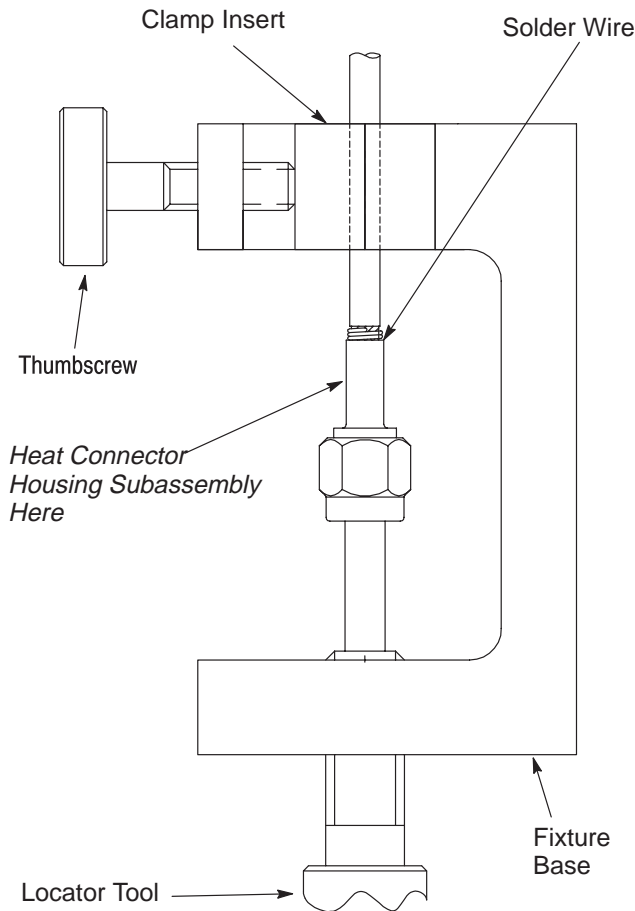


Figure 5

4. Maintain pressure on the cable to keep the interface bottomed on the locator tool.
5. Tighten the clamp screw to secure the cable, being careful to **not** crush the cable.
6. Twice, wrap .015 inch diameter solder wire around the tinned braid, next to the housing subassembly.
7. Heat the connector housing subassembly forming a concave fillet between the hosing and the braid.