

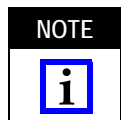
Figure 1

## 1. INTRODUCTION

SMA straight cable jacks (crimp attachment) 1051855-1 and 1052024-1 are designed to be crimped onto coaxial cable size RG 174/U using the following tools:

TOOL DESCRIPTION	PART NUMBER	
	CURRENT	PREVIOUS
Crimp Tool	1055236-1	2098-0105-54
Contact Holder Assembly	1055454-1	2098-5221-10 (T-4578)

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 4, REVISION SUMMARY.

## 2. DESCRIPTION

Each cable jack consists of the components shown in Figure 1.

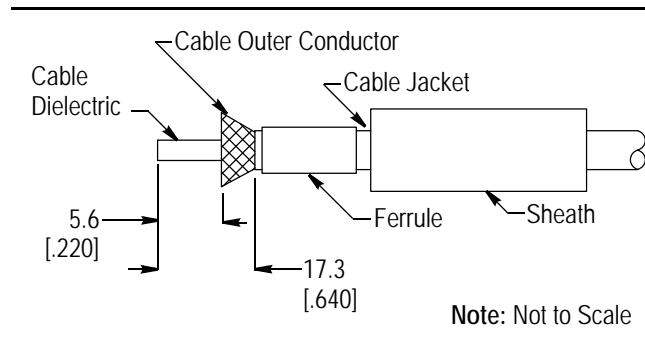
## 3. ASSEMBLY PROCEDURE

### 3.1. Prepare Coaxial Cable End

1. Place the sheath and ferrule onto the cable.
2. To expose the cable outer conductor, remove the end portion of the cable jacket to the dimension given in Figure 3.
3. Trim the cable outer conductor to the dimension given in Figure 3.
4. Flare the cable outer conductor.

### 3.2. Crimp Sleeve onto Cable

1. Insert the sleeve into the clamp nut
2. Position the sleeve and clamp nut assembly on the cable and in the crimp tool as shown in Figure 4.
3. Slide the ferrule over the flared portion of the cable outer conductor.



Note: Not to Scale

Figure 3

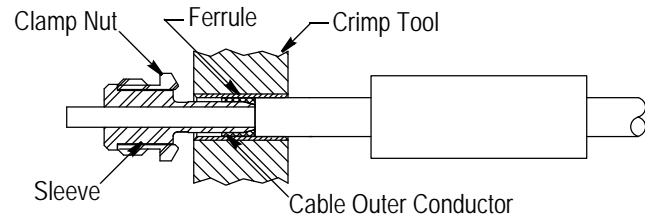


Figure 4

4. Hold the sleeve and clamp nut assembly in place, and crimp the ferrule.
5. Trim and remove excess cable outer conductor strands.

### 3.3. Solder Center Contact to Cable Inner Conductor

1. Trim the cable dielectric flush with the end of the sleeve to expose the cable inner conductor.
2. Place the back-up bushing onto the cable inner conductor.
3. Trim and de-burr the cable inner conductor projection to the dimension given in Figure 5.
4. Tin the cable inner conductor.
5. Place the center contact in the contact holder assembly.

6. Heat the center contact using a soldering iron, then carefully push the center contact over the cable inner conductor to rest firmly against the back-up bushing.

7. Remove excess solder and splatter.

### 3.4. Secure Sleeve and Sheath to Housing

1. Assemble the dielectric over the center contact.
2. Engage the threads of the sleeve and clamp nut assembly with the housing. Tighten to a torque between 1.36 and 1.69 N [12 and 15 in-lbs].
3. Position the sheath over the ferrule as shown in Figure 6
4. Using a thermo gun, apply indirect heat to the sheath until it shrinks.

### 3.5. Inspect Completed Cable Jack

Adherence to the assembly procedure should yield the tolerances shown in Figure 7.

## 4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo
- Updated instruction sheet to corporate requirements
- Changed OSM to SMA
- Removed obsolete cable jacks
- Changed dimension in Figures 5 and 7

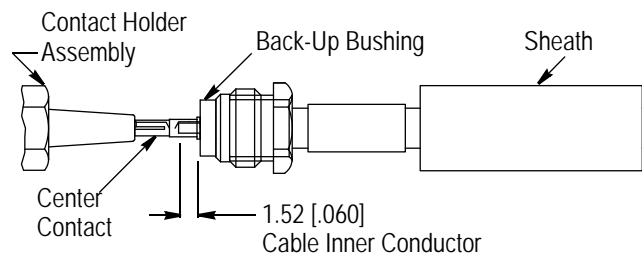


Figure 5

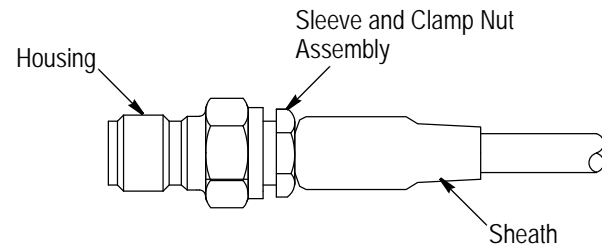


Figure 6

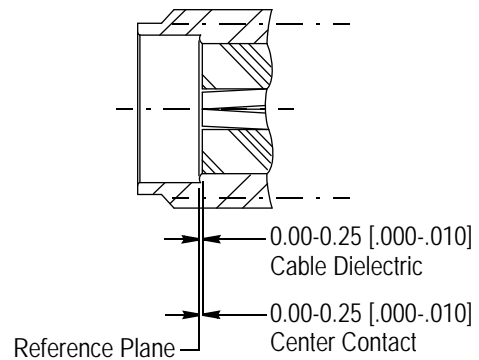


Figure 7