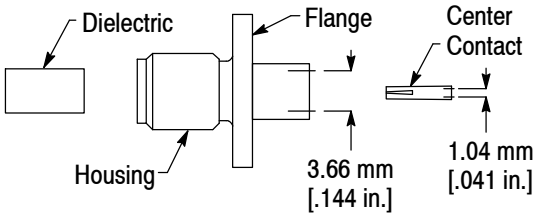


JACK PART NUMBER		MILITARY PART NUMBER M39012/82- (Category B)
CURRENT	PREVIOUS	
1051088-1	2006-8002-90	3002
1051092-1	2006-8006-90	3006

Figure 1

1. INTRODUCTION

SMA flange mount cable jacks (direct solder attachment) listed in Figure 1 are designed to be soldered to .141 semi-rigid coaxial cable size RG 402/U with a diameter of 3.58 mm [.141 in.] using the following tools:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Cable Fixture Subassembly	1055439-1	2098-5206-54 (T-4567)
Solder Gage	91362-6	2098-5516-02 (T-4562-5)
Contact Holder Assembly	1055454-1	2098-5221-10 (T-4578)
Insert Assembly	1055440-1	2098-5207-54 (T-4700-1)
Locator Tool	1055443-1	2098-5210-02 (T-4569)
Dielectric Insert Tool	1055448-1	2098-5215-02 (T-4551)

NOTE

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

2. DESCRIPTION

Each jack consists of the components shown in Figure 1. The housing features a flange for mounting the jack to a panel.

3. ASSEMBLY PROCEDURE

DANGER

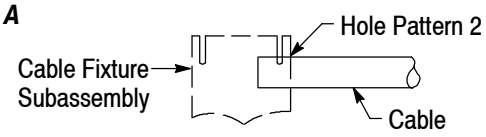
Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into Hole Pattern 2 of the cable fixture subassembly. Refer to Figure 2, Detail A.

2. Place a saw in the saw slot and while rotating the cable, cut through the cable jacket and into, but not through, the dielectric. Remove the cable from the cable fixture subassembly, and finish cutting the dielectric with a blade.

3. Pry the jacket and dielectric from the cable to expose the center conductor. Make sure that the center conductor is within the dimension shown in Figure 2, Detail B.

Detail A



Detail B

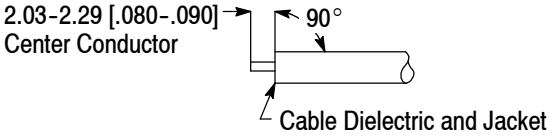


Figure 2

4. Tin the cable center conductor.

5. Place the center conductor in the solder gage. Align the end of the cable jacket with the solder gage. See Figure 3.

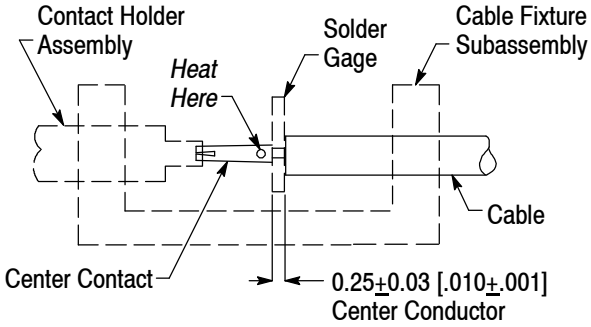


Figure 3

6. Place the center contact in the contact holder assembly. Heat the center contact, and slide it onto the center conductor until it rests firmly against the solder gage. See Figure 3.

7. Remove the cable from solder gage and contact holder assembly. Remove excess solder from the center contact.

8. Insert the center contact into the housing.

9. Place the assembly in the cable fixture subassembly as shown in Figure 4. Clamp the cable fixture subassembly vertically in the vise. Make sure to tighten the clamp screw to secure the cable, and tighten the locator tool to seat the housing firmly against the cable.

NOTE

The cable fixture subassembly should be clamped vertically so that the housing stays against the locator tool.

10. Using solder made of 60% tin and 40% lead, join the housing to the cable at the location shown in Figure 4.

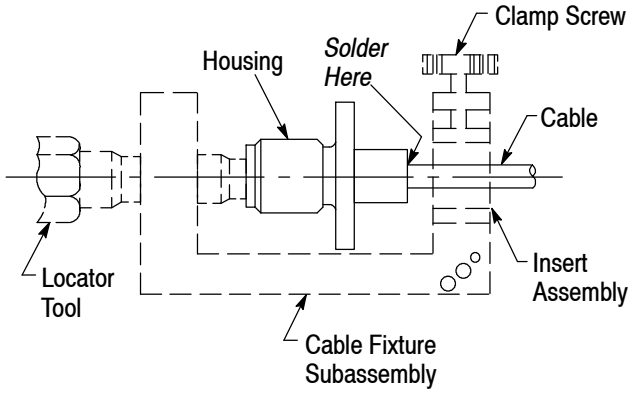


Figure 4

11. Thread housing onto dielectric insert tool.

12. Insert the dielectric into the housing of the dielectric insert tool. Place the plunger of the tool into position, and press the plunger until the flange bottoms on the tool housing. See Figure 5.

13. Remove the jack from the tool, and inspect the jack according to Figure 6.

NOTE

Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/82.

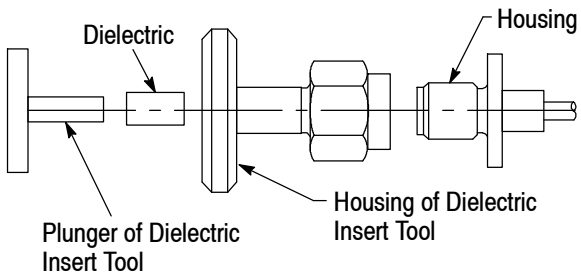


Figure 5

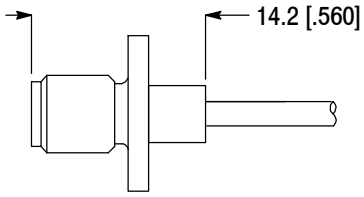


Figure 6

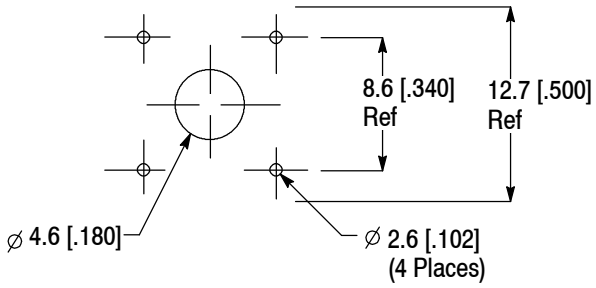
4. PANEL MOUNTING

1. Cut the panel using the dimensions provided in Figure 7.

2. Secure the jack to the panel using four commercially available screws.

Recommended Panel Cutout

Note: Not to Scale



Mounting the Jack

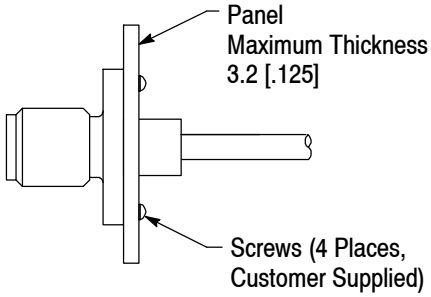


Figure 7

5. REPLACEMENT AND REPAIR

DO NOT re-use any soldered components by removing the cable.

Components of the jack are not repairable. Replace any defective or damaged components.

6. REVISION SUMMARY

Since the previous release of ths document, the Tyco Electronics logo has been applied.