

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Straight Cable Plug Compression Crimp Attachments 1050812-1 and 1050813-1, which are applied onto RG 405/U and .085 semi-rigid coaxial cable.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the previous part number to the TE Connectivity part number.

TOOL DESCRIPTION	TE PART NUMBER	PREVIOUS PART NUMBER
Crimp Tool Kit	1055835-1	2598-5200-54
Optional Tools		
Cable Trim Tool	1055530-1	2098-5686-54
Cable Pointer	1080269-1	2098-5685-54

Figure 2

NOTE



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

2. DESCRIPTION (Figure 1)

The cable plug compression crimp attachment consists of a connector assembly.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Cable (Figure 3)

Trim cable to the dimensions shown in Figure 3.

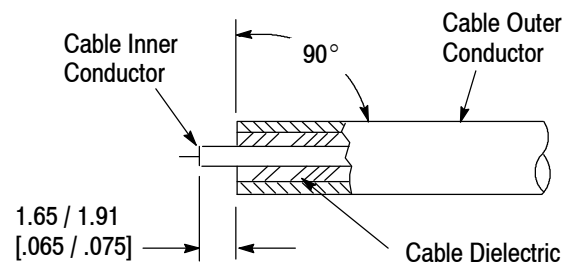


Figure 3

3.2. Shaping Inner Conductor of Cable

1. Trim inner conductor to length as shown in Figure 3.
2. File blunt end of inner conductor to an 85° to 90° cone as shown in Figure 4.

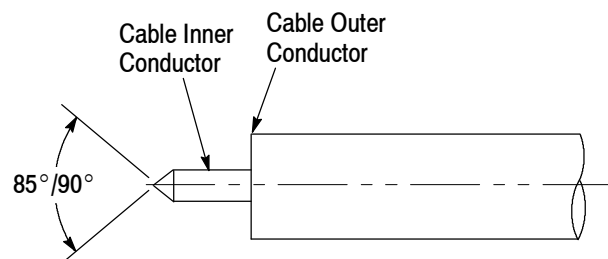


Figure 4

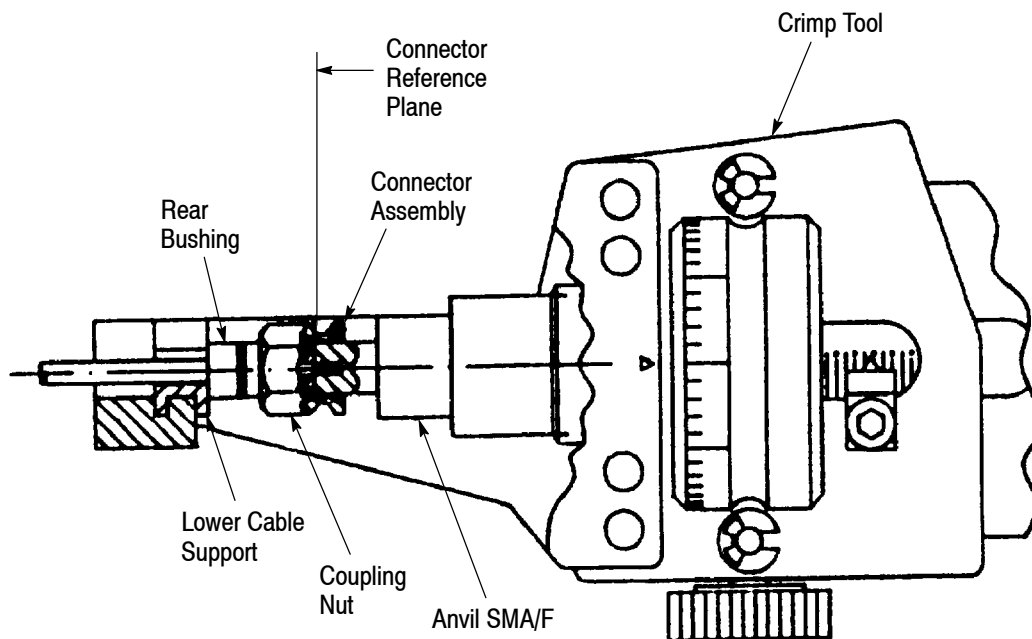


Figure 5

3.3. Installing Cable into Connector Assembly (Figure 5)

1. Install lower cable support (for .085 cable) and anvil (SMA/F) into crimp tool.
2. Set crimp length on crimp tool to 7.06 [.278].
3. Carefully insert cable inner conductor into pre-assembled center contact of connector assembly until cable bottoms on shoulder in connector assembly.
4. Place assembly into crimp tool, bottoming the connector reference plane against anvil and allowing the cable to settle in the lower cable support.
5. Squeeze handles of crimp tool until ratchet releases.
6. Assembly is now complete.

NOTE



The coupling nut of the connector assembly should be pulled completely forward and the crimp tool should be held slightly vertically, so that the coupling nut does not slide back during the crimping. This will prevent the rear bushing from hitting the coupling nut during crimping.

CAUTION



Damaged components must not be used. They must be replaced with new components.

4. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.