

Figure 1

1. INTRODUCTION

SMT Straight Cable Plug (Crimp Attachment) 1051664-1, 1051665-1, and 1311077-1 are designed to be crimped onto coaxial cable sizes RG 174/U, 179, 187, 188, and 316 using the following tools:

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	TE CONNECTIVITY	M/A-COM
Center Contact Holder	1055454-1	2098-5221-10 (T-4578)
Crimp Tool (Die A)	1055236-1	2098-0105-54

NOTE



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

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

The plug consists of a housing subassembly, dielectric, center contact, back-up bushing, inner sleeve, retaining nut, outer sleeve, and sheath. Refer to Figure 1.

3. ASSEMBLY PROCEDURE

DANGER



Follow safety precautions included with the tools used for assembly.

- Slide the sheath, then the outer sleeve onto the cable. Strip the cable to the dimensions shown in Figure 2. Take care not to nick the dielectric. Flare the braid.
- Insert the inner sleeve into the retaining nut. Slide the assembly over the dielectric and under the braid until the assembly bottoms. Refer to Figure 3, Detail A.
- Slide the outer sleeve over the braid. Holding the retaining nut in position, crimp the outer sleeve in place. Trim excess braid strands. Strip the dielectric

flush with the end of the inner sleeve to expose the conductor. Refer to Figure 3, Detail B.

- Slide the back-up bushing onto the conductor until it butts against the inner sleeve. Trim and de-burr the conductor to the dimension shown in Figure 3, Detail C.

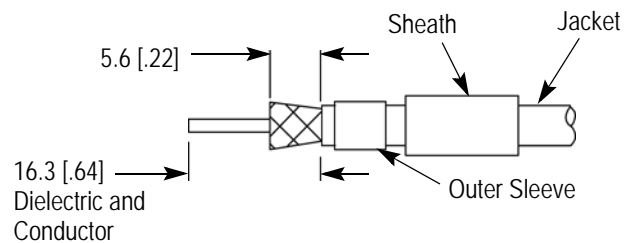
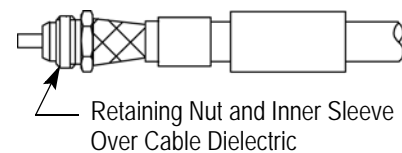
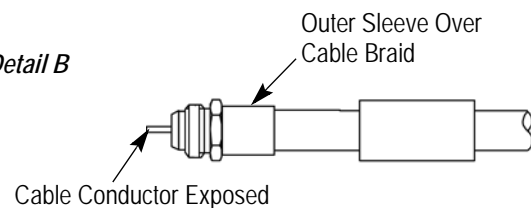


Figure 2

Detail A



Detail B



Detail C

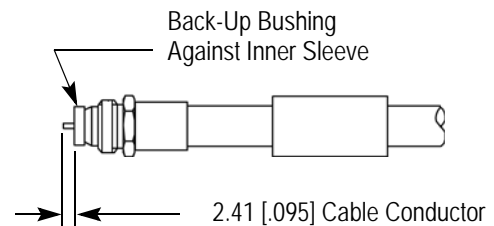


Figure 3

5. Tin the conductor.
6. Place the center contact in the center contact holder. Heat the center contact with a soldering iron, then carefully push the center contact over the conductor until it rests firmly against the back-up bushing. See Figure 4, Detail A. Remove excess solder and splatter.
7. Slide the plug dielectric over the center contact until it bottoms. See Figure 4, Detail B.
8. Screw the housing subassembly onto the retaining nut, and tighten to a torque between 1.36 and 1.81 N•m [12 and 16 in.-lbs.]. See Figure 4, Detail C.
9. Slide the sheath over the outer sleeve until the ends are aligned. Using a heat gun, apply direct heat to the sheath until the sheath has shrunk and is secured to the cable. Refer to Figure 4, Detail D.
10. Adherence to assembly procedure should yield tolerances shown in Figure 5.

4. REVISION SUMMARY

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

- Updated document to corporate requirements

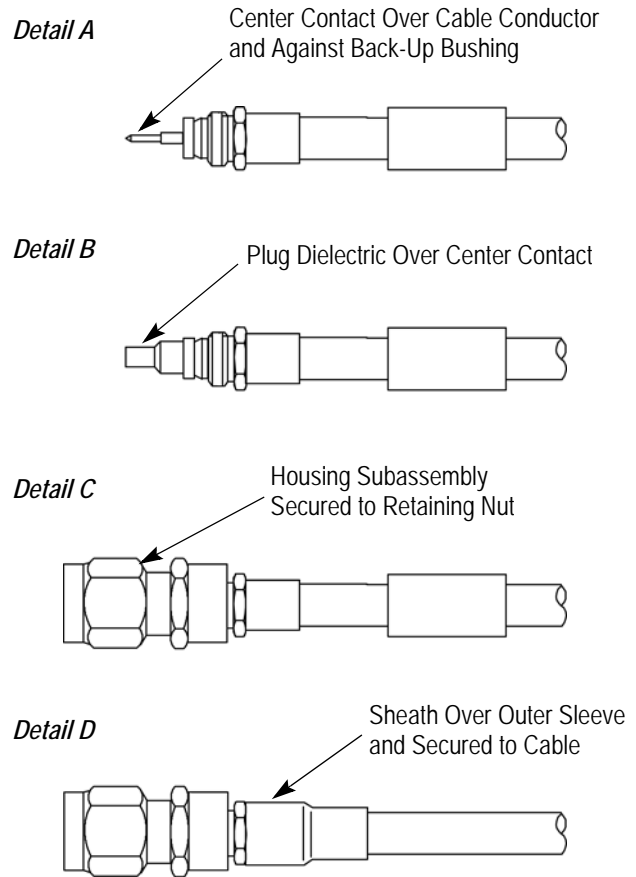


Figure 4

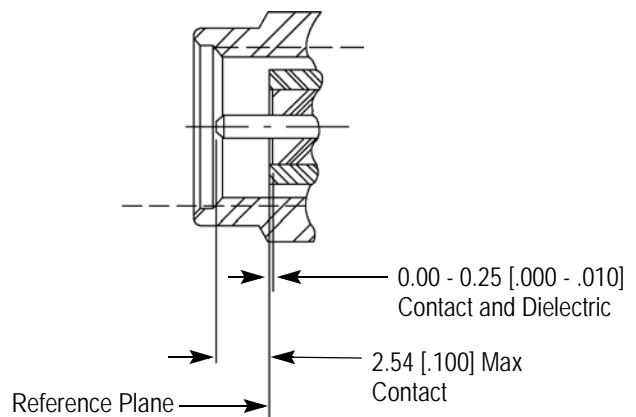


Figure 5