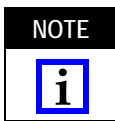


TE CONNECTIVITY PART NUMBER	DESCRIPTION	CABLE TYPE
1408442-1	SMA Straight Cable Plug Connector	Times LMR-240

Figure 1

1. INTRODUCTION

This instruction sheet describes the assembly of SMA Straight Cable Plug 1408442-1 for use with the cable listed in Figure 1. This plug connector is used in crimp-type applications.



NOTE Dimensions in this instruction sheet are in metric units [with inches in brackets], unless otherwise indicated. Figures and illustrations are for reference only and are not drawn to scale.

The tools in Figure 2 are used to apply SMA Straight Cable Plug Connector 1408442-1.

TE CONNECTIVITY PART NUMBER	PREVIOUS PART NUMBER	DESCRIPTION
REQUIRED TOOLING		
1055454-1	2098 5221 10 (T-4578)	Center Contact Holder
1060773-1	5698 5014 54 (T-4748)	Crimp Tool
1060715-1	5698 5016 54	Ferrule Crimp Die (Hex)
1055500-1	2098 5516 02 (T-4562-5)	Solder Gage
OPTIONAL TOOLING		
1055780-1	2598 5006 54	"D" Crimp Frame
1055781-1	2598 5007 54	Ferrule Crimp Die (Hex)

Figure 2

2. ASSEMBLY

2.1. Preparing the Cable End (Figure 3)

1. Place the ferrule on the cable end.

2. Remove the end portion of the cable jacket.
3. Trim the cable outer conductor (braid) and dielectric to length, as shown in Figure 3.
4. Flare the cable braid.

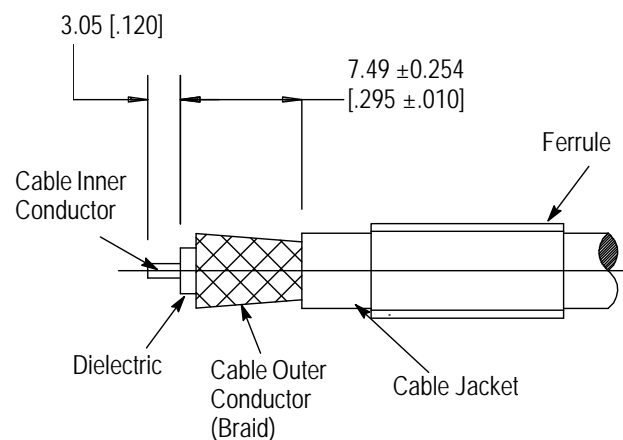


Figure 3

2.2. Soldering the Center Contact (to Inner Conductor)



Soldering equipment is hot. To avoid personal injury be sure to follow all local safety practices when working with solder.

1. Tin the inner conductor of the cable.
2. Place the solder gage on the cable as shown in Figure 4.

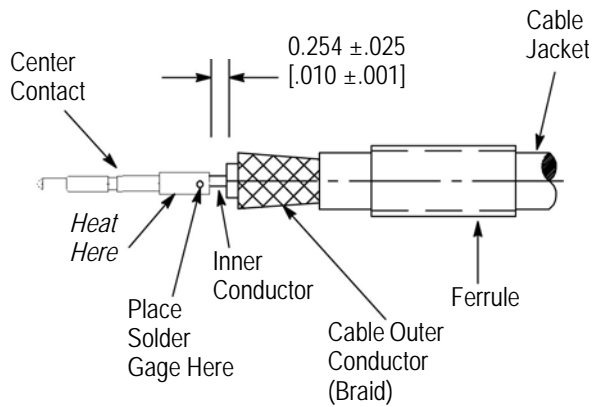


Figure 4

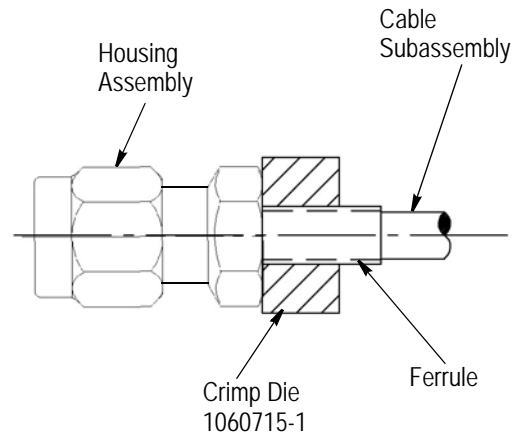


Figure 5

3. Place the contact in the holder and push it over the inner conductor as shown in Figure 4.
4. Heat the center contact as shown.
5. Remove excess solder.

2.3. Crimping the Cable to the Inner Sleeve (Figure 5)

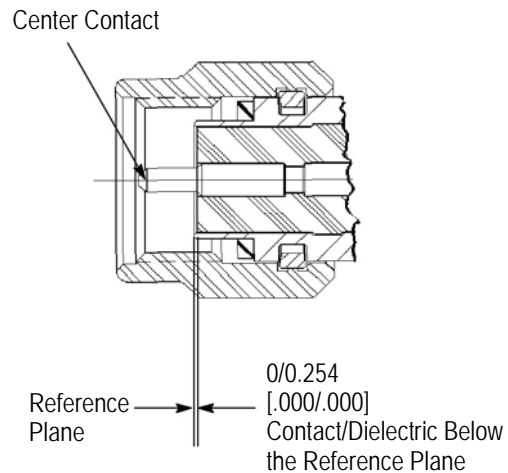
1. Insert the cable subassembly into the plug housing until the center contact “snaps” into place.
2. Slide the outer sleeve over the flared portion of the outer conductor (braid).
3. Hold the cable (firmly seated) and crimp the cable to the inner sleeve.
4. Trim and remove the excess outer conductor (braid) strands.

2.4. Inspecting the Completed Assembly

Adherence to the assembly steps should yield the tolerances shown in Figure 6.

3. REVISION SUMMARY

- New logo



Plug Interface

Figure 6