

| Tyco Electronics Part Number | Previous Part Number | Description                                           | Cable Type   |
|------------------------------|----------------------|-------------------------------------------------------|--------------|
| 1996634-1                    | 5034 7196 09         | SMC Bulkhead Cable Jack Connectors (Crimp Attachment) | RG178/U, 196 |

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedure for the SMC Bulkhead Cable Jack Connectors listed in Figure 1. These connectors are crimp attachment type connectors that attach to the cable listed in Figure 1.

The table in Figure 2 references the tooling used to apply these connectors. The table includes tool descriptions, the Tyco Electronics part number, and the corresponding (previous) part number.

| Tyco Electronics Part Number | Previous Part Number | Description                    |
|------------------------------|----------------------|--------------------------------|
| 1055463-1                    | 2098 5237 10         | Center Contact Holder (T-4579) |
| 1055781-1                    | 2098 5007 54         | Crimp Die                      |
| 1055780-1                    | 2598 5006 54         | Crimp Tool                     |

Figure 2

### NOTE



Dimension on this sheet are in millimeters [with inches in brackets], unless otherwise specified. Figures and illustrations are for reference only and are not drawn to scale.

Reasons for revision can be found in Section 4, REVISION SUMMARY.

## 2. DESCRIPTION

Each SMC Bulkhead Cable Jack Connector consists of a housing assembly, a dielectric, a center contact, an inner sleeve assembly, an outer sleeve, and a sheath. See Figure 1.

## 3. ASSEMBLY PROCEDURE

### DANGER



Follow safety precautions included with the tools used for assembly.

- Slide the sheath and the outer sleeve onto the cable.

### DANGER



To avoid personal injury, be sure to use appropriate safety equipment, including gloves, when using cable stripping tools.

- Strip the cable according to the dimensions in Figure 3.
- Flare the cable braid.
- Tin the inner conductor.

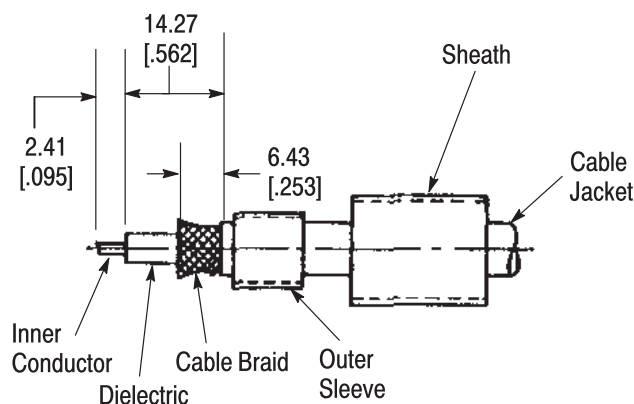


Figure 3

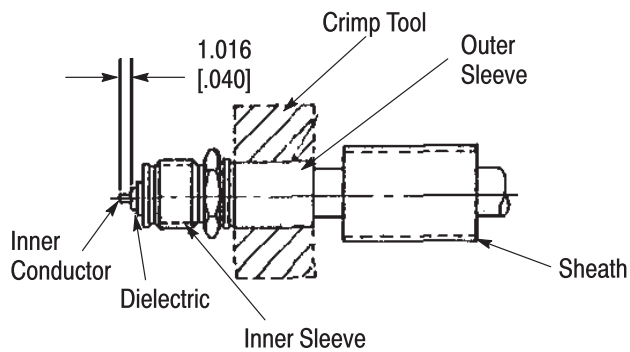


Figure 4

5. Position and secure the inner sleeve in a bench vise.
6. Insert the cable into the inner sleeve and seat it firmly.
7. Slide the outer sleeve over the flared cable braid.
8. Hold the cable firmly and crimp the outer sleeve to the braid using 2.67 mm [.105 in.] hex die cavity. See Figure 4.
9. Trim the excess cable braid.
10. Place the center contact in the center contact holder (Figure 2) and heat the center contact.
11. Push the center contact over the inner conductor of the cable and adding solder through the site hole as required. See Figure 5.

**NOTE**

The large diameter of the contact should rest firmly against the dielectric.

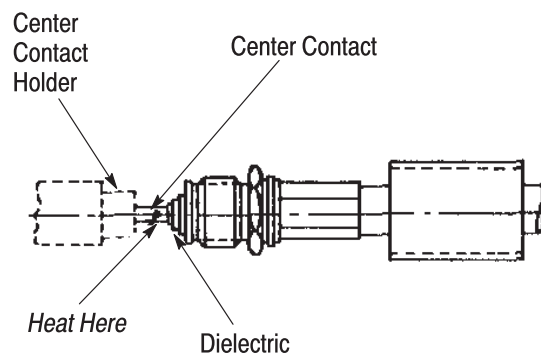


Figure 5

12. Remove excess solder.
13. Assemble the dielectric over the center contact.
14. Engage the threads of the inner sleeve to the housing and torque to 0.79–1.13 N•m [7–10 in. lbs].
15. Position the outer sheath over the outer sleeve as shown in Figure 6.
16. Shrink the sheath with a heat gun, using indirect heat.

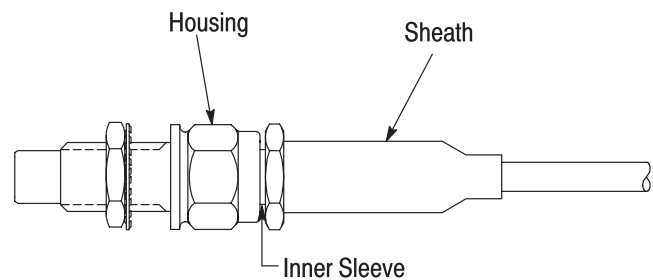


Figure 6

17. Adherence to the preceding steps should yield the tolerances shown in Figure 7.

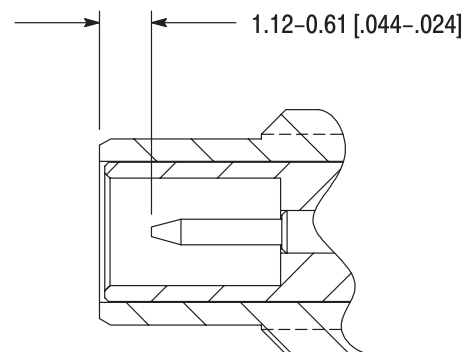


Figure 7

**4. REVISION SUMMARY**

- Initial release of document