

Figure 1

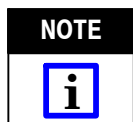
1. INTRODUCTION

This instruction sheet contains the assembly procedures for the SMA Bulkhead Feedthrough Cable Jack Solder Attachment 1051998-1, which is applied onto RG 142/U and RG 400/U 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
Center Contact Crimp Tool	N/A	M22520/1-01
Center Contact Crimp Die	N/A	M22520/1-15
Outer Sleeve Crimp Tool	N/A	M2250/5-01
Outer Sleeve Crimp Die	N/A	M22520/5-57 Closure A
Center Contact Holder (optional)	1055454-1	2098-5221-10

Figure 2



NOTE Dimensions on 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 document are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The bulkhead feedthrough cable jack solder attachment consists of a mounting nut, lockwasher, "O" ring, housing sub-assembly, center contact, and outer sleeve.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Coaxial Cable End (Figure 3)

1. Place outer sleeve on cable.
2. Remove end portion of cable jacket to expose cable outer conductor.
3. Trim outer conductor to length.
4. Trim cable dielectric to length.
5. Trim inner conductor to length.
6. Flare outer conductor.

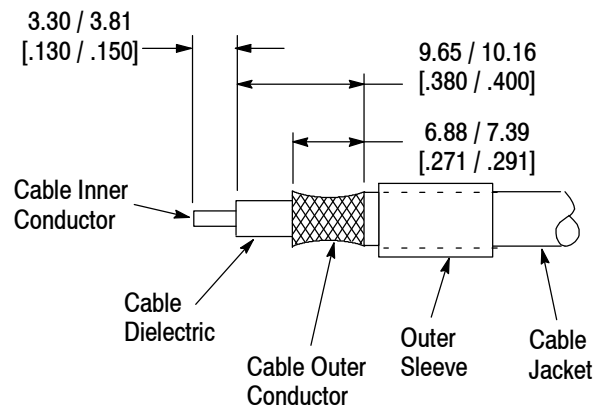


Figure 3

OPTION 1: Crimping Center Contact

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

1. Set selector knob to number “3”.
2. Place center contact into center contact positioner tool and bottom.

NOTE *Proper positioning of center contact in the positioner tool will result in a controlled compensation for optimum electrical performance.*

3. Insert cable inner conductor into center contact and bottom cable in positioner.
4. Hold cable firmly seated and crimp.

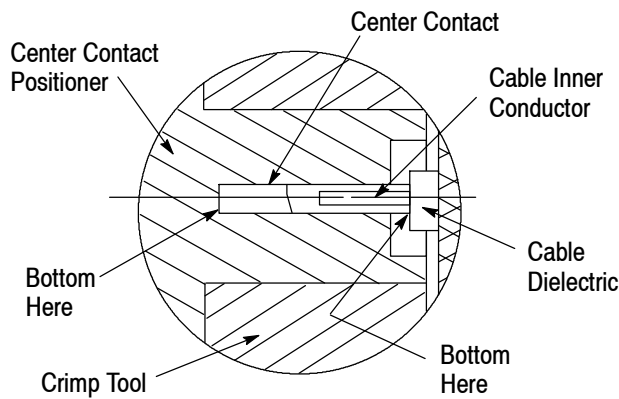


Figure 4

OPTION 2: Soldering Center Contact

3.3. Soldering of Center Contact to Cable Inner Conductor (Figure 5)

1. Tin inner conductor of cable.
2. Place center contact in holder. Heat center contact and push it over inner conductor of cable to rest firmly against cable dielectric.
3. Remove excess solder.

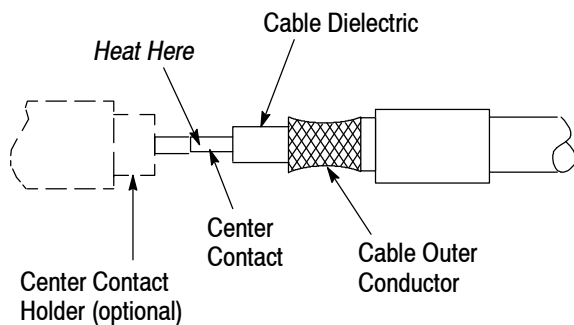


Figure 5

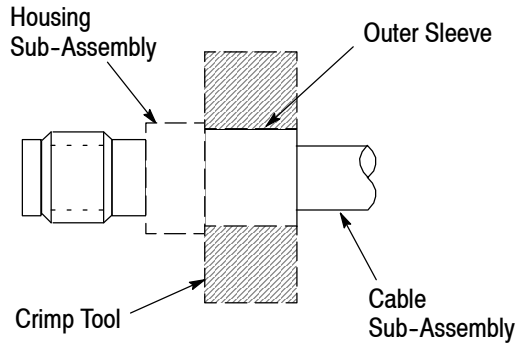


Figure 6

3.4. Crimp Cable Sub-Assembly to Housing Sub-Assembly (Figure 6)

1. Position and secure housing sub-assembly in a small bench vise.
2. Insert cable sub-assembly into housing sub-assembly and seat firmly.
3. Slide outer sleeve over flared portion of cable outer conductor.
4. Hold cable firmly seated and crimp outer sleeve in place.
5. Trim and remove excess outer conductor strands.
6. Assembly is now complete.

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

4. MILITARY INFORMATION

TE PART NUMBER	MILITARY PART NUMBER	PREVIOUS PART NUMBER
1051998-1	M39012/59-3502	2034-8052-92

5. REVISION SUMMARY

- Updated document to corporate requirements
- New logo