

JACK PART NUMBER			CABLE SIZE	TOOLING		JACK DIMENSION (MM[IN.])		
TYCO ELECTRONICS PART NO.	PREVIOUS PART NO.	MILITARY PART NO. M39012/58B-		CRIMP CLOSURE	PART NO.	A	B	C
1052043-1	2036 8015 92	3015	RG 142/U	B	Current 1055236-1 Previous 2098 0105 54	3.10 [.122]	1.04 [.041]	5.56 [.219]

Figure 1

**1. INTRODUCTION**

This instruction sheet covers the assembly of the SMA Straight Cable Jack shown in Figure 1. Figure 1 also includes the cable type and crimp tooling required to assemble this connector.

**NOTE** Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

**2. ASSEMBLY PROCEDURES**

**2.1. Coaxial Cable Preparation**

Slide the ferrule over the cable. Trim the cable as shown in Figure 2.

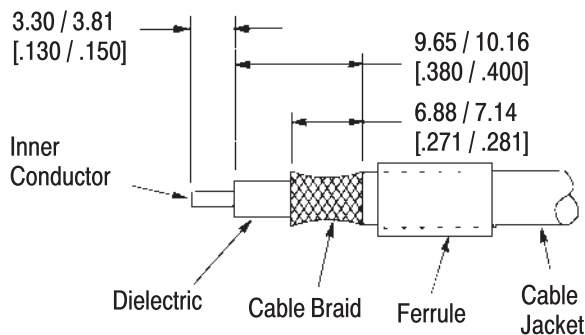


Figure 2

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

**DANGER** 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 Center Contact Holder 1055463-1 (optional).
3. Heat the center contact and push it firmly over the inner conductor of the cable to rest firmly against the cable dielectric.

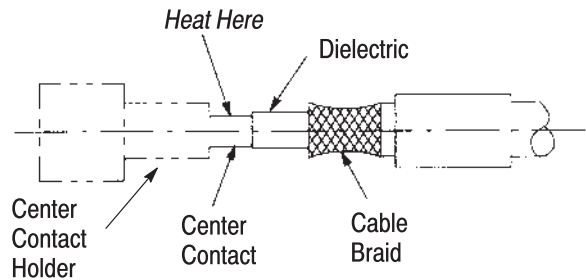


Figure 3

4. Remove the excess solder.

### 2.3. Crimping the Connector to the Cable (Figure 4)

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

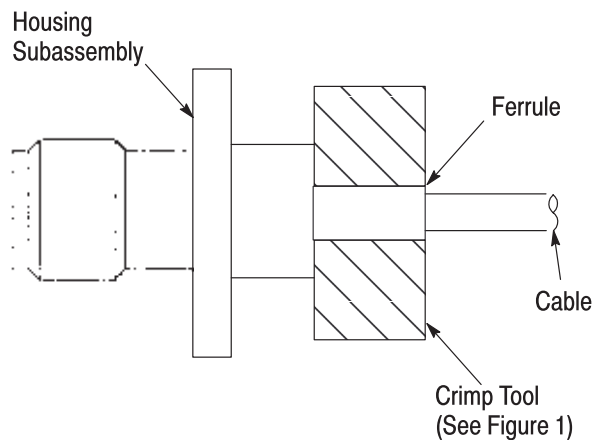


Figure 4

### 3. REPLACEMENT AND REPAIR

Do NOT re-use a soldered contact, housing, or crimped ferrule by removing the cable.

Components of the jack are not repairable. Remove and replace any defective or damaged components.

### 4. REVISION SUMMARY

Initial release of 408-8746