

Figure 1

1. INTRODUCTION

SMA Straight Cable Plug (Crimp Attachment) 1362564-1 (previous part number 2231-5007-10) is designed to be installed onto Low Loss Coaxial Cable 1314240-1 (previous part number MA318) using the following tools:

DESCRIPTION	PART NUMBER	
	CURRENT	PREVIOUS
Locator Tool	1055451-1	2098-5218-02
.384-in. Hex Die	—	—

NOTE



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

Each cable plug consists of a connector subassembly, dielectric, center contact, crimp ferrule, and shrink sleeve. See Figure 1.

3. ASSEMBLY PROCEDURE

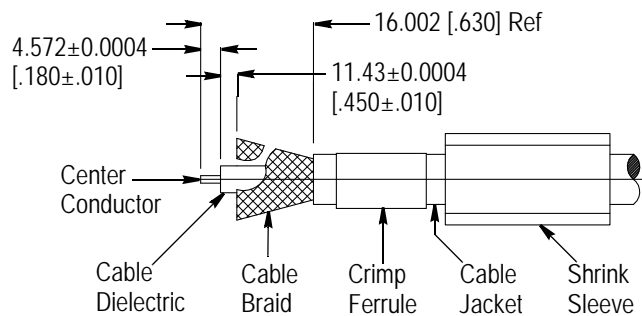
3.1. Preparing the Cable

- Place the shrink sleeve and crimp ferrule on the cable.
- Strip and trim the cable end to the dimensions shown in Figure 2
- Flair the two braid layers away from the fluoropolymer core (cable dielectric).

CAUTION



Be careful to NOT damage the core.



Note: Dimensions are in millimeters [and inches].

Figure 2

3.1. Attaching the Center Contact

- Tin the cable center conductor.
- Place 63/37 solder into the center contact and position the pin on the cable center conductor.
- Solder the center contact flush to the center conductor.

DANGER



To avoid personal injury, be sure to follow all local safety regulations when handling solder.

- Assemble the dielectric onto the center contact as shown in Figure 3.

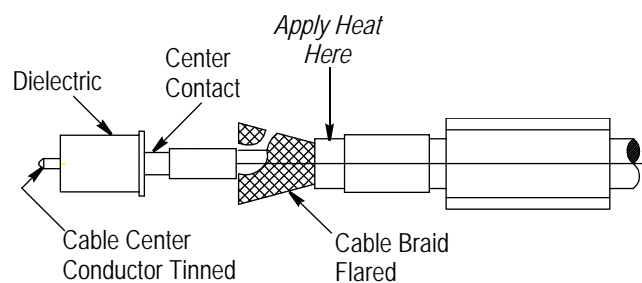


Figure 3

3.2. Crimping Connector Subassembly to Cable

1. Place the locator tool into the connector subassembly.
2. Slide the connector subassembly over the dielectric, over the cable dielectric, and under the cable braid.
3. Push the cable firmly into the connector subassembly until the dielectric and cable braid bottom in the connector subassembly. See Figure 4, Detail A.
4. Slide the crimp ferrule over the back end of the connector subassembly (so that the ferrule is seated against the connector subassembly), then crimp the crimp ferrule using a .384-in. hex die. See Figure 4, Detail B.
5. Trim off excess cable braid.

3.3. Applying Shrink Sleeve to Connector Subassembly

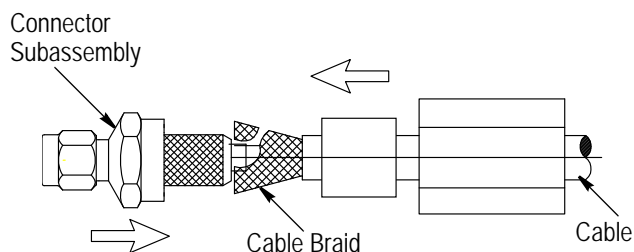
1. Position the shrink sleeve as shown in Figure 5.
2. Apply heat using a hot air gun, and shrink the shrink sleeve onto the connector subassembly and cable.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo
- Removed trademark from description of cable core

Detail A



Detail B

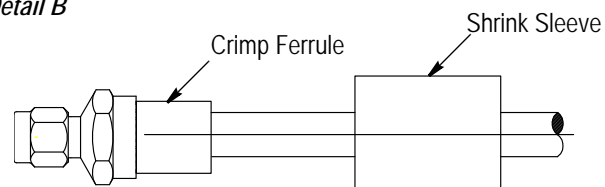


Figure 4

*Shrink Sleeve
Shrunk*

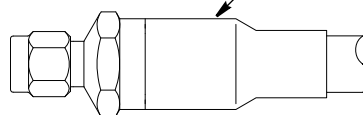


Figure 5