

Figure 1

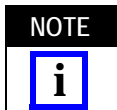
1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Right-Angle Cable Plug Direct Solder Attachments 1051161-1, 1051172-1, 1051164-1, and 1051174-1, 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 TE Connectivity part number.

TOOL DESCRIPTION	TE PART NUMBER	PREVIOUS PART NUMBER
Locator Tool	1055451-1	2098-5218-02

Figure 2



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 right angle cable plug direct solder attachments consist of a housing sub-assembly and a disc.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Cable (Figure 3)

Trim the cable to the dimensions shown in Figure 3.

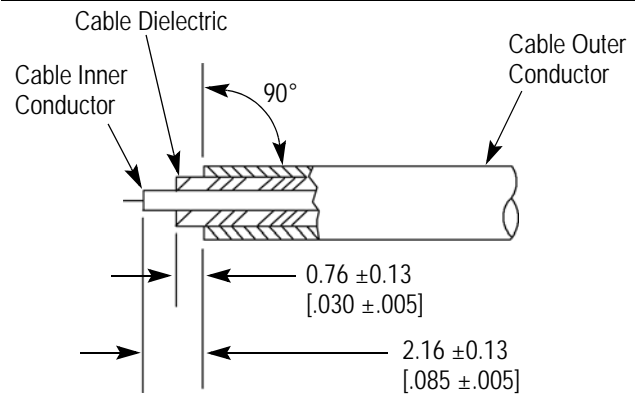
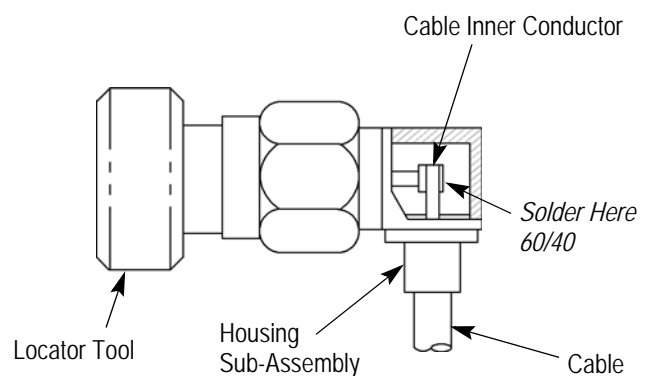


Figure 3

3.2. Soldering Cable Inner Conductor to Housing Sub-Assembly (Figure 4)

1. Secure locator tool to threads of housing sub-assembly.
2. Position and secure housing sub-assembly by using a small bench vise.
3. Tin inner conductor of cable.
4. Insert cable into housing sub-assembly.
 - a. Nest inner conductor in contact slot.
 - b. Hold dielectric flush as shown in Figure 4.
5. Place soldering iron on tip of contact and solder.



NOTE: Cable dielectric is to be flush with center contact.

Figure 4

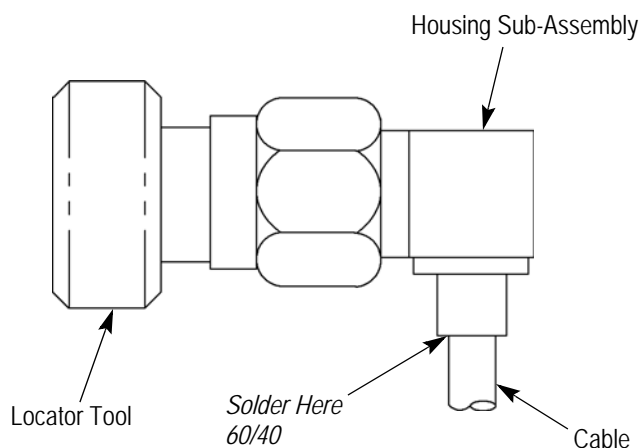


Figure 5

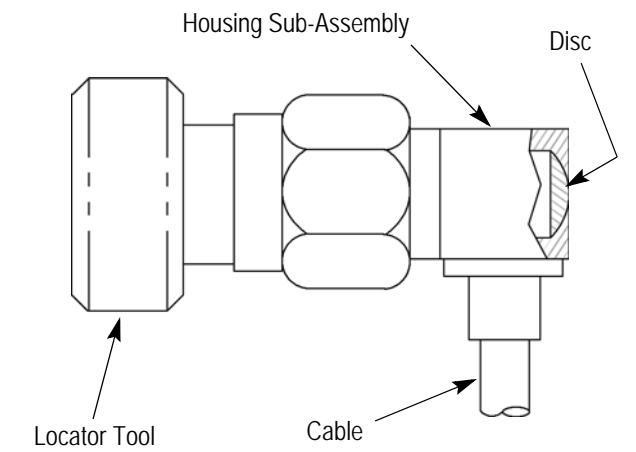


Figure 6

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

Solder housing sub-assembly to cable as shown in Figure 5.



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

3.4. Seal Opening in Housing (Figure 6)

Press the disc into opening in rear of housing sub-assembly and remove locator tool, after which one of the below methods may be used:

Option 1: Tin perimeter of opening and press disc into position. Apply heat to cap, do not allow solder to penetrate housing.

Option 2: Disc may be epoxied into place. Do not allow epoxy to penetrate inside housing.

4. MILITARY INFORMATION

TE PART NUMBER	MILITARY P/N M39012/80B	PREVIOUS PART NUMBER
1051161-1	3002	2007-8002-92
1051172-1	3102 [†]	2007-8102-92
1051164-1	3004	2007-8004-92
1051174-1	3104 [†]	2007-8104-92

[†] No safety wire holes.

5. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.