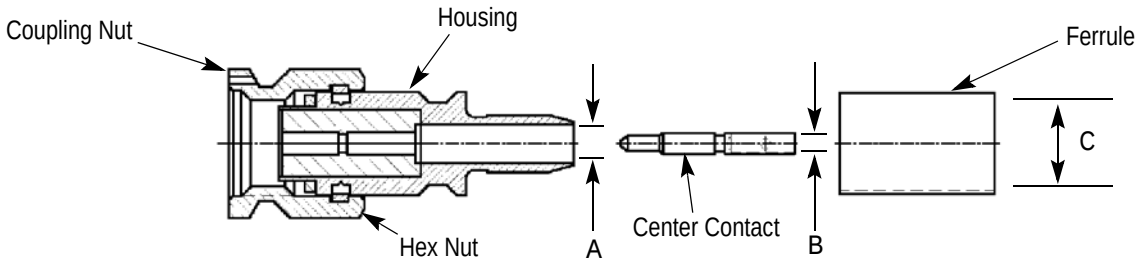
SMA Straight Cable Plugs



PLUG PART NUMBER			CABLE RG/U	CRIMPING TOOL	CRIMP DIE M22520/5-	DIE CLOSURE	PLUG DIMENSION, mm [in.]		
TE CONNECTIVITY		MILITARY M39012/55-					A	B	C
CURRENT	PREVIOUS								
1051774-1 1051805-1	2031-8020-92 2031-8120-92	B3020 B3120†	RG122/U	M22520/5-01	05 09 41	B A B	2.54 [.100]	.889 [.035]	4.44 [.175]
1051775-1 1051806-1	2031-8021-92 2031-8121-92	B3021 B3121†	RG58/U		05	A	3.1 [.122]	1.04 [.041]	5.21 [.205]
1051776-1 1051807-1	2031-8022-92 2031-8122-92	B3022 B3122†	RG142/U		11	A			5.56 [.219]
1051777-1 1051808-1	2031-8023-92 2031-8123-92	B3023 B3123†	RG223/U		19	B			
1051778-1 1051809-1	2031-8024-92 2031-8124-92	B3024 B3124†	RG303/U		57	A			5.21 [.205]
1051783-1 1051813-1	2031-8027-92 2031-8127-92	-3027 -3127†	RG122/U		05 09 41	B A B	2.54 [.100]	.889 [.035]	4.44 [.175]
1051785-1 1051815-1	2031-8028-92 2031-8128-92	-3028 -3128†	RG142/U RG223/U		05 11 19 57	A A B A	3.1 [.122]	1.04 [.041]	5.56 [.219]
1051787-1 1051816-1	2031-8029-92 2031-8029-92	-3029 -3129†	RG58/U RG303/U						5.21 [.205]

†No Safety Wire Holes

Figure 1

1. INTRODUCTION

These instructions cover the application of the SMA straight cable plugs listed in the table in Figure 1. These connectors are used in crimp-type attachment applications, and crimp onto the cable listed in Figure 1.

NOTE

Dimensions in these instructions are in metric units [with U.S. customary units in brackets], unless otherwise indicated.

The table in Figure 1 indicates the crimp tooling required for the application of these connectors.

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

2. ASSEMBLY

2.1. Coaxial Cable Preparation (Figure 2)

1. Slide the ferrule over the cable.
2. Strip the end portion of the cable jacket to expose the cable outer conductor (cable braid) to the dimensions in Figure 2.
3. Trim the outer conductor to length.
4. Trim the cable dielectric to length.
5. Trim the inner conductor to length.
6. Flare the outer conductor as shown in Figure 2.

2.2. Soldering the Center Contact to the Cable Inner Conductor (Figure 3)

Soldering equipment is hot. To avoid personal injury, be sure to follow all local and safety practices (including wearing gloves).

1. Tin the center conductor of the cable.
2. Place the center contact in (optional) center contact holder 1055454-1.
3. Heat center contact and push it over the inner conductor of the cable to rest firmly against the cable dielectric.
4. Remove excess solder.

2.3. Crimping the Connector to Cable (Figure 4)

1. Secure locator tool 1055451-1 to the threads of the housing subassembly.
2. Position and secure the housing assembly in a small bench vise.
3. Insert cable into the housing subassembly and seat the cable firmly.
4. Slide the ferrule over the flared portion of the cable outer conductor (braid)
5. Hold the cable firmly seated and crimp the ferrule in place.
6. Trim and remove the excess outer conductor (cable braid).

3. REVISION SUMMARY

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

- Updated document to corporate requirements.

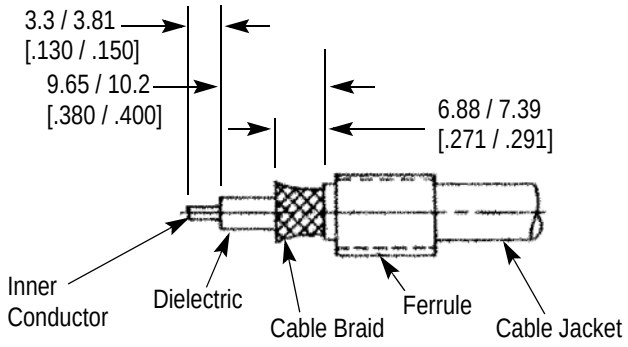


Figure 2

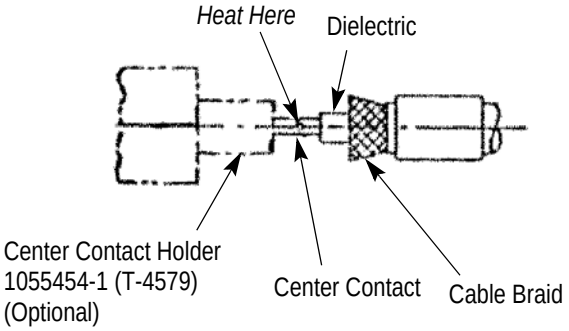


Figure 3

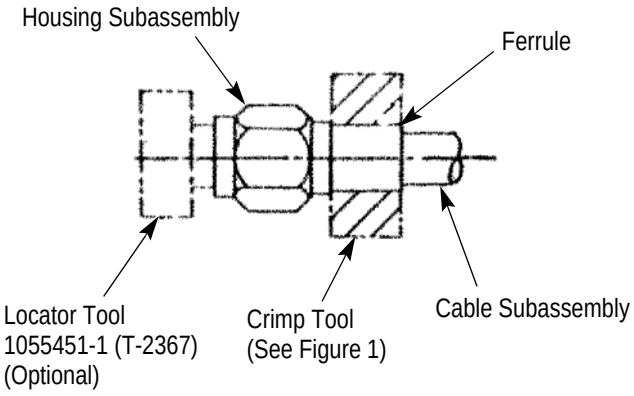


Figure 4