

CABLE PLUG PART NUMBER		MILITARY PART NUMBER M39012/80-
CURRENT	PREVIOUS	
1051165-1	2007-8005-92	3005
1051175-1	2007-8105-92	3105 (No Safety Wire Holes)
1051168-1	2007-8007-92	3007
1051177-1	2007-8107-92	3107 (No Safety Wire Holes)

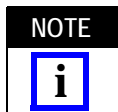
Figure 1

1. INTRODUCTION

SMA Right-Angle Cable Plug (Direct Solder Attachment) 1051165-1, 1051168-1, 1051175-1, and 1051177-1 are designed to be soldered onto RG 405/U 2.16 mm [0.085 in.] diameter semi-rigid coaxial cable using the following tool as shown in Figure 2.

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	TE CONNECTIVITY	PREVIOUS PART NUMBER
Locator Tool	1055451-1	2098-5218-02

Figure 2



NOTE Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.

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

2. DESCRIPTION

The plug connector consists of a housing assembly, disc cap, and a coupling nut. See Figure 1.

3. ASSEMBLY PROCEDURE

3.1. Preparation of Cable



Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into the fixture base hole pattern No. 2, as shown in Figure 3.

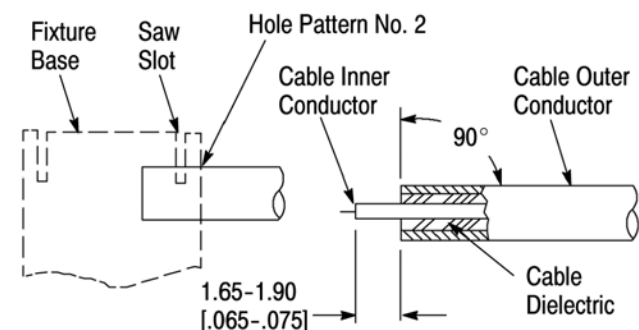


Figure 3

2. Place saw in saw slot and cut through outer conductor and into dielectric while rotating cable.

3. Remove cable from fixture and finish cutting dielectric with cutting blade.
4. Bare inner conductor by prying cut outer conductor and dielectric from cable.
5. Complete trimming of cable inner conductor to dimension shown in Figure 3.

3.2. Soldering of Center Contact to Inner Conductor

1. Secure locator tool to threads of coupling nut as shown in Figure 4.
2. Position cable inner conductor in center contact slot.
3. Place pre-heated soldering iron on tip of contact and solder as shown in Figure 4.

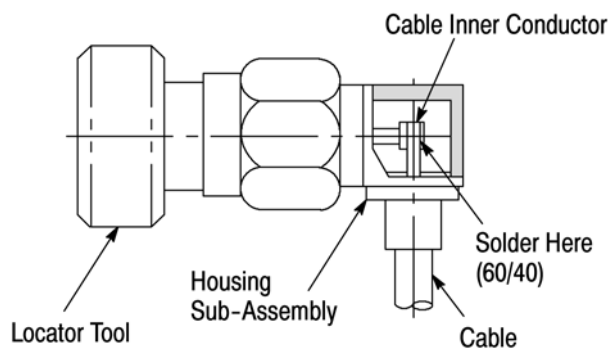


Figure 4

3.3. Soldering of Housing Sub-Assembly to Cable

Solder housing sub-assembly to cable as shown in Figure 5.

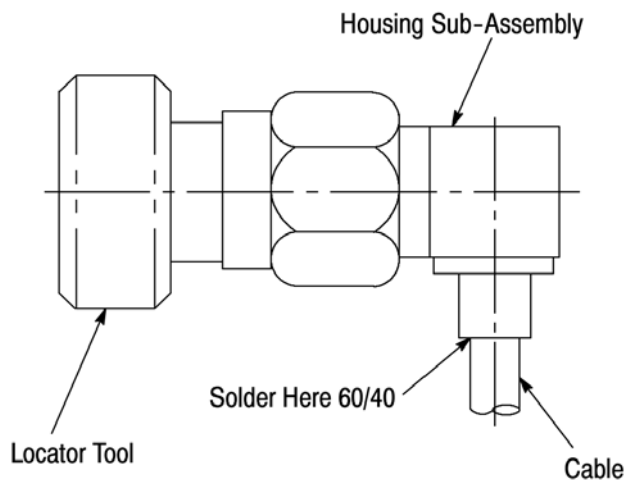


Figure 5

3.4. Seal Opening in Housing

1. Press disc cap into opening in rear of housing sub-assembly as shown in Figure 6.
2. Remove locator tool.
3. Two options of sealing the disc cap are:
 - a. Tin perimeter of opening and press disc cap into position. Apply heat to disc cap. Do not allow solder to penetrate housing.
 - b. Disc cap may be epoxied into place. Do not allow epoxy to penetrate inside housing.

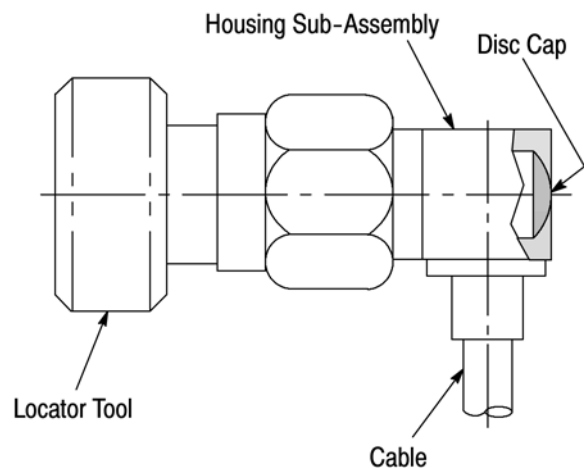


Figure 6



Damaged components may not be used. They must be replaced with new components.

4. REVISION SUMMARY

- New logo