

PART NUMBER			
TE CONNECTIVITY		CABLE TYPE	DIMENSION "A"
CURRENT	PREVIOUS		
1050605-1	2001-5397-02	RG 402/U	3.66 [.133] Min
1050609-1	2001-5431-02	RG 405/U	2.26 [.089] Min

NOTE: Adherence to steps given will yield tolerances shown on drawings.

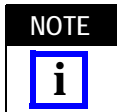
Figure 1

## 1. INTRODUCTION (Figure 1)

SMA Straight Cable Plugs (Direct Solder Attachment) 1050605-1 and 1050609-1 are designed to be soldered onto semi-rigid coaxial cable using the following tools shown in Figure 2.

TOOL DESCRIPTION	PART NUMBER CROSS REFERENCE	
	TE	PREVIOUS
Locator Tool	1055451-1	2098-5218-02
Clamp Inserts	1055440-1	2098-5207-54
Fixture Base	1055439-1	2098-5206-54

Figure 2



NOTE: 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 3, REVISION SUMMARY.

## 2. ASSEMBLY PROCEDURE

### 2.1. Preparation of Cable



Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into the fixture base hole pattern No. 2. as shown in Figure 3.
2. Place saw in saw slot and cut through outer conductor and into dielectric while rotating cable.

3. Remove cable from fixture and finish cutting dielectric with cutting blade.

4. Bare inner conductor by prying cut outer conductor and dielectric from cable.

5. Complete trimming of cable inner conductor to dimension shown in Figure 3.

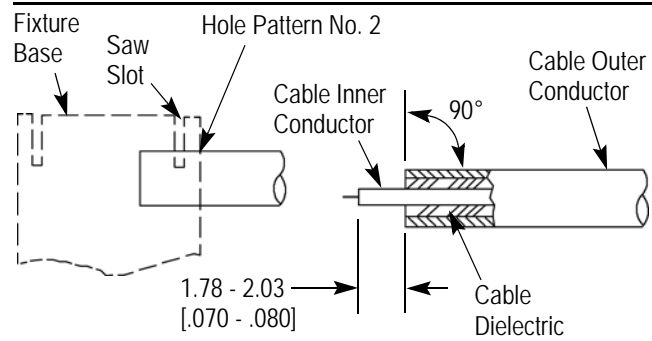


Figure 3

6. Shape the blunt end of the inner conductor to an 85° to 90° cone as shown in Figure 4.

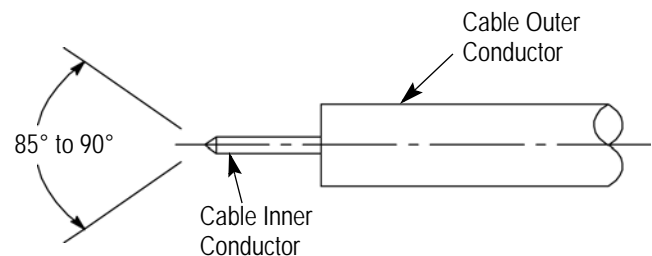
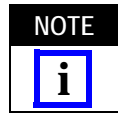


Figure 4

## 2.2. Soldering of Cable to Housing Sub-Assembly

1. Assemble the cable into the housing sub-assembly.
2. Carefully insert the cable inner conductor into the pre-assembled center contact of the housing sub-assembly.
3. Place the loose assembly in fixture base as shown in Figure 5.
4. Tighten the clamp screw to secure the cable.
5. Tighten the locator tool to seat the housing sub-assembly firmly.
6. Maintain position of the housing sub-assembly firmly against the locator tool and solder.



*Fixture base should be clamped vertical in a vise to keep housing sub-assembly seated against locator tool.*



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

## 3. REVISION SUMMARY

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

- Updated document to corporate requirements.

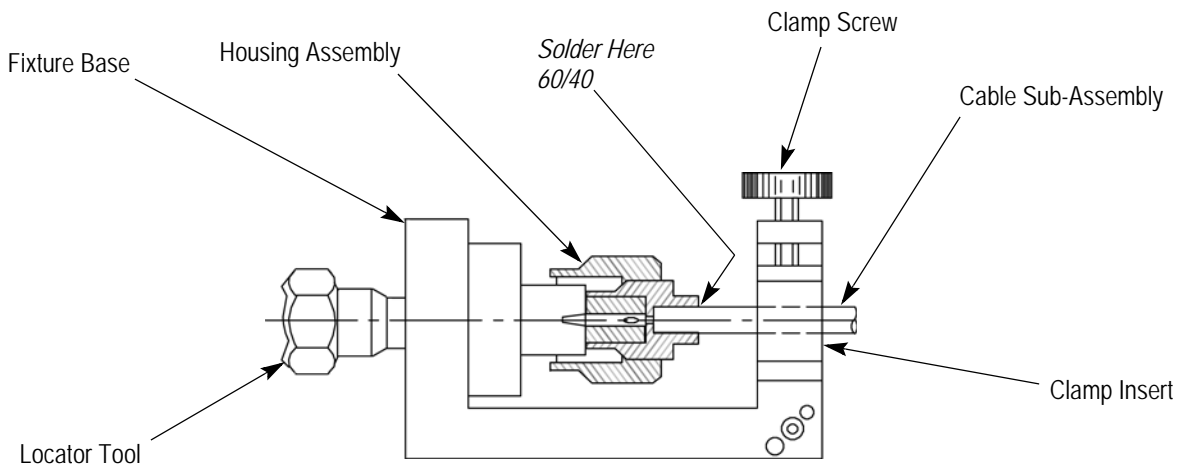


Figure 5