

CABLE PLUG PART NUMBER		
CURRENT	MILITARY M39012/79	PREVIOUS
1050776-1	3002	2001-8002-92
1058590-1		
1050786-1	3102 †	2001-8102-92

† No safety wire holes.

Figure 1

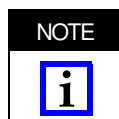
1. INTRODUCTION

This instruction sheet contains the assembly procedure for SMA Straight Cable Plug Direct Solder Attachments 1050776-1, 1058590-1, and 1050786-1, which are applied onto RG 402/U (.141) semi-rigid coaxial cable. See Figure 1.

Figure 2 represents tools applicable to these cable plugs.

DESCRIPTION	PART NUMBER	
	CURRENT	PREVIOUS
Fixture Base	1055439-1	2098-5206-54
Clamp Insert	1055440-1	2098-5207-54
Center Contact Holder	1055454-1	2098-5221-10
Solder Gage	91362-6	2098-5516-02
Locator Tool	1055443-1	2098-5210-02
Dielectric Insert Tool	1055447-1	2098-5214-02

Figure 2



Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

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

2. DESCRIPTION

Each straight cable plug consists of a dielectric bushing, housing subassembly, and center contact.

3. ASSEMBLY PROCEDURE

3.1. Prepare the Cable

1. Insert the squared cable end into the fixture base hole pattern No. 2.
2. Place the saw in the saw slot and cut through the outer conductor and into the dielectric while rotating the cable.
3. Remove the cable from the fixture and finish cutting the dielectric with the cutting blade.
4. Bare the inner conductor by prying the cut outer conductor and dielectric from the cable.
5. Complete trimming of the cable inner conductor to the dimension given in Figure 3.

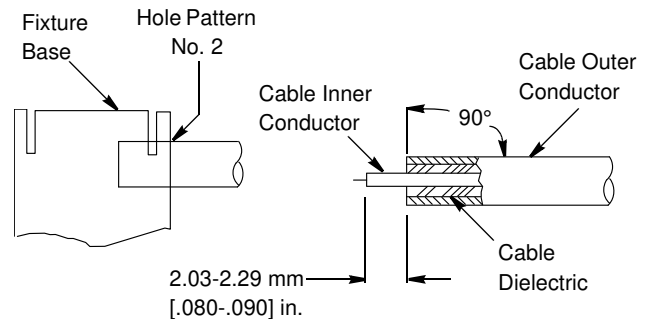


Figure 3

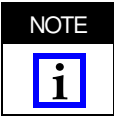
3.2. Solder Center Contact to Cable Inner Conductor (Figure 4)

1. Tin the inner conductor of the cable.
2. Place the solder gage on the inner conductor so that it is flush with end of the outer conductor.
3. Place the center contact in the holder. Heat the center contact and push it over the inner conductor of the cable to rest firmly against the solder gage.
4. Remove the solder gage and excess solder.

3.3. Solder Cable Subassembly to Housing Subassembly (Figure 5)

1. Place the housing subassembly on the end of the cable subassembly.
2. Place the loose assembly in the fixture base as shown in Figure 5.

- a. Nest the center contact in the locator tool.
 - b. Tighten the clamp screw to secure the cable.
 - c. Tighten the locator tool to seat the cable firmly.
3. Slide the housing subassembly over the locator tool.
 4. Maintain the position of the housing subassembly firmly against the locator tool, and solder.



The fixture base should be clamped vertically in the vise to keep the housing subassembly seated against the locator tool.



Do not use damaged or defective components. Replace damaged or defective components with new components.

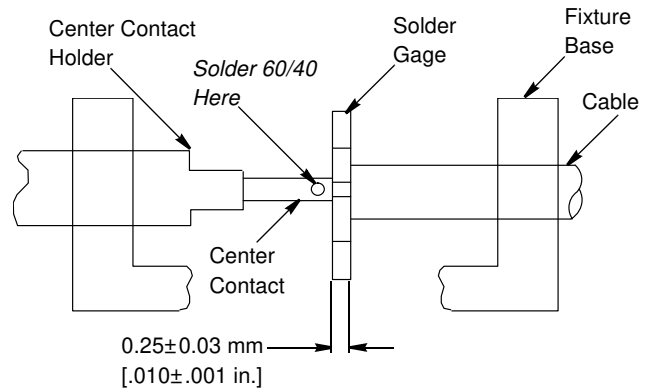


Figure 4

3.4. Press Dielectric Bushing into Housing Subassembly (Figure 6)

1. Thread the insert tool into the housing subassembly.
2. Insert the dielectric into the insert tool housing.
3. Place the insert tool plunger into position and press until the flange bottoms on the tool housing.

Assembly is now complete.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo

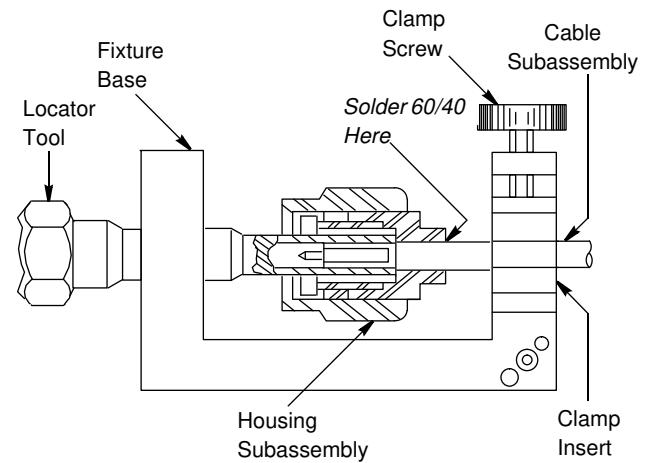


Figure 5

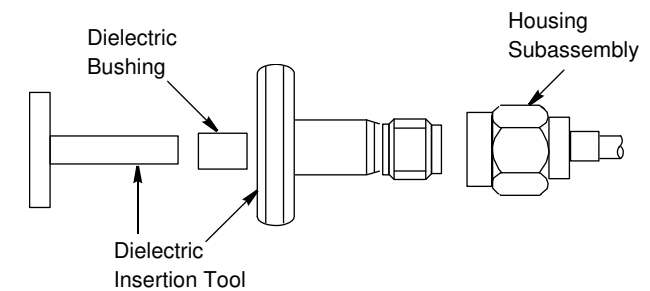


Figure 6