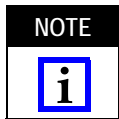


Figure 1

## 1. INTRODUCTION

This instruction sheet covers the assembly procedure for SMA Bulkhead Feed-Through Cable Jack Solder Attachment 1051942-1, which may be applied to RG-174/U, 179, 187, 188, or 316 cable.



*Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.*

Reasons for reissue are provided in Section 4, REVISION SUMMARY.

## 2. DESCRIPTION

The cable jack consists of a mounting nut, lockwasher, housing subassembly, center contact, outer sleeve, and a sheath. See Figure 1.

Tools applicable to the cable jack are listed in Figure 2.

DESCRIPTION	CURRENT PART NUMBER	PREVIOUS PART NUMBER
Center Contact Holder	1055454-1	2098-5221-10 (T-4578)
Solder Gauge	91362-1	2098-5212-02 (T-4562-1)
Locator Tool	1055446-1	2098-5213-02 (T-948)

Figure 2

## 3. ASSEMBLY PROCEDURE

### 3.1. Preparing Coaxial Cable End (Figure 3)

1. Place the sheath and outer sleeve on the cable.
2. Remove the end portion of the cable jacket to expose the cable outer conductor.
3. Trim the outer conductor, cable dielectric, and inner conductor to the length given in Figure 3.

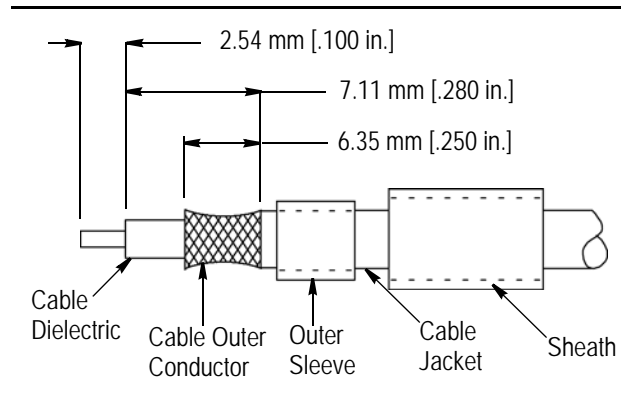


Figure 3

4. Flare the outer conductor.

### 3.2. Solder Center Contact to Cable Inner Conductor (Figure 4)

1. Tin the inner conductor.
2. Place the center contact in the holder.
3. Heat the center contact with the soldering iron, and carefully push it over the inner conductor to rest firmly against the gauge.
4. Remove excess solder or splatter.

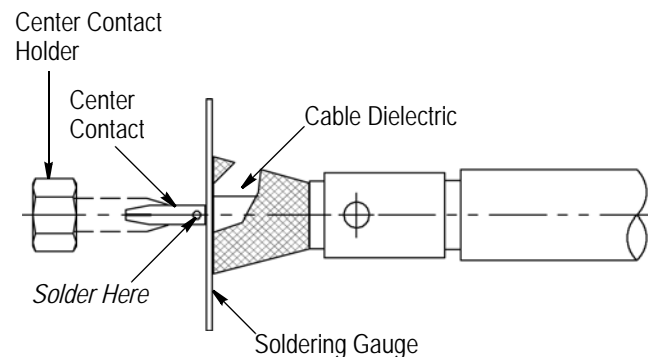


Figure 4

### 3.3. Solder Cable to Housing Subassembly (Figure 5)

1. Secure the locator tool to the threads of the housing subassembly.
2. Position and secure the housing subassembly in a small bench vise.
3. Insert the cable into the housing subassembly and seat firmly.
4. Slide out the sleeve over the flared portion of the outer conductor.
5. Hold the cable firmly seated and solder through the holes in the outer sleeve.
6. Trim and remove excess outer conductor strands.

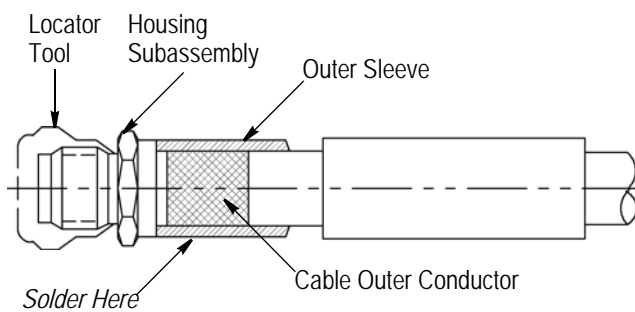


Figure 5

### 3.4. Shrink Sheath to Cable

1. Position the sheath over the outer sleeve as shown in Figure 6.
2. Apply indirect heat with a thermo gun to shrink the sheath.
3. Remove the locator tool.

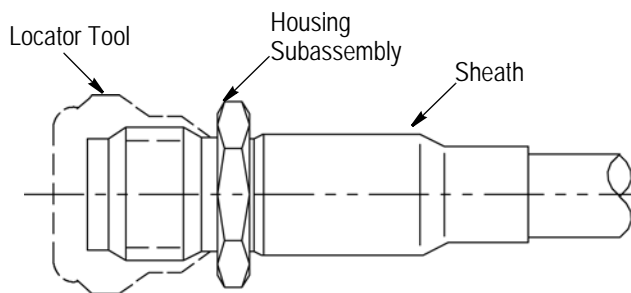
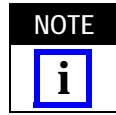


Figure 6

### 3.5. Inspection of Completed Connector Assembly

Adherence to the assembly procedure will yield tolerances given in Figure 7.



*Damaged product should not be used. If a damaged component is evident, it should be replaced with a new one.*

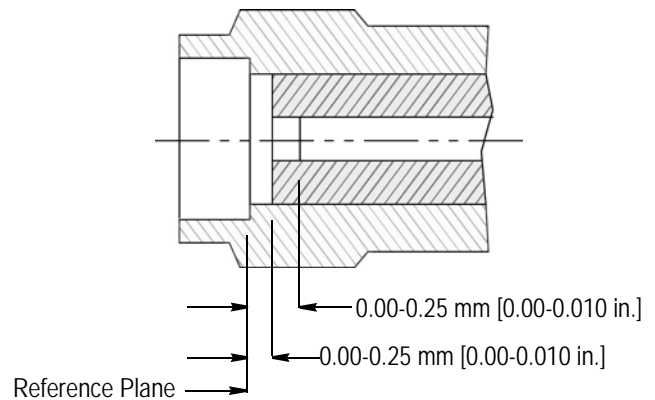


Figure 7

### 4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Added “solder here” to Figure 4
- Changed dimensions in Figure 7