

Figure 1

1. INTRODUCTION

SSMA Straight Cable Jack (Solder Attachment) 1045497-1 is designed to be soldered onto coaxial cable sizes RG 174/U, 179, 187, 188, or 316 using the following tools:

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	TE PART NUMBER	PREVIOUS PART NUMBER
Center Contact Holder	1055463-1	2098-5237-10 (T-4579)
Locator Tool	1055464-1	2098-5238-02 (T-2108)

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 jack consists of a housing subassembly, center contact, ferrule, and shrink tubing. Refer to Figure 1.

3. ASSEMBLY PROCEDURE

DANGER



Follow safety precautions included with the tools used for assembly.

1. Slide the shrink tubing, then the ferrule onto the cable. Strip the cable to the dimensions shown in Figure 2. Take care not to nick the conductor. Flare the cable braid.

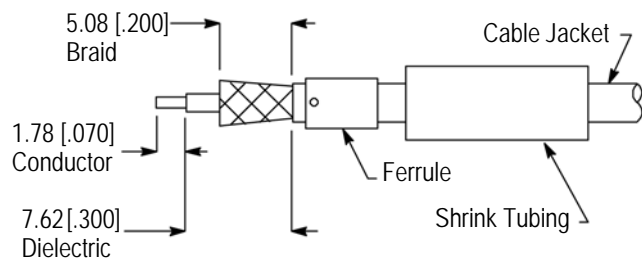
2. Tin the cable conductor.

3. 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 cable conductor until it rests firmly against the

dielectric. See Figure 3, Detail A. Remove center contact holder. Remove excess solder and splatter.

4. Secure the threaded end of the housing subassembly onto the locator tool. Secure the assembly in a small bench vise.

5. Insert the center contact into the back of the housing subassembly until the center contact is seated firmly. Make sure that the cable braid does not enter the housing subassembly. See Figure 3, Detail B.



Note: Not to Scale

Figure 2

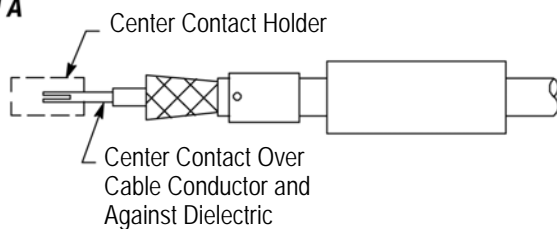
6. Slide the ferrule over the cable braid. Holding the cable in place, solder through the holes in the ferrule. Trim excess braid strands. Refer to Figure 4, Detail A.

7. Slide the shrink tubing over the ferrule until the ends are aligned. Using a heat gun, apply indirect heat to the shrink tubing until it has shrunk and is secured to the cable. Refer to Figure 4, Detail B.

8. Remove the assembly from the locator tool.

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

Detail A



Detail B

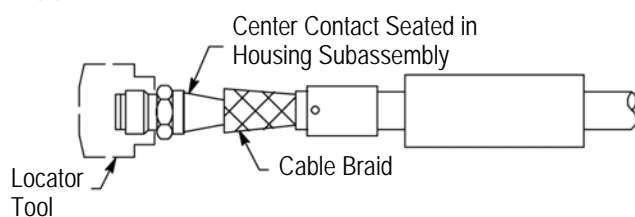


Figure 3

4. REVISION SUMMARY

These instructions were revised to include the new company logo.

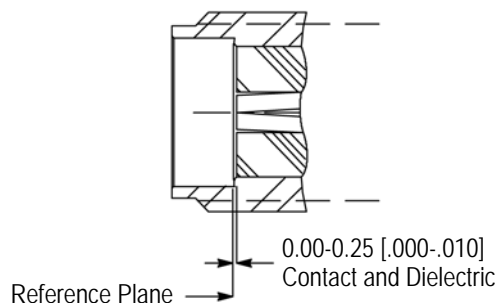
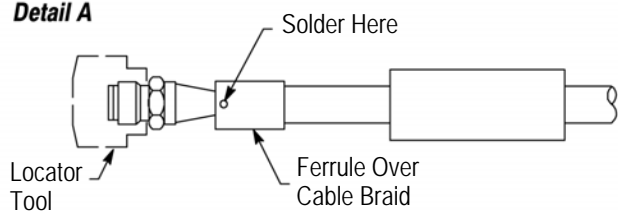


Figure 5

Detail A



Detail B

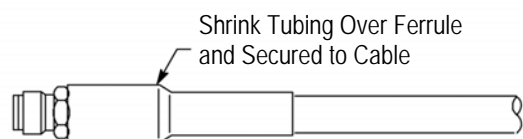


Figure 4