

JACK PART NUMBER	
CURRENT	PREVIOUS
1056527-1	2902-7985-62

Figure 1

1. INTRODUCTION

SMP jack (direct solder attachment) shown in Figure 1 is designed to be soldered to semi-rigid coaxial cable size RG 405/U with a diameter of 2.16 mm [.085 in.] using the following tools:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Cable Fixture Subassembly	1055439-1	2098-5206-54 (T-4567)
Solder Gage	91362-6	2098-5516-02 (T-4562-5)
Locator Tool (For Center Contact)	1055888-1	2598-5407-02
Insert Assembly	1055441-1	2098-5208-54 (T-4700-2)
Locator Tool (For Housing Subassembly)	1055887-1	2598-5406-02

The jack consists of a housing subassembly and center contact. See Figure 1.



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. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into Hole Pattern 2 of the cable fixture subassembly. Refer to Figure 2.
2. Place a saw in the saw slot and while rotating the cable, cut through the cable jacket and into, but not through, the dielectric. Remove the cable from the cable fixture subassembly, and finish cutting the dielectric with a blade.
3. Pry the jacket and dielectric from the cable to expose the center conductor. Make sure that the center conductor meets the dimension shown in Figure 2.

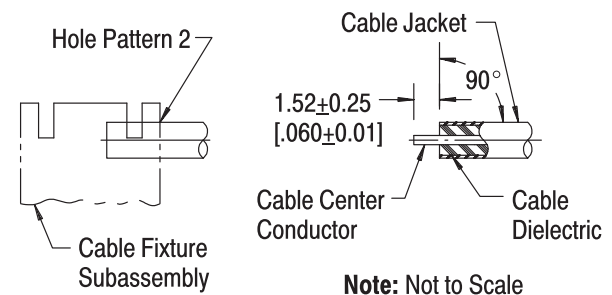


Figure 2

4. Tin the cable center conductor.
5. Place the cable in the solder gage so that it is flush with the cable jacket.
6. Place the center contact in the locator tool (for center contact). Heat the center contact, and slide it onto the center conductor until it rests firmly against the solder gage. See Figure 3.

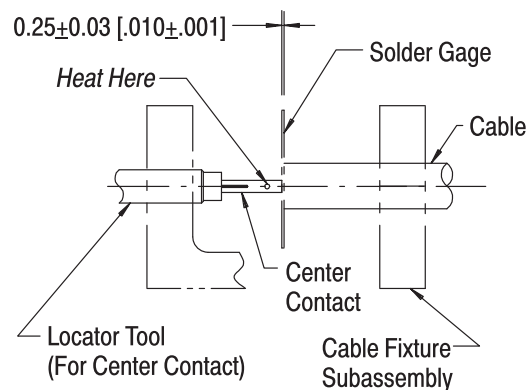


Figure 3

7. Remove solder gage and excess solder.

8. Insert the center contact into the housing subassembly until it bottoms.
9. Place the assembly in the cable fixture subassembly as shown in Figure 4. Tighten the clamp screw to secure the cable, and tighten the locator tool to seat the housing subassembly firmly against the cable.
10. Using solder made of 60% tin and 40% lead, join the housing subassembly to the cable at the location shown in Figure 4.

3. REPLACEMENT AND REPAIR

DO NOT re-use a soldered center contact or housing subassembly by removing the cable.

Components of the jack are not repairable. Replace any defective or damaged components.

4. REVISION SUMMARY

The following revisions were made since the previous release:

- Dimensions in Figure 2 and Figure 5 were corrected
- Tyco Electronics logo was updated

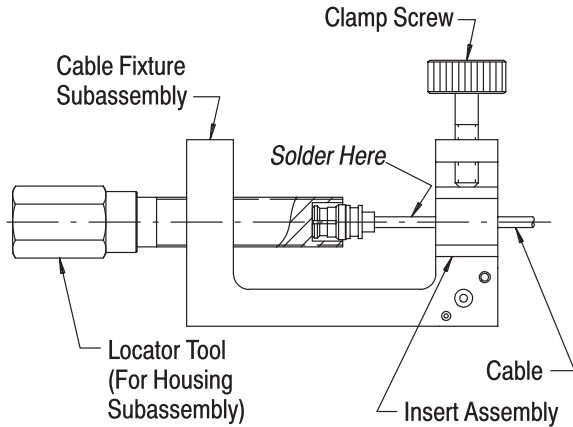


Figure 4

11. Adherence to assembly procedure should yield tolerances shown in Figure 5.

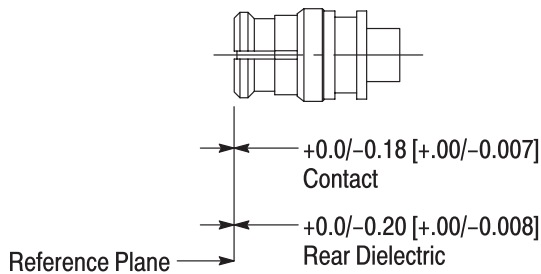


Figure 5