

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Bulkhead Feed Through Cable Jack Compression Crimp Attachment 1051032-1, which is applied onto RG 405/U (.085) semi-rigid coaxial cable.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the previous part number to the Tyco Electronics part number.

TOOL DESCRIPTION	TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER
Crimp Tool Kit	1055835-1	2598-5200-54
Optional Hand Trim and Point Tool	1055815-1	2598-5120-54

Figure 2

NOTE

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

2. DESCRIPTION (Figure 1)

The cable jack compression crimp attachment consists of a mounting nut, lockwasher, gasket, and housing subassembly.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Cable (Figure 3)

Trim cable to the dimensions shown in Figure 3.

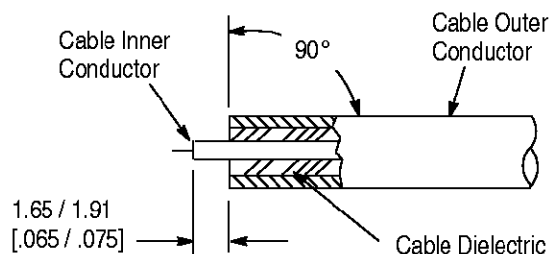


Figure 3

3.2. Shaping Inner Conductor of Cable (Figure 4)

- Trim inner conductor to length as shown in Figure 3.
- File blunt end of inner conductor to an 85° to 90° cone.

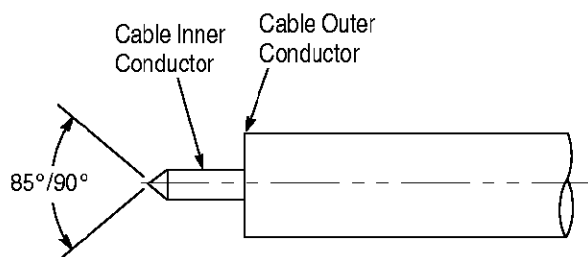


Figure 4

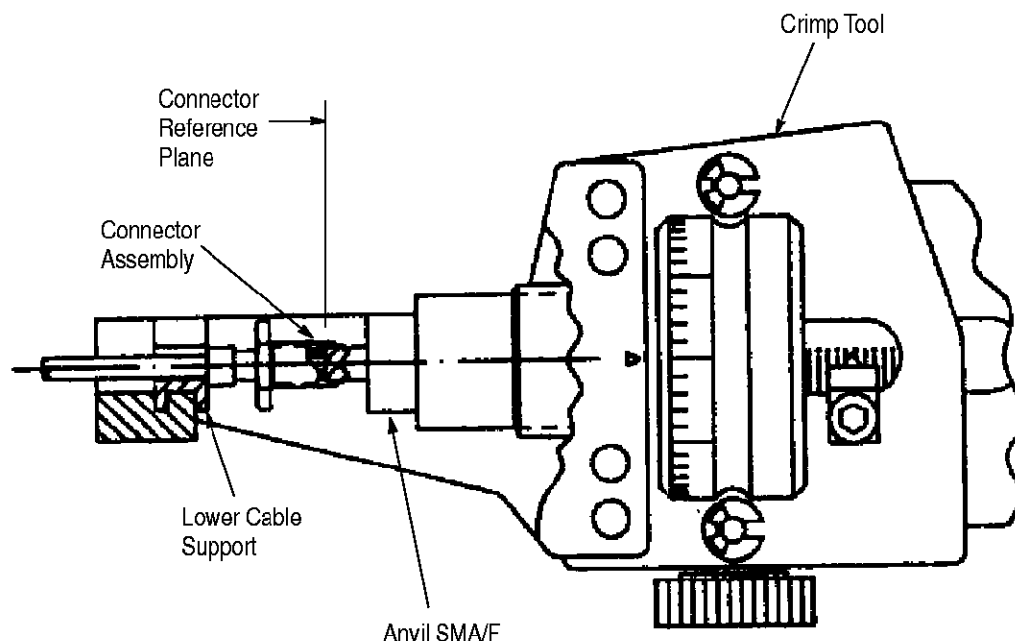


Figure 5

3.3. Installing Cable into Connector Assembly (Figure 5)

1. Install lower cable support (for .085 cable) and anvil (SMA/F) into crimp tool.
2. Set crimp length on crimp tool to 13.44 [.529].
3. Carefully insert cable inner conductor into pre-assembled center contact of connector assembly until cable bottoms on shoulder in connector assembly.
4. Place assembly into crimp tool, bottoming the connector reference plane against anvil and allowing the cable to settle in the lower cable support.
5. Squeeze handles of crimp tool until ratchet releases.
6. Assembly is now complete.

CAUTION

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

4. MILITARY INFORMATION

MILITARY MAINTENANCE TOOLS

Crimp Tool: M/22520/36-01

Positioning Dies: M22520/36-02

Locator Tool: M22520/36-17
2098-0728-54 (Previous Part Number)
1055300-1 (Tyco Electronics Part Number)

5. REVISION SUMMARY

Initial release of document per EC 0990-0134-03