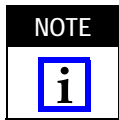


Figure 1

1. INTRODUCTION

SMA (OSM) Straight Cable Jack (Crimp Attachment) 1051861-1 is designed to be crimped onto coaxial cable size RG 142U (or equivalent) using the following tools:

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	CURRENT	PREVIOUS
Center Contact Holder	1055454-1	2098-5221-10 (T-4578)
Crimp Tool	1055236-1	2098-0105-54
Hex Crimp Die	1060714-1	B



*Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets].
Figures are not drawn to scale.*

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

The cable jack consists of a housing, dielectric, center contact, dielectric bushing, inner sleeve, clamp nut, ferrule, shrink tubing. See Figure 1.

3. ASSEMBLY PROCEDURE

3.1. Prepare Cable (Figure 2)

1. Place the shrink tubing, then the ferrule onto the cable.
2. Strip the cable jacket to the dimension given in Figure 2.
3. Trim the cable braid to the length given in Figure 2. Flare the cable braid.

3.2. Crimp Inner Sleeve to Cable (Figure 3)

1. Insert the inner sleeve into the clamp nut.
2. Position the inner sleeve and clamp nut onto the cable dielectric as shown in Figure 3.
3. Slide the ferrule over the flared portion of the cable braid.

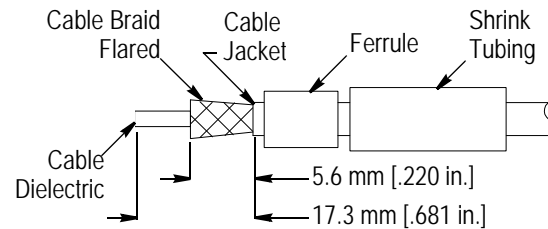


Figure 2

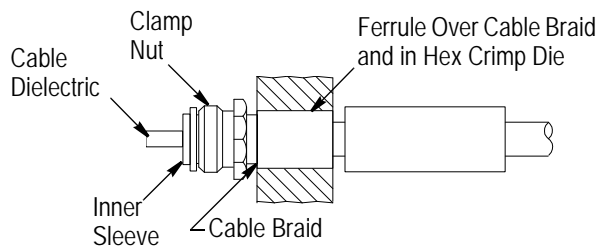


Figure 3

4. Place the ferrule into the .213 crimping chamber of the hex crimp die. Hold the clamp nut and ferrule in place, and crimp the ferrule.

5. Trim, and remove, excess cable braid strands.

3.3. Solder Center Contact to Cable (Figure 4)

1. Trim the cable dielectric flush with the end of the inner sleeve to expose the cable inner conductor.
2. Place the dielectric bushing onto the cable inner conductor.
3. Trim, and de-burr, the cable inner conductor projection to the length given in Figure 4.
4. Tin the cable inner conductor.
5. Place the center contact in the center contact holder. Using a soldering iron, heat the center contact, then carefully push the center contact over the cable inner conductor until it rests firmly against the dielectric bushing.
6. Remove excess solder or splatter.

3.4. Secure Housing to Inner Sleeve (Figure 5)

1. Install the dielectric onto the center contact.
2. Thread the housing onto the inner sleeve, and tighten to a torque between 1.4 and 1.7 Nm [12 and 15 in.-lbs].
3. Position the shrink tubing over the ferrule as shown in Figure 5.
4. Using a thermo gun, apply indirect heat to the shrink tubing until it is snug.

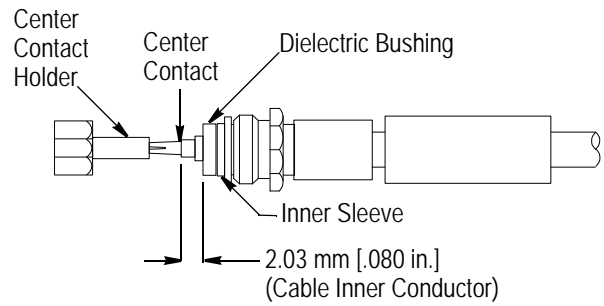


Figure 4

3.5. Inspection

Adherence to assembly procedure should yield tolerances given in Figure 6.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo
- Updated instruction sheet to corporate requirements
- Removed obsolete product part numbers and related cable sizes
- Added current tooling part numbers

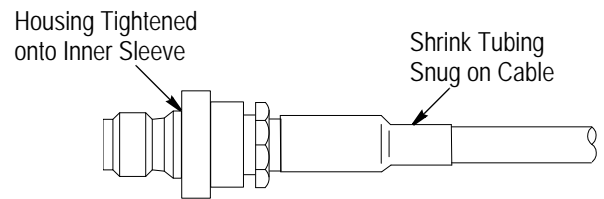


Figure 5

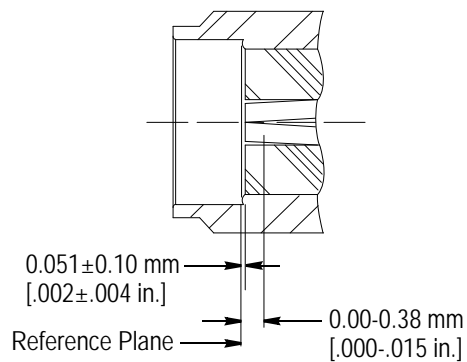


Figure 6