

CONNECTOR			CABLE TYPE	CRIMP DIE M22520/5-	CRIMP CLOSURE	DIMENSIONS		
CURRENT PART NUMBER	PREVIOUS PART NUMBER	MILITARY PART NUMBER (M39012/59)				DIM. A (In.)	DIM. B (In.)	DIM. C (In.)
1484543-1	2034-8020-92	B 3020	RG122/U	-05	B	.100	.035	.175
				-09	A			
				-41	B			
1087842-1	2034-8021-92	B 3021	RG 58/U	-05	A	.122	.041	.205
1051989-1	2034-8022-92	B 3022	RG142/U	-11	A			.219
1051990-1	2034-8023-92	B 3023	RG223/U	-19	B			.219
1051991-1	2034-8024-92	B 3024	RG303/U	-57	A			.205
1051995-1	2034-8027-92	-3027	RG122/U	-05	B			.100
				-09	A			
				-41	B			
1051996-1	2034-8028-92	-3028	RG142/U	-05	A	.122	.041	.219
			RG223/U	-11	A			
1051997-1	2034-8028-92	-3029	RG 58/U	-19	B			.209
			RG303/U	-57	A			

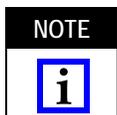
Figure 1

1. INTRODUCTION

These instructions cover the assembly of the SMA Bulkhead Feedthrough Cable Jack Connectors listed in Figure 1. Figure 1 also lists the cable types required for the various connectors, as well as the crimp closure, and the dimensions of the various connectors. In addition, Figure 1 lists the military crimp dies required for the specific connectors.

All of these connectors are used in crimp type applications.

Tooling required for the application (with the exception of the military crimp dies) is listed in Figure 2.



Dimensions in this document are in metric units [with U.S. customary units in brackets], unless otherwise specified.

Reasons for revision can be found in Section 3, REVISION SUMMARY.

PART NUMBER	MILITARY PART NUMBER	DESCRIPTION
1055454-1	--	Center Contact Holder
--	M22520/5-01	Crimp Tool
--	(See Figure 1)	Crimp Dies

Figure 2

2. ASSEMBLY

2.1. Preparing the Coaxial Cable End (Figure 3)

1. Place the outer sleeve (ferrule) on the cable.
2. Remove the end portion of the cable jacket to expose the cable braid.

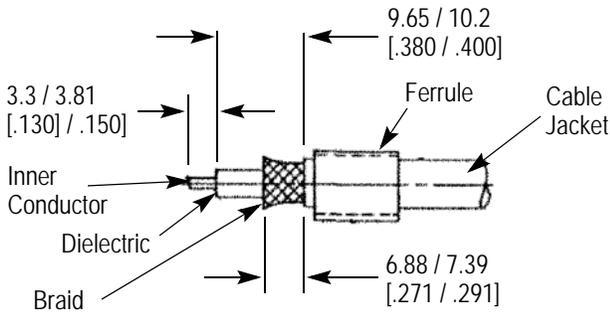


Figure 3

3. Trim the outer conductor to length, as shown in Figure 3.
4. Trim the dielectric to length, as shown in Figure 3.
5. Trim the inner conductor to length, as shown in Figure 3.
6. Flare the cable braid.

2.2. Soldering the Center Contact to the Cable Inner Conductor (Figure 4)



To avoid personal injury, be sure to follow all local practices and exercise caution when working with soldering equipment.

1. Tin the inner conductor of the cable.
2. Place the center contact in the center contact holder and heat the contact.
3. Remove excess solder.
4. Push the center contact over the inner conductor of the cable until it rests firmly against the cable dielectric.
5. Remove excess solder.

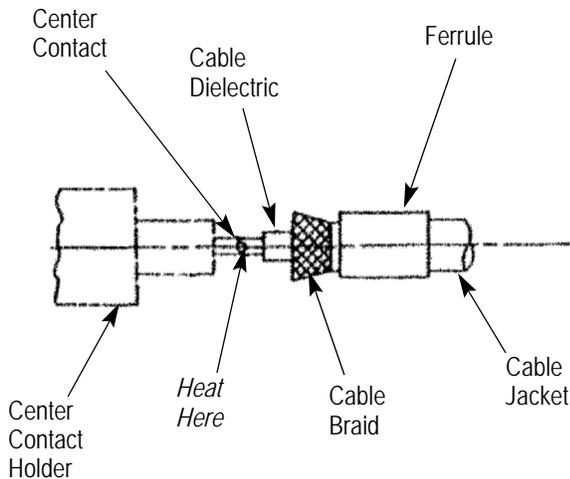


Figure 4

2.3. Crimping the Cable Subassembly to the Housing Subassembly

1. Position and secure the housing subassembly in a small bench-type vise.
2. Insert cable subassembly into housing subassembly and seat firmly.
3. Slide the ferrule over the flared portion of the cable braid.
4. Hold the cable (firmly seated) and crimp the ferrule in place. Refer to Figure 5.

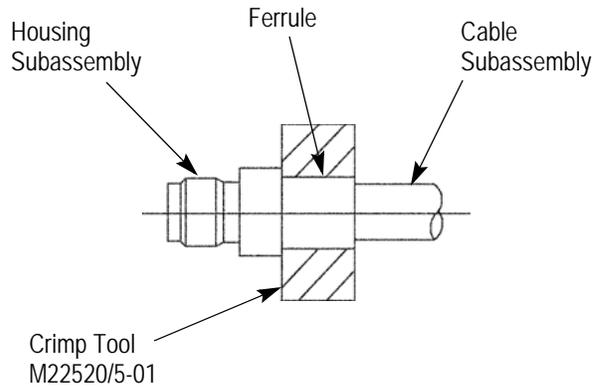


Figure 5

5. Trim and remove the excess cable braid strands.
6. The completed connector should appear as shown in Figure 6.

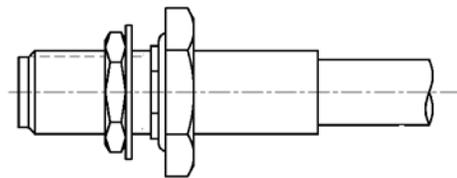


Figure 6

3. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.