

TE CONNECTIVITY PART NO.	PREVIOUS PART NO.	CABLE TYPE	DESCRIPTION
1052030-1	2036 5016 00	RG178/U, 196, OSMT Cable	SMA Straight Cable Jacks (Crimp Attachment)
1051869-1	2032 5026 02		
1052031-1	2036 5016 02		
1051868-1	2032 5026 00		

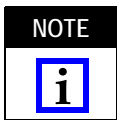
Figure 1

1. INTRODUCTION

These instructions cover the assembly of the SMA Straight Cable Jack Connectors listed in Figure 1. Figure 1 also lists the cable types required for the various connectors.

All of these connectors are used in crimp type applications.

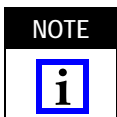
Tooling required for the application (with the exception of the military crimp dies) is listed in Figure 2.



Dimensions in this document are in metric units [with U.S. customary units in brackets], unless otherwise specified. Figures and illustrations are for reference only and are not drawn to scale.

TE PART NO.	PREVIOUS PART NO.	DESCRIPTION
1055454-1	2098 5221 10 (T-4578)	Center Contact Holder
1055236-1	2098 0105 54	Crimp Tool (Die No. A)

Figure 2



Reasons for revision can be found in SECTION 3.

2. ASSEMBLY

2.1. Preparing the Coaxial Cable End (Figure 3)

1. Place the shrink tubing and the ferrule on the cable.

2. Remove the end portion of the cable to expose the cable braid.
3. Trim the braid to the length specified in Figure 3.
4. Flare the cable braid.

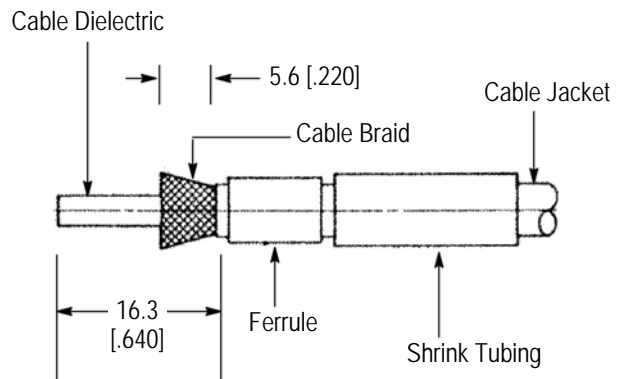


Figure 3

2.2. Crimping Cable to the Inner Sleeve

1. Insert the inner sleeve into the retaining nut.
2. Position the loose unit on the dielectric as shown in Figure 4.
3. Slide the ferrule over the flared portion of the cable braid.
4. Seat and hold the retaining nut and crimp the ferrule in place.
5. Trim the excess cable braid strands.

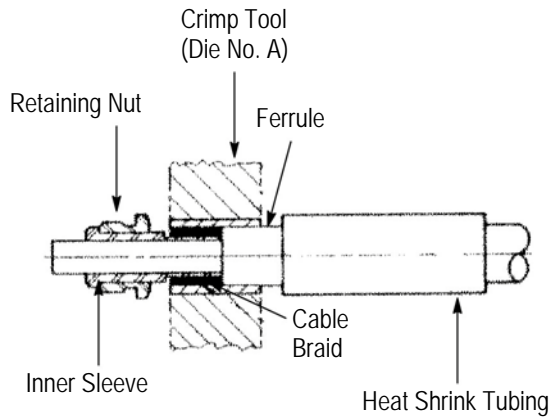


Figure 4

2.3. Soldering the Center Contact to the Cable Inner Conductor

1. Trim the cable dielectric flush with the end of the inner sleeve to expose the inner conductor.
2. Place the back-up bushing on the inner conductor.
3. Trim and de-burr the inner conductor projection to length. See Figure 5.
4. Tin the inner conductor.
5. Place the center contact socket in the center contact holder.
6. Heat the center contact with a soldering iron and gently push it on over the cable inner conductor until it rests firmly against the back-up bushing.

DANGER



To avoid personal injury and damage to OSMT cable, be sure to minimize soldering iron heat and follow all local safety practices.

7. Remove the excess solder or splatter.

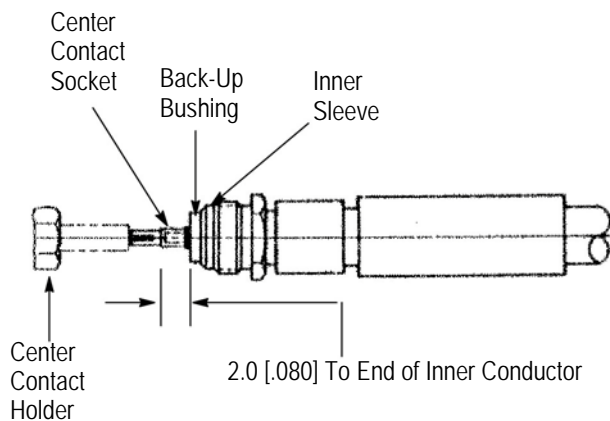


Figure 5

2.4. Completing the Assembly

1. Carefully insert the center contact into the dielectric busing inner diameter of the housing subassembly.
2. Engage the threads of the retaining nut and tighten. Torque the nut to twelve-to-fifteen inch-pounds.
3. Position the shrink tubing over the ferrule as shown in Figure 6.
4. Apply indirect heat to the shrink tubing with a heat gun.

DANGER



To avoid personal injury and damage to cable, be sure to minimize the heat.

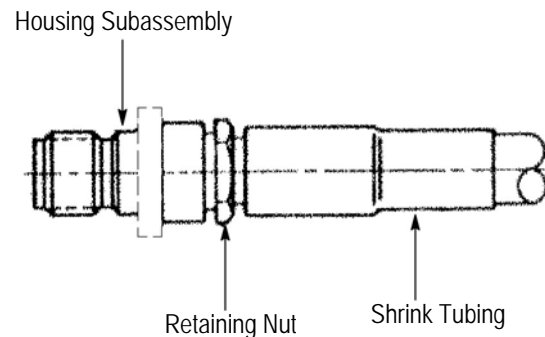


Figure 6

2.5. Inspecting the Completed Assembly

Adherence to the assembly steps should yield the tolerances shown in Figure 7.

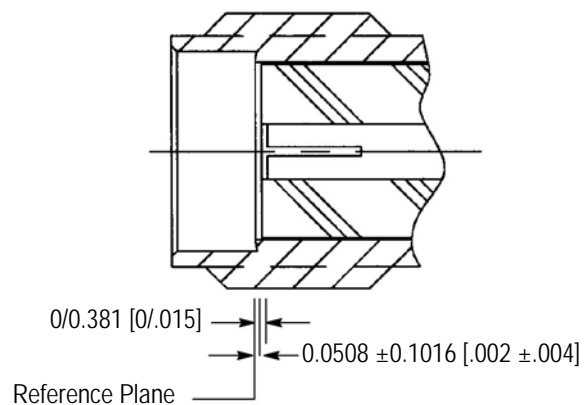


Figure 7

3. REVISION SUMMARY

- New logo