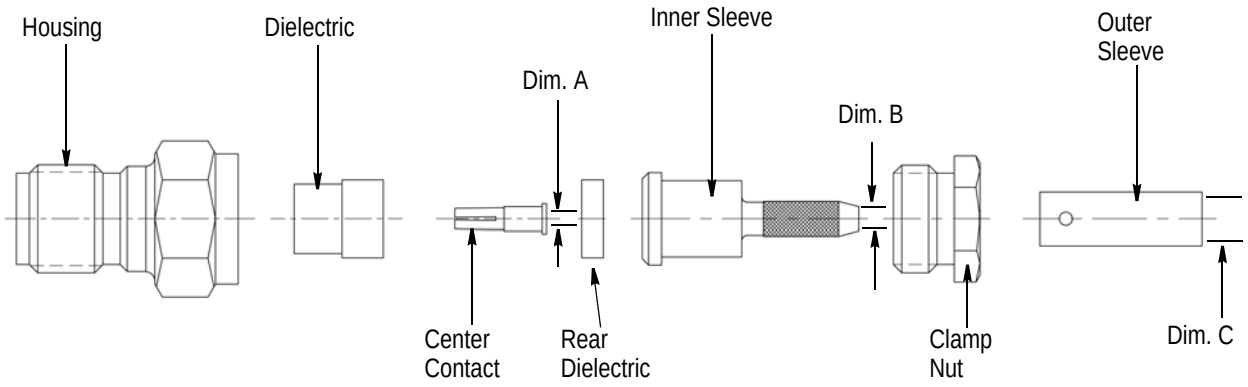
SMA Straight Cable Jack (Solder Attachment)



JACK PART NUMBER			CABLE TYPE	JACK DIMENSION (mm [In.])		
TE PART NUMBER	PREVIOUS PART NUMBER	MILITARY M39012/57		A	B	C
1090174-1	2032 8006 92	3006	RG178/U	0.56 [.022]	0.94 [.037]	2.56 [.101]
1051900-1	2032 8007 92	3007	RG174/U, RG316/U	0.56 [.022]	1.70 [.067]	3.25 [.128]

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly procedures for the SMA Straight Cable Jacks listed in the table in Figure 1. The table also includes the cable type

NOTE

Dimensions in these instructions are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

2. ASSEMBLY PROCEDURES

2.1. Coaxial Cable Preparation

Slide the ferrule over the cable. Trim the cable to the dimensions shown in Figure 2.

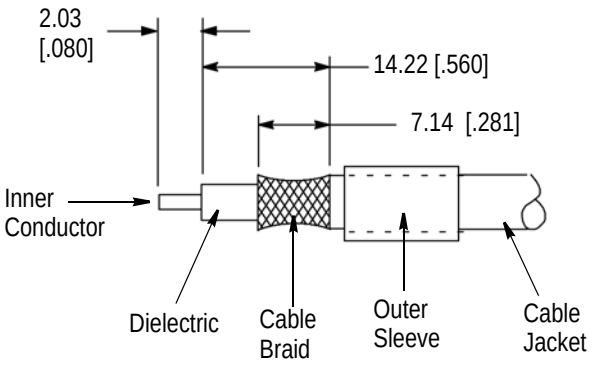


Figure 2

2.2. Soldering the Cable to the Inner Sleeve

DANGER

Soldering equipment is hot. To avoid personal injury, be sure to follow all local and safety practices (including wearing gloves).

1. Tin the center conductor of the cable.
2. Position and secure inner sleeve in a small bench vise.
3. Insert cable into inner sleeve and seat firmly.
4. Slide outer sleeve over flared portion of cable braid.
5. Hold cable firmly seated and solder outer sleeve in place.

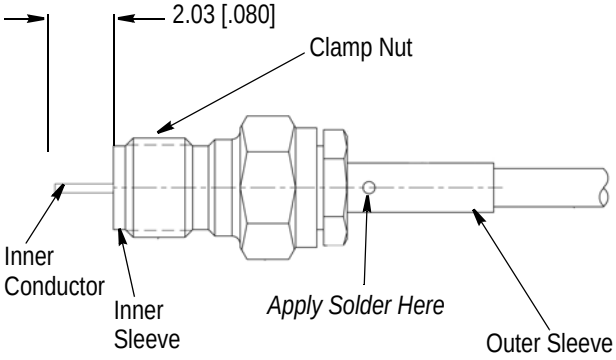


Figure 3

TOOLING ASSISTANCE CENTER 1-800-722-1111
PRODUCT INFORMATION 1-800-522-6752

6. Trim and remove excess cable braid strands.

2.3. Soldering the Center Contact to the Cable Inner Conductor

1. Insert rear dielectric over inner conductor until it seats firmly against the inner sleeve. See Figure 4.

2. Place the center contact in Center Contact Holder 1055454-1 (optional).

3. Heat center contact and push it over the inner conductor of the cable to rest firmly against the rear dielectric.

4. Remove excess solder.

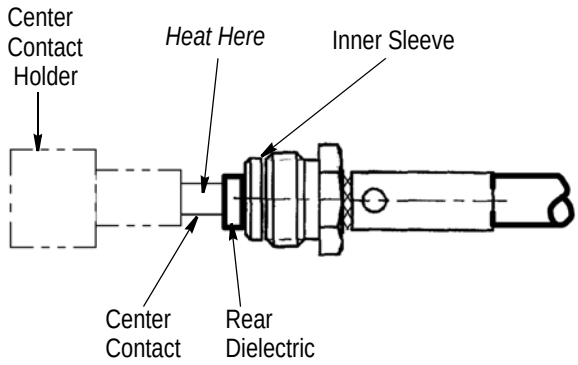


Figure 4

2.4. Secure Housing to Inner Sleeve

1. Place dielectric over center contact. See Figure 5.

2. Engage threads of inner sleeve to housing. Torque to 12-15 In.-lbs.

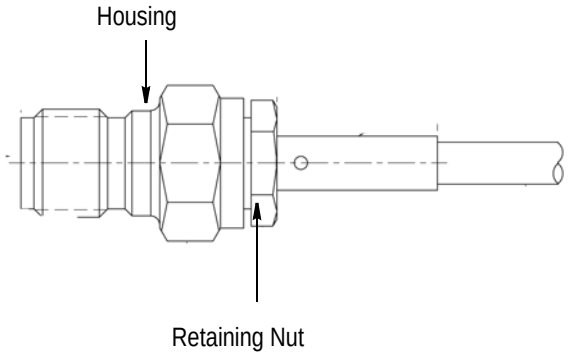


Figure 5

3. REPLACEMENT AND REPAIR

\Do NOT re-use a soldered contact or outer sleeve.

Components of the jack are not repairable. Remove and replace any defective or damaged components.

4. REVISION SUMMARY

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