

PLUG PART NUMBER		MILITARY PART NUMBER M39012/56B-	CABLE (RG/U)	CRIMP TOOL DIE CLOSURE	PLUG DIMENSION (mm [in.])	
CURRENT	PREVIOUS				A	B
1052156-1	2037-8011-92	3011	178	A	0.94 [.037]	2.56 [.101]
1052186-1	2037-8111-92	3111■				
1052157-1	2037-8012-92	3012	174, 316	C	1.70 [.067]	3.25 [.128]
1052187-1	2037-8112-92	3112■				
1052158-1	2037-8013-92	3013	122	D	2.54 [.100]	4.45 [.175]
1052188-1	2037-8113-92	3113■				
1052159-1	2037-8014-92	3014	58	B	3.10 [.122]	5.21 [.205]
1052189-1	2037-8114-92	3114■				
1052160-1	2037-8015-92	3015	142	B	3.10 [.122]	5.56 [.219]
1052190-1	2037-8115-92	3115■				
1052161-1	2037-8016-92	3016	223	B	3.10 [.122]	5.56 [.219]
1052191-1	2037-8116-92	3116■				
1052162-1	2037-8017-92	3017	303	B	3.10 [.122]	5.21 [.205]
1052192-1	2037-8117-92	3117■				
1052163-1	2037-8018-92	3018	178	A	0.94 [.037]	2.56 [.101]
1052193-1	2037-8118-92	3118■				
1052165-1	2037-8019-92	3019	174, 316	C	1.70 [.067]	3.25 [.128]
1052194-1	2037-8119-92	3119■				
1052166-1	2037-8020-92	3020	122	D	2.54 [.100]	4.45 [.175]
1052195-1	2037-8120-92	3120■				
1052167-1	2037-8021-92	3021	58	B	3.10 [.122]	5.21 [.205]
1052196-1	2037-8121-92	3121■				
1052168-1	2037-8022-92	3022	142	B	3.10 [.122]	5.56 [.219]
1052197-1	2037-8122-92	3122■				
1052169-1	2037-8023-92	3023	223	B	3.10 [.122]	5.56 [.219]
1052198-1	2037-8123-92	3123■				
1052170-1	2037-8024-92	3024	303	B	3.10 [.122]	5.21 [.205]
1052199-1	2037-8124-92	3124■				

■ No safety wire holes

Figure 1

1. INTRODUCTION

SMA right-angle cable plugs (crimp attachment) listed in Figure 1 are designed to be soldered to the corresponding cable sizes using the following tools.

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Locator Tool	1055451-1	2098-5218-02 (T-2367)
Crimp Tool	1055236-1	2098-0105-54



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

2. DESCRIPTION

The plug consists of the components shown in Figure 1. The housing subassembly contains a contact.

3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

1. Slide the outer sleeve onto the cable.
2. Strip the cable to the dimensions shown in Figure 2. Flare the cable braid.

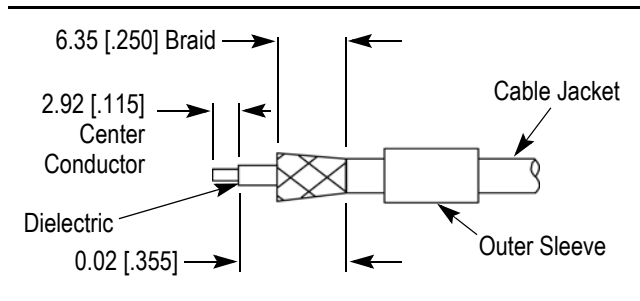


Figure 2

3. Secure the housing subassembly to the locator tool as shown in Figure 3. Secure the housing subassembly in a small bench vise.
4. Tin the cable center conductor.
5. Insert the center conductor into the housing subassembly making sure that the center conductor sits in the contact slot and the dielectric is against the contact. See Figure 3.
6. Place the soldering iron on the tip of the contact, and solder. Refer to Figure 3.
7. Slide the outer sleeve over the cable braid, and crimp the outer sleeve. Refer to Figure 3. Trim excess braid strands.

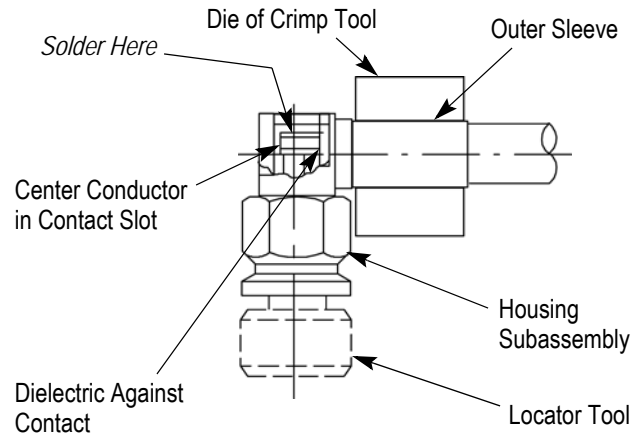


Figure 3

8. Press the disc into the opening at the back of the housing subassembly. See Figure 4. Remove the assembly from the locator tool. If preferred, apply epoxy to the disc to hold it in place. **DO NOT** allow epoxy to penetrate the housing subassembly.

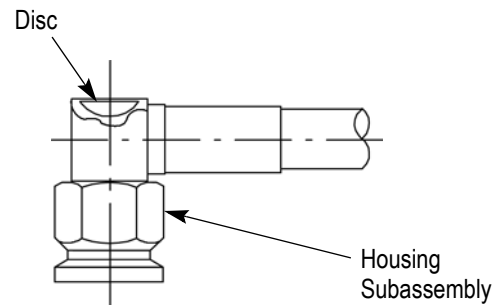


Figure 4

4. REPLACEMENT AND REPAIR

DO NOT re-use any crimped or soldered components by removing the cable. **DO NOT** re-use the disc after it has been assembled to the plug.

Components of the plug are not repairable. **DO NOT** use any defective or damaged components.

5. REVISION SUMMARY

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

- Updated document to corporate requirements.