

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Straight Cable Jack Direct Solder Attachments 1311889-1, 1050924-1, and 1050928-1, which are applied onto RG 402/U (.141) 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
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	1055448-1	2098-5215-02

Figure 2

### NOTE

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

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

## 2. DESCRIPTION (Figure 1)

The SMA straight cable jack direct solder attachments consist of a dielectric, housing, and center contact.

## 3. ASSEMBLY PROCEDURES

### 3.1. Preparing the Cable (Figure 3)

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

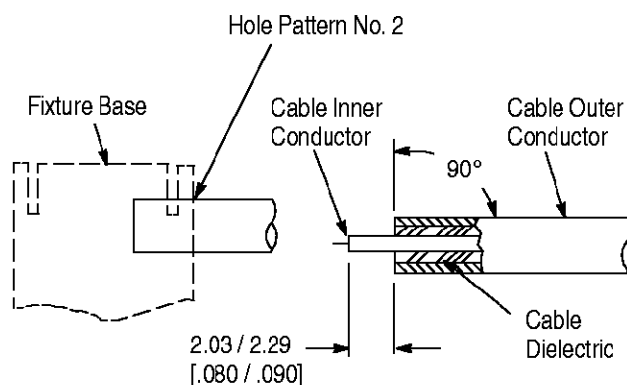


Figure 3

### 3.2. Soldering of Center Contact to Cable Inner Conductor (Figure 4)

1. Tin inner conductor of cable.
2. Place solder gage on inner conductor flush with end of outer conductor.

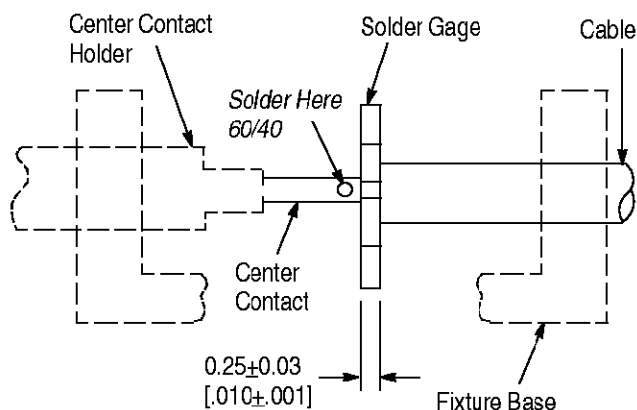


Figure 4

3. Place center contact in holder, heat center contact, and push it over inner conductor of cable to rest firmly against solder gage.

4. Remove solder gage and excess solder.

### 3.3. Soldering of Cable Sub-Assembly to Housing (Figure 5)

1. Place connector housing on end of cable sub-assembly.
2. Place loose assembly in fixture base as shown in Figure 5.
  - a. Nest center contact in locator tool.

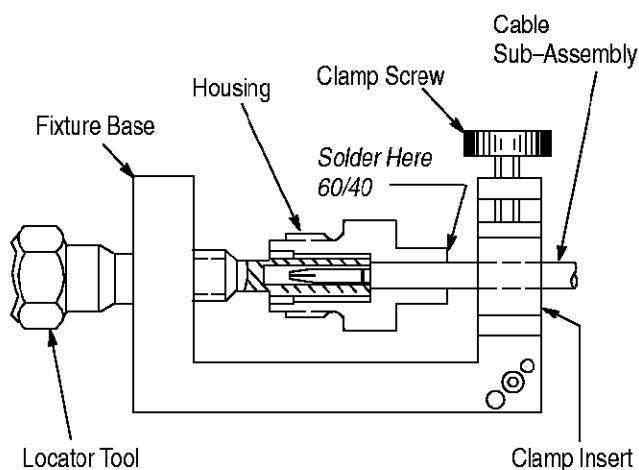


Figure 5

- b. Tighten clamp screw to secure cable.
- c. Tighten locator tool to seat cable firmly.

3. Slide housing over locator tool.
4. Maintain position of housing firmly against locator tool and solder.

#### NOTE

*Fixture should be clamped vertically in vise to keep housing seated against locator tool.*

### 3.4. Pressing of Dielectric Bushing into Housing Sub-Assembly (Figure 6)

1. Thread insert tool onto housing sub-assembly.
2. Insert dielectric into insert tool housing.
3. Place insert tool plunger into position and press until flange bottoms on tool housing.
4. Assembly is now complete.

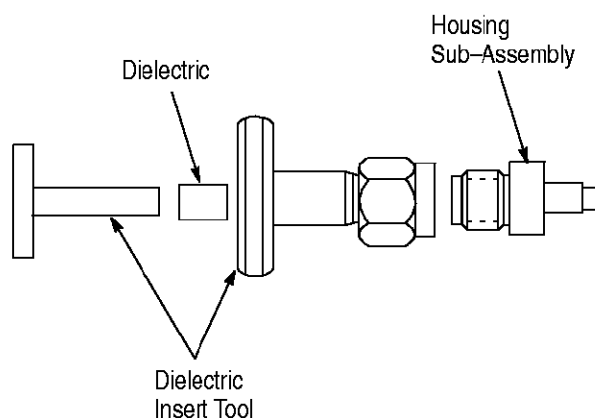


Figure 6

#### CAUTION

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

## 4. MILITARY INFORMATION

TYCO ELECTRONICS PART NUMBER	MILITARY P/N M39012/81	PREVIOUS PART NUMBER
1311889-1	B3002	2002-8002-90
1050924-1		
1050928-1	-3006	2002-8006-90

## 5. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0272-03 include:

- Update document to corporate requirements
- Update artwork to make document easier to read