

TE PART NUMBER	MILITARY P/N M39012/58-	PREVIOUS PART NUMBER	CABLE TYPE	CRIMP DIE M22520/5-	CRIMP CLOSURE	DIM. "A"	DIM. "B"	DIM. "C"	DIM. "D"
1052046-1	-3025	2036-8025-92	RG 178/U	-03 -33	B B	0.56 [.022]	0.56 [.022]	0.94 [.037]	2.57 [.101]
1052047-1	-3026	2036-8026-92	RG 174/U RG 316/U	-03 -035	A B	0.56 [.022]	0.56 [.022]	1.70 [.067]	3.25 [.128]

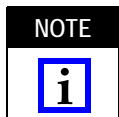
Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Straight Cable Plugs (Crimp Attachments), shown in Figure 1. These plugs are applied onto RG 178/U, RG 174/U, and RG 316/U coaxial cable.

The table below represents tool numbers applicable to this instruction sheet. The table references the previous part number to the TE part number.

DESCRIPTION	TE PART NUMBER	PREVIOUS PART NUMBER
Crimp Tool	N/A	M22520/5-01
Center Contact Holder (Optional)	1055454-1	2098-5221-10



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

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

2. DESCRIPTION (Figure 1)

The straight cable plugs consist of a housing sub-assembly, center contact, back-up bushing, inner sleeve, retaining nut, and outer sleeve.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Coaxial Cable End (Figure 2)

1. Place outer sleeve on cable.
2. Remove end portion of cable jacket to expose cable outer conductor.
3. Trim outer conductor to length.
4. Trim cable dielectric to length.
5. Trim inner conductor to length.
6. Flare outer conductor.

3.2. Crimping Cable to Inner Sleeve (Figure 3)

1. Tin inner conductor of cable.
2. Assemble inner sleeve into clamp nut.
3. Position and secure inner sleeve in a small bench vise.

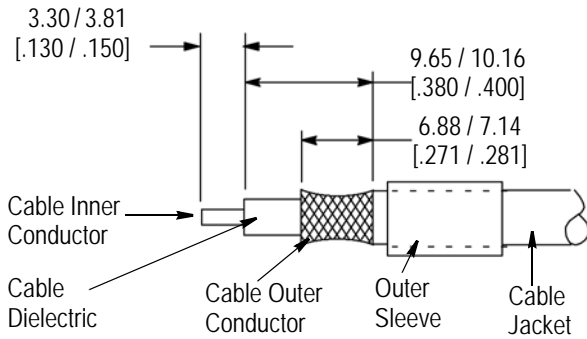


Figure 2

4. Insert cable dielectric into inner sleeve and seat firmly.
5. Slide outer sleeve over flared portion of outer conductor.
6. Hold cable firmly seated and solder outer sleeve in place.
7. Trim and remove excess outer conductor strands.
8. If necessary, trim cable dielectric flush to face of inner sleeve.

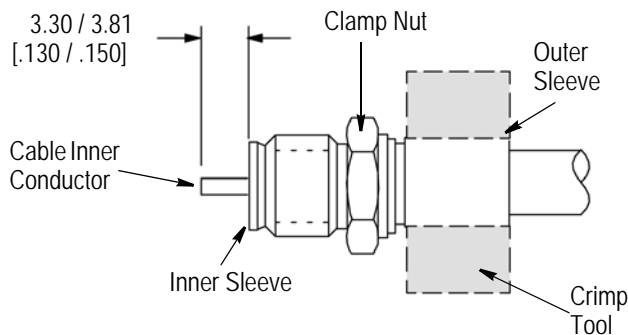


Figure 3

3.3. Soldering of Center Contact to Cable Inner Conductor (Figure 4)

1. Place center contact in holder, heat center contact, and push it over inner conductor of cable to rest firmly against rear dielectric.
2. Remove excess solder.



Damaged components must not be used. They must be replaced with new components.

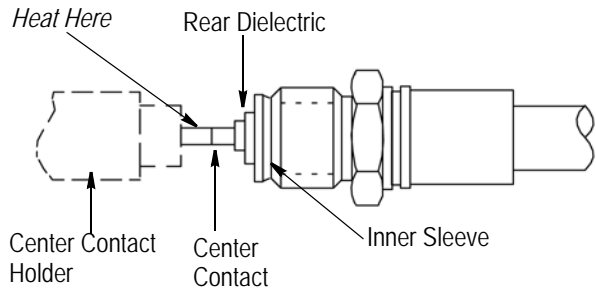


Figure 4

3.4. Securing Housing to Inner Sleeve Sub-Assembly (Figure 5)

1. Assemble dielectric over center contact.
2. Engage threads of inner sleeve sub-assembly to housing and torque to 1.36 - 1.70 Nm [12-15 in-lb].

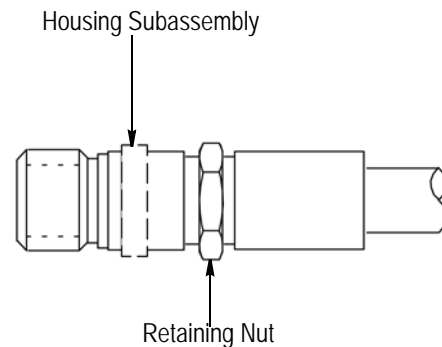


Figure 5

4. REVISION SUMMARY

Since the previous release of this instruction sheet, the current TE logo has been applied.