

Plug Part Number		Plug Description	Military Part Number M39012/ (Category B)
Current	Previous		
1050932-1	2002-8203-92	Straight	81-3003
1051095-1	2006-8203-92	Flange Mount	82-3003

Figure 1

1. INTRODUCTION

SMA cable plugs (compression crimp attachment) shown in Figure 1 are designed to be crimped to semi-rigid coaxial cable size RG 405/U with a diameter of 2.16 mm [.085 in.] using the following tool:

Tool Description	Tool Part Number	
	Current	Previous
Compression Crimp Tool Kit (408-8536)	1055835-1	2598-5200-54

The following tool is optional:

Tool Description	Tool Part Number	
	Current	Previous
Hand Trim and Point Tool	1055815-1	2598-5120-54

NOTE Production tooling is available upon request.



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



2. DESCRIPTION

Each plug consists of a connector assembly with an internal contact. See Figure 1. The straight plug features a hex (shown in Figure 1). The flange mount plug features a flange for mounting the plug to a panel.

3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

- Strip the cable within the dimension given in Figure 2.

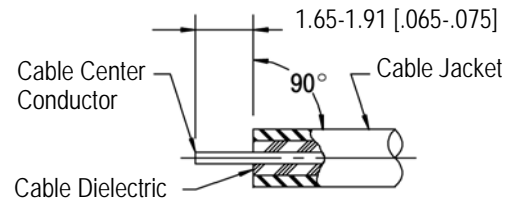


Figure 2

- File the blunt end of the cable center conductor to a cone between 85° to 90°. Refer to Figure 3.

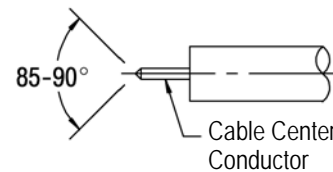


Figure 3

- Install the .085 S.R. lower cable support and the SMA/F anvil into the crimp tool. Set the tool crimp length to .530.

- Carefully insert the cable center conductor into the connector assembly (making sure to enter the contact) until the cable bottoms on the internal shoulder of the connector assembly.

- Place the connector assembly in the crimp tool so that the connector reference plane (shown in Figure 4) of the connector assembly is against the anvil and the cable sits in the lower cable support. See Figure 4.

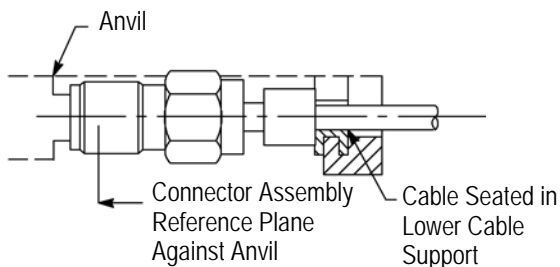
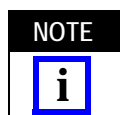


Figure 4

6. Actuate the crimp tool according to the instructions packaged with the crimp tool.

7. Remove the plug from the crimp tool, and inspect the plug according to Figure 5.



Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/81 for straight plugs and MIL-PRF-39012/82 for flange mount plugs.

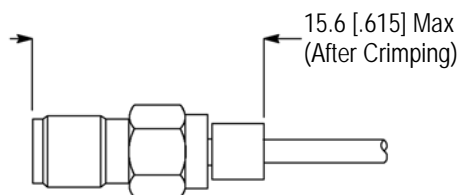


Figure 5

4. PANEL MOUNTING

1. Cut the panel using the dimensions provided in Figure 6.

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

Recommended Panel Cutout

Note: Not to Scale

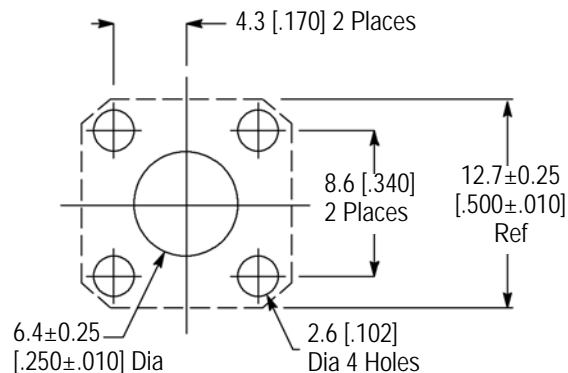


Figure 6

5. REPLACEMENT AND REPAIR

DO NOT re-use a crimped plug by removing the cable.

The plugs are not repairable. DO NOT use any defective or damaged plugs.

6. REVISION SUMMARY

Since the previous release of these instructions, the new company logo was applied.