

Figure 1

1. INTRODUCTION

SMA Right Angle Cable Plug (Direct Solder Attachment) 1051109-1 and 1051110-1 are designed to be soldered onto .141 or .085 semi-rigid coaxial cable, or .141 semi-rigid microporous cable using the following tool:

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	TYCO ELECTRONICS	M/A-COM
Locator Tool	1055451-1	2098-5218-0217 (T-2367)

NOTE

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

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

2. DESCRIPTION

The plug connector consists of a housing subassembly and disc. See Figure 1.

3. ASSEMBLY PROCEDURE

DANGER

Follow safety precautions included with the tools used for assembly.

1. Strip the cable to the dimensions shown in Figure 2.
2. Secure the threaded end of the housing subassembly onto the locator tool. Secure the assembly in a small bench vise.
3. Tin the cable center conductor.

CAUTION

If using microporous cable, do not allow flux or solvent on or near the cable dielectric.

4. Insert the center conductor into the housing subassembly. See Figure 3, Detail A. Make sure that the conductor is positioned in the slot of the

contact inside the housing and the cable dielectric is against the contact. See Figure 3, Detail B.

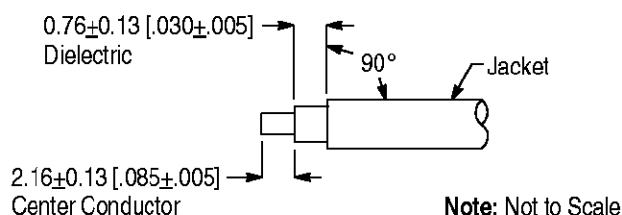
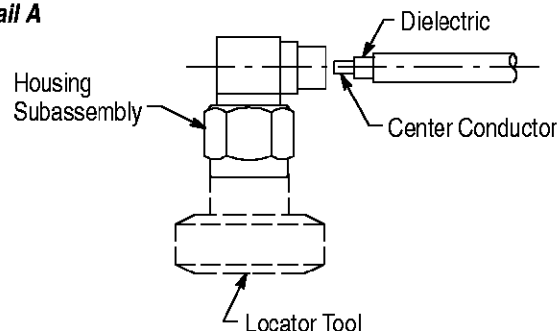


Figure 2

Detail A



Detail B

Center Conductor in Slot of Contact and Dielectric Against Contact

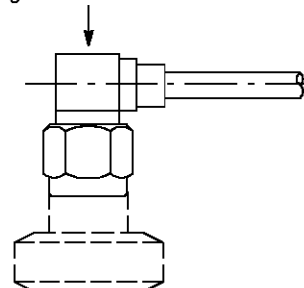


Figure 3

5. Place the soldering iron on the tip of the contact, and solder.

6. Solder the housing subassembly to the cable. Refer to Figure 4, Detail A.

7. Refer to Figure 4, Detail B, and install the disk onto the housing subassembly according to the following preferred option:

Option 1—Press the disk into the opening in the housing subassembly, and secure with epoxy. Do not allow epoxy to enter the housing subassembly.

Option 2—Tin the perimeter of the opening in the housing subassembly. Do not allow solder to enter the housing subassembly. Press the disk into the opening, then apply heat to the disk.

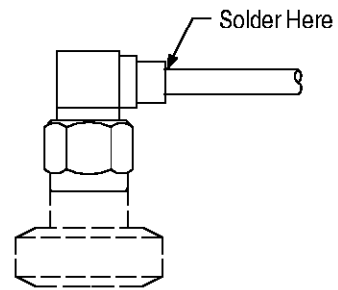
8. Remove the locator tool.

4. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0031-01 include:

- Updated document to corporate requirements

Detail A



Detail B

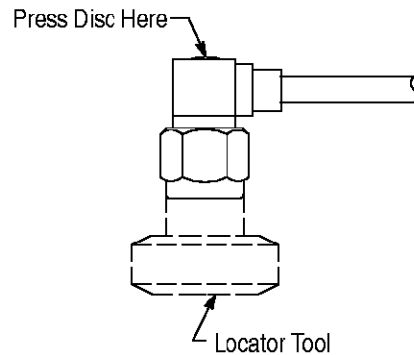


Figure 4