

Figure 1

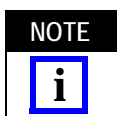
1. INTRODUCTION

SSMA straight cable plug connectors (solder attachment) shown in Figure 1 are designed to be soldered to .085-in. semi-rigid coaxial cable.

The tools used for assembly are listed in Figure 2.

CURRENT PART NUMBER	PREVIOUS PART NUMBER	DESCRIPTION
1055439-1	2098-5206-54 (T-4567)	Fixture Base
1055441-1	2098-5208-54 (T-4700-2)	Clamp Insert
1055457-1	2098-5232-02 (T-4570)	Locator Tool
1055465-1	2098-5269-02 (T-5708)	Trim Tool (Optional)
1055449-1	2098-5216-54 (T-5702)	Retaining Ring Pliers

Figure 2



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 5, REVISION SUMMARY.

2. DESCRIPTION

The plug consists of a coupling nut, gasket, retaining ring, and housing. See Figure 1.

3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

1. Trim the cable end square, as shown in Figure 3.

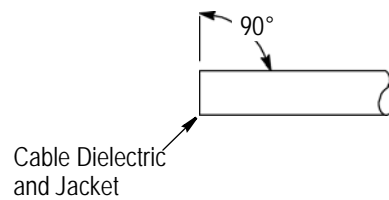


Figure 3

2. Place the connector housing on the end of the cable.
3. Place the loose assembly in the fixture base as shown in Figure 4.
 - a. Nest the cable end in the locator tool.
 - b. Tighten the clamp screw to secure the cable.
 - c. Tighten the locator tool to seat the cable firmly.

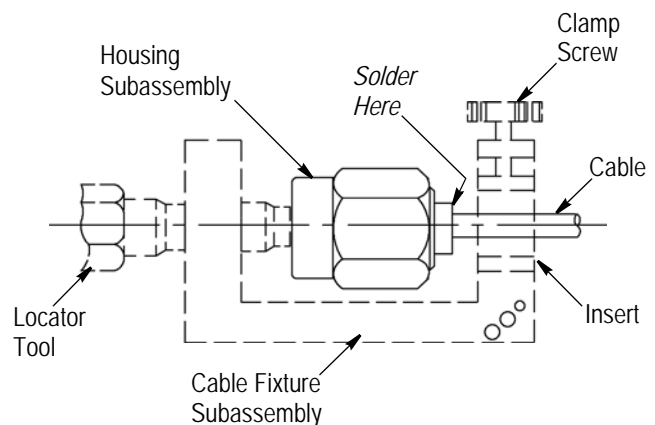
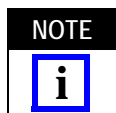


Figure 4

4. Slide the housing against the locator tool.
5. Maintain the position of the housing (firmly) against the locator tool and solder the connector



The fixture should be clamped vertically in a vise to keep the housing seated against the locator tool.

6. Trim the extended or exposed dielectric flush with the end of the cable outer conductor.
7. Place the dielectric recess tool on the dielectric and push to recess the dielectric with the cable outer conductor. See Figure 5.

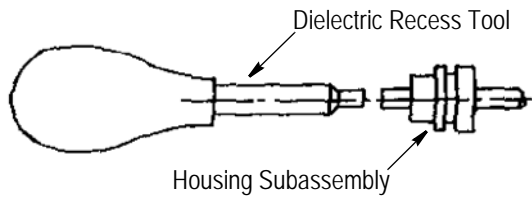


Figure 5

8. Insert the squared cable end into Hole Pattern 1 of the cable fixture subassembly. Refer to Figure 6.
9. Place a saw in the saw slot (Figure 6) and while rotating the cable, cut through the cable jacket and into, but not through, the dielectric.
10. Remove the cable from the cable fixture subassembly, and finish cutting the dielectric with a blade.

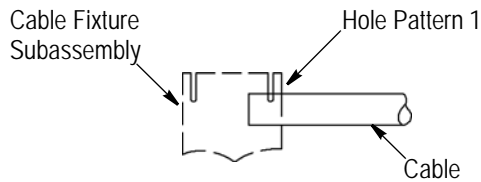


Figure 6

11. Pry the jacket and dielectric from the cable to expose the center conductor.
12. Place the trim tool over the inner cable conductor projection and rotate to face off the front face. See Figure 7. Inspect dimensional tolerances.

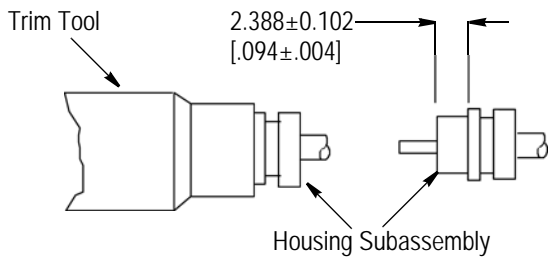


Figure 7

13. Trim to length, as shown in Figure 8.
14. File the blunt end to a 75- to 90-degree cone. See Figure 8.

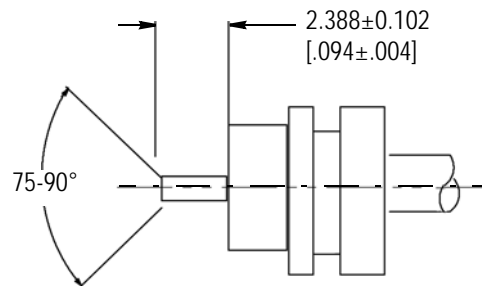


Figure 8

15. Place the retaining ring and gasket on the housing.
16. Compress the retaining ring with the retaining ring pliers.
17. Push the coupling nut onto the housing and retaining ring. The coupling nut should rotate freely. See Figure 9.

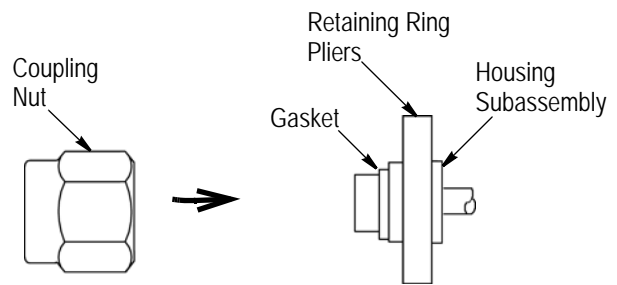


Figure 9

4. REPLACEMENT AND REPAIR

DO NOT re-use a soldered center contact or housing subassembly by removing the cable.

Components of the plug are not repairable. Replace any defective or damaged components.

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Corrected current part numbers for tool and pliers in Figure 2