

Connector Number			Cable Type	Dimensions		
TE Part Number	Previous Part Number	Military Part Number (M39012/55)		Dim. A (I.D.)	Dim. B (I.D.)	Dim. C (I.D.)
1051760-1	2031-8008-92	-3008	RG122/U	.100 In.	.035 In.	.175 In.
1051792-1	2031-8108-92	-3108*				
1051762-1	2031-8009-92	-3009	RG 58/U RG142/U RG223/U	.122 In.	.041 In.	.219 In.
1051794-1	2031-8109-92	-3109				
1051763-1	2031-8010-92	-3010				
1051795-1	2031-8110-92	-3110*	RG303/U	.122 In.	.041 In.	.219 In.

(*No Safety Wire Holes)

Figure 1

1. INTRODUCTION

These instructions cover the assembly of the SMA Straight Cable Plug Connectors listed in Figure 1. Figure 1 also lists the cable types required for the various connectors, and the dimensions of the various connectors.

All of these connectors are used in solder-type applications.

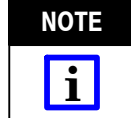
Tooling required for the application is listed in Figure 2.

TE Part Number	Previous Part Number	Description
1055454-1	2098-5221-10 (T-4578)	Center Contact Holder
1055451-1	2098-5218-02	Locator Tool

Figure 2



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



NOTE Reasons for revision can be found in SECTION 3.

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 the cable braid.
3. Trim the outer conductor to length, as shown in Figure 3.

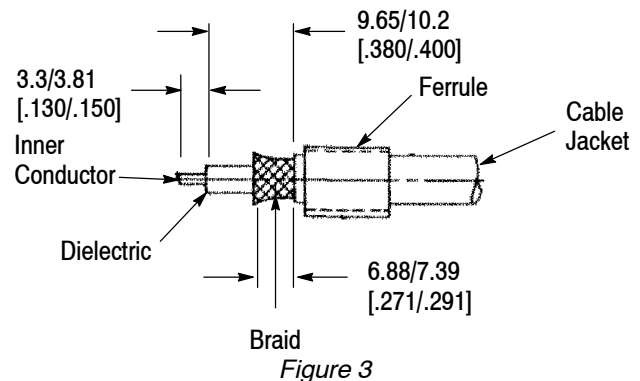


Figure 3

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 Inner Conductor (Figure 4)



To avoid personal injury, always follow local safety practices when handling solder equipment.

1. Tin the inner conductor of the cable.
2. Place the center contact in the center contact holder, heat the center contact, and push it over the inner conductor of the cable to rest firmly against the dielectric.
3. Remove excess solder.

2.3. Soldering the Cable to the Housing Subassembly (Figure 5)

1. Secure the locator tool to the threads of the housing subassembly.
2. Position and secure the housing subassembly in a small bench vise.
3. Insert cable into the housing subassembly and seat firmly.
4. Slide the outer sleeve over the flared cable braid.



To avoid personal injury, always follow all local safety practices when handling solder equipment.

5. Hold the cable (firmly seated) and solder through the holes in the outer sleeve.
6. Trim and remove excess cable braid.
7. The assembled plug should resemble the plug in Figure 6.

3. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed the military number from M39012/57B to M39012/55;
- Updated format; and
- Applied TE logo

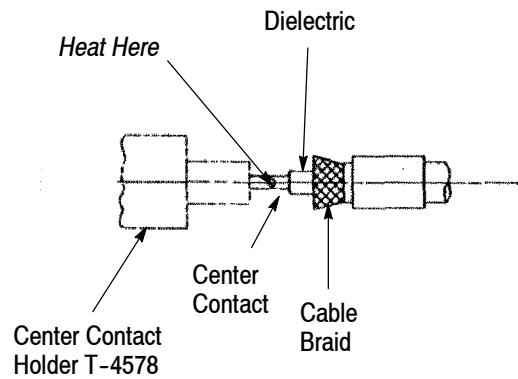


Figure 4

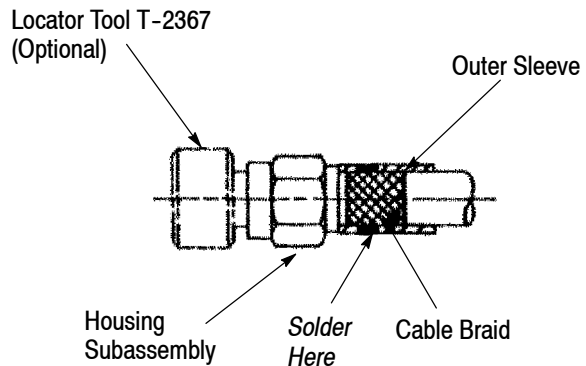


Figure 5

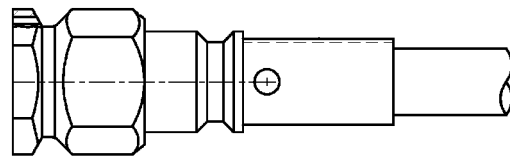


Figure 6