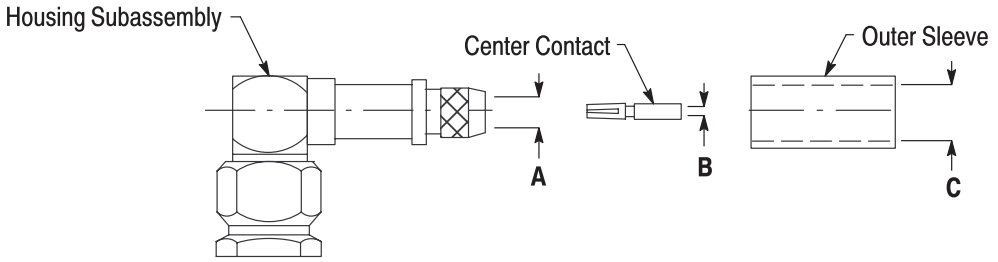


PLUG PART NUMBER		MILITARY PART NUMBER M39012/56–	CABLE (RG/U)	PLUG DIMENSION (mm [in.])		
CURRENT	PREVIOUS			A	B	C
1052178–1	2037–8052–92	3502	142, 400	3.10 [.122]	1.04 [.041]	5.59 [.220]
1086723–1	2037–8162–92	3602▪				

▪ No Safety Wire Holes

Figure 1

1. INTRODUCTION

SMA right–angle cable plugs (crimp attachment) listed in Figure 1 are designed to be crimped to the corresponding cable sizes using the following tools:

TOOL DESCRIPTION	MILITARY PART NUMBER	
	CENTER CONTACT CRIMP M22520/1–	OUTER SLEEVE CRIMP M22520/5–
Crimp Tool	01	01
Crimp Die	15	57 (Closure A)

The following tool is optional:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Center Contact Holder	1055454–1	2098–5221–10 (T–4578)

NOTE

Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.

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

2. DESCRIPTION

The plug consists of the components shown in Figure 1.

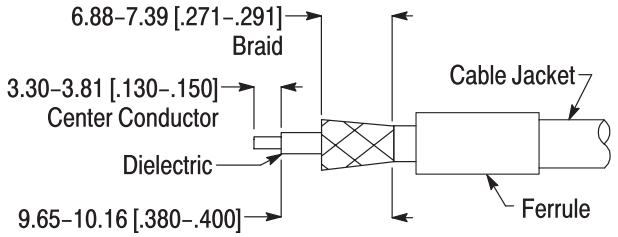
3. ASSEMBLY PROCEDURE

3.1. Standard Crimp Procedure

DANGER

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.



Note: Not to Scale

Figure 2

3. Set the selector knob of the crimp tool (for the center contact) to “3”. Insert the center contact into the crimp die until it bottoms. Insert the cable center conductor into the center contact until the dielectric bottoms. Refer to Figure 3.
4. Holding the assembly in position, crimp the center contact.
5. Secure the housing subassembly in a small bench vise. Insert the center contact into the housing subassembly until it bottoms.

6. Slide the outer sleeve over the cable braid. Holding the cable in position, crimp the outer sleeve. See Figure 5. Trim excess braid strands.

3.2. Alternate Soldering Procedure

DANGER

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.

3. Tin the cable center conductor.

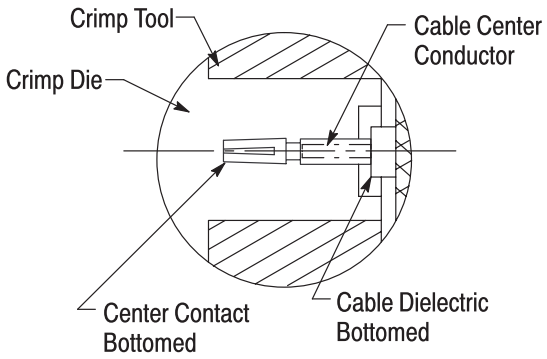


Figure 3

4. Place the center contact into the center contact holder. Heat the center contact, then push it over the cable center conductor until it rests firmly against the dielectric. See Figure 4. Remove excess solder.

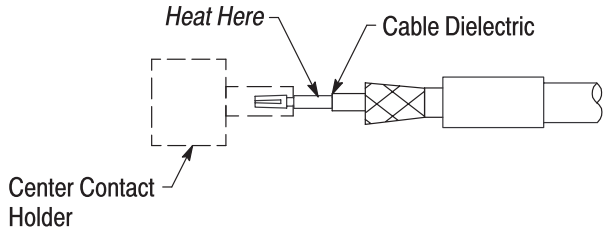


Figure 4

5. Secure the housing subassembly in a small bench vise. Insert the center contact into the housing subassembly until it bottoms.

6. Slide the outer sleeve over the cable braid. Holding the cable in position, crimp the outer sleeve. See Figure 5. Trim excess braid strands.

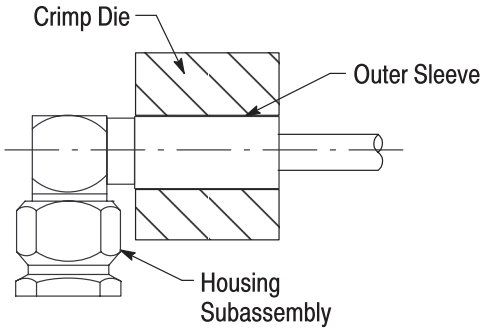


Figure 5

NOTE

Adherence to steps given will yield tolerances provided in military document MIL–PRF–39012/56.

4. REPLACEMENT AND REPAIR

DO NOT re–use soldered or crimped components of the plug by removing the cable.

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

5. REVISION SUMMARY

- Updated document to corporate requirements
- Split Section 3 into two sub–heads (Standard Crimping Procedure) and (Alternative Soldering Procedure) and renumbered