

JACK PART NUMBER		MILITARY PART NUMBER M39012/82-
CURRENT NO.	PREVIOUS NO.	
1051090-1	2006-8004-92	3004 (Category B)
1051094-1	2006-8008-92	3008 (Category E)

Figure 1

## 1. INTRODUCTION

SMA straight cable jacks (solder clamp attachment) listed in Figure 1 are designed to be soldered to semi-rigid coaxial cable size RG 402/U with a diameter of 3.58 mm [.141 in.] using the following tools:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT NO.	PREVIOUS NO.
Cable Fixture Subassembly	1055439-1	2098-5206-54 (T-4567)
Contact Holder Assembly	1055454-1	2098-5221-10 (T-4578)
Insert Assembly	1055440-1	2098-5207-54 (T-4700-1)

The following tool is optional:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT NO.	PREVIOUS NO.
Locator Tool	----	2098-5606-02

### NOTE



Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

## 2. DESCRIPTION

Each jack consists of the components shown in Figure 1. The housing features a flange for mounting the jack to a panel.

## 3. ASSEMBLY PROCEDURE

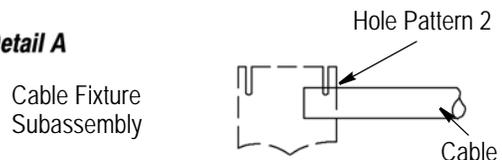
### DANGER



Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into Hole Pattern 2 of the cable fixture subassembly. Refer to Figure 2, Detail A.
2. Place a saw in the saw slot and while rotating the cable, cut through the cable jacket and into, but not through, the dielectric. Remove the cable from the cable fixture subassembly, and finish cutting the dielectric with a blade.
3. Pry the jacket and dielectric from the cable to expose the center conductor. Make sure that the center conductor meets the dimension shown in Figure 2, Detail B.

### Detail A



### Detail B

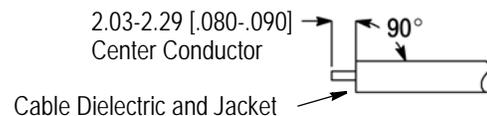


Figure 2

4. Slide the clamp nut and sleeve onto the cable.

5. Clamp the cable fixture subassembly vertically in a vise. Slide the clamp nut away from the sleeve, and position the assembly in the cable fixture subassembly. Position the end of the cable in the locator tool. Tighten the clamp screw to secure the cable. Tighten the locator tool to seat the cable firmly. Slide the sleeve against the locator tool. See Figure 3.

**NOTE**



*The cable fixture subassembly should be clamped vertically so that the sleeve stays against the locator tool.*

6. Using solder made of 60% tin and 40% lead, join the sleeve to the cable at the location shown in Figure 3.

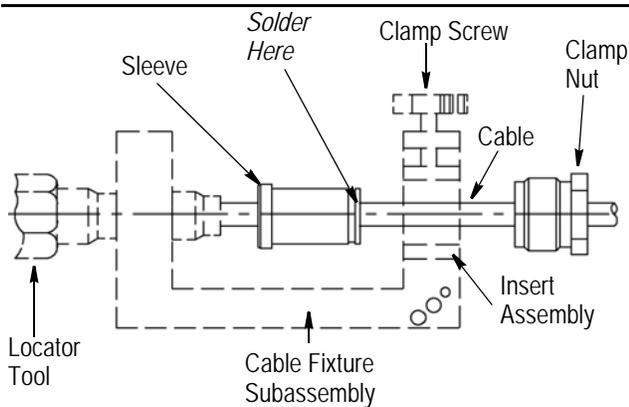


Figure 3

7. Tin the cable center conductor.

8. Slide the rear dielectric onto the cable center conductor.

9. Position the center contact in the contact holder assembly. Heat the center contact, then push it over the cable dielectric until the large diameter end of the center contact rests firmly against the rear dielectric. See Figure 4. Remove any excess solder.

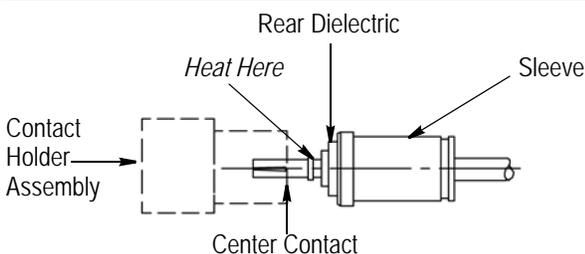


Figure 4

10. Slide the dielectric onto the center contact. Slide the clamp nut over the sleeve, then thread the clamp nut onto the housing. Tighten to a torque between 2.8 and 3.4 Nm [25 and 30 in.-lbs]. Refer to Figure 5.

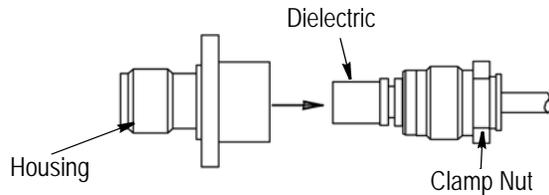


Figure 5

11. Inspect the jack according to Figure 6.

**NOTE**



*Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/82.*

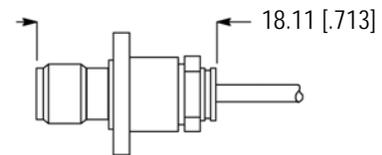


Figure 6

**4. REPLACEMENT AND REPAIR**

DO NOT re-use any soldered components by removing the cable.

Components of the jack are not repairable. Replace any defective or damaged components.

**5. PANEL MOUNTING**

1. Cut the panel using the dimensions provided in Figure 7.

2. Secure the jack to the panel using four commercially available screws.

*Recommended Panel Cutout*

**Note: Not to Scale**

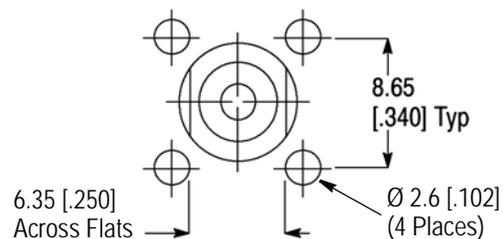


Figure 7

**6. REVISION SUMMARY**

Since the previous revision, the current TE logo has been applied.