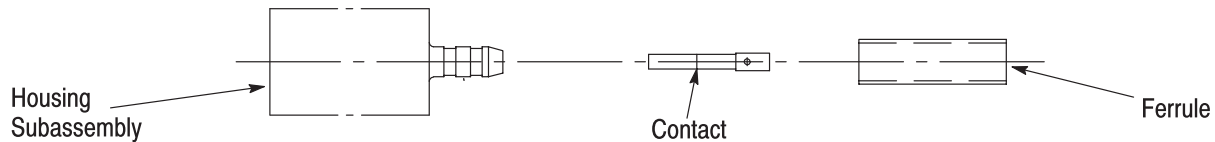


SMA Low Cost Straight Cable Connectors



CONNECTOR NO.		TYPE	CRIMP DIE NO.		HEX SIZE	DIM A	CABLE
TE PART NO.	PREVIOUS PART NO.		TE PART NO.	PREVIOUS PART NO.			
1056436-1	2831-7316-02	Plug	1055270-1	2098-0323-54	3.835 [.151]	8.128 [.320]	RG-316/U Double Braid
1056438-1	2831-7341-02	Plug	1060714-1 (B)	5698-5015-54 No. B	5.410 [.213]	8.001 [.315]	RG-142/U Double Braid
1056441-1	2831-7358-02	Plug	1060714-1 (B)	5698-5015-54 No. B	5.410 [.213]	8.001 [.315]	RG-58/U, RG-141/U, RG-303/U
1056443-1	2831-7366-02	Plug	1060714-1 (C)	5698-5015-54 No. C	3.251 [.128]	8.128 [.320]	RG-174/U, RG-188/U, RG-316/U
1056445-1	2834-7316-02	Jack	1055270-1	2098-0323-54	3.835 [.151]	8.255 [.325]	RD-316/U Double Braid
1056447-1	2834-7341-02	Jack	1060714-1 (B)	5698-5015-54 No. B	5.410 [.213]	8.001 [.315]	RG-142/U Double Braid
1056450-1	2834-7358-02	Jack	1060714-1 (B)	5698-5015-54 No. B	5.410 [.213]	8.001 [.315]	RG-58/U, RG-141/U, RG-303/U
1056452-1	2834-7388-02	Jack	1060714-1 (C)	5698-5015-54 No. C	3.251 [.128]	8.255 [.325]	RG-174/U, RG-188/U, RG-316/U
1274827-1	--	Jack	1060714-1 (B)	5698-5015-54 No. B	5.410 [.213]	8.001 [.315]	WP93385

Note: Crimping to solid wire is not recommended.

1. INTRODUCTION

These instructions describe the installation of the SMA Low Cost Straight Cable (crimp attachment) connectors listed in Figure 1. Cable, crimp dies, and previous part numbers are also listed in Figure 1.

For required tooling, refer to Figure 2.

NOTE Dimensions are in metric units [with inches in brackets] unless otherwise specified..

NOTE Reasons for revision are contained in Section 3, REVISION SUMMARY.

TE PART NO.	PREVIOUS PART NO.	DESCRIPTION
1055454-1	2098-5221-10	Center Contact Holder
1060713-1	5698-5014-54	Ferrule Crimp Die (.213 and .128 Hex)
1055270-1	2098-0323-54	Ferrule Crimp Die (.151 Hex)
1055879-1	2598-5379-54	Center Contact Crimp Die (.042 Hex)

For specific application crimp tooling, refer to Figure 1.

Figure 2

Figure 1

2. ASSEMBLY

2.1. Prepare The Coaxial Cable (Figure 3)

1. Place the ferrule on the cable.
2. Remove the end portion of the cable jacket to expose the cable braid.
3. Trim the cable braid to length.
4. Trim the cable dielectric to length.
5. Flare the cable braid.

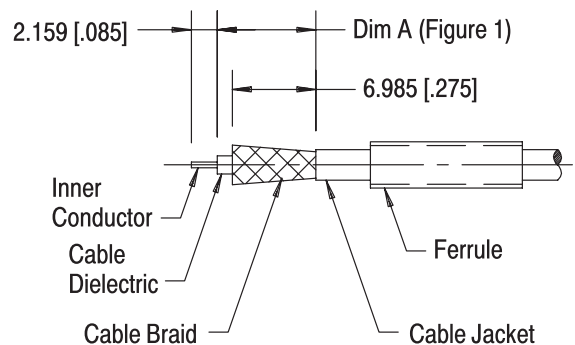


Figure 3

2.2. Attaching Center Contact to the Inner Conductor

A. Soldering of Center Contact (Figure 4)

DANGER Follow all local safety practices when using soldering equipment.



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

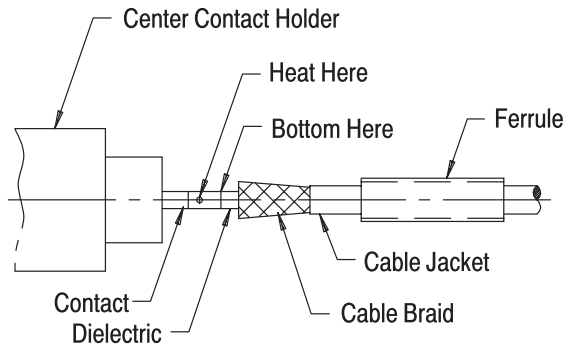


Figure 4

B. Optional Crimping of Center Contact (Figure 5)

1. Assemble the contact over the inner conductor so that it rest firmly against the cable dielectric.
2. Hold the contact (seated against the dielectric) and crimp it into place.

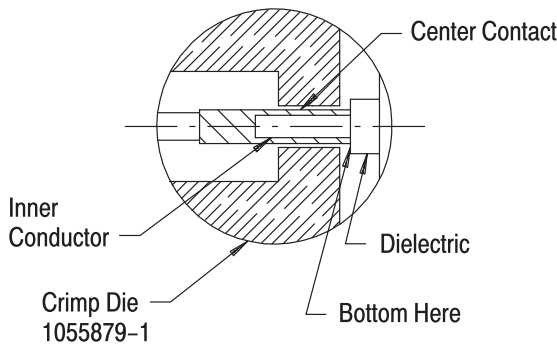


Figure 5

2.3. Crimp the Cable to the Inner Sleeve (Figure 6)

1. Insert the cable subassembly into the housing subassembly and seat it firmly.
2. Slide the outer sleeve over the flared portion of the braid.

3. Hold the seat the cable, hold it firmly, and crimp the outer sleeve in place.
4. Trim and remove the excess braid strands.

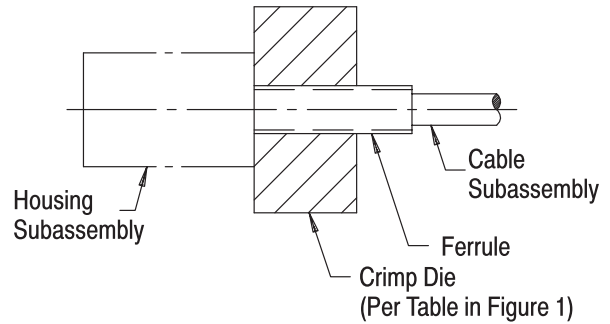


Figure 6

2.4. Inspection of Completed Assembly

Adherence to the preceding steps should yield the tolerances shown in Figure 7.

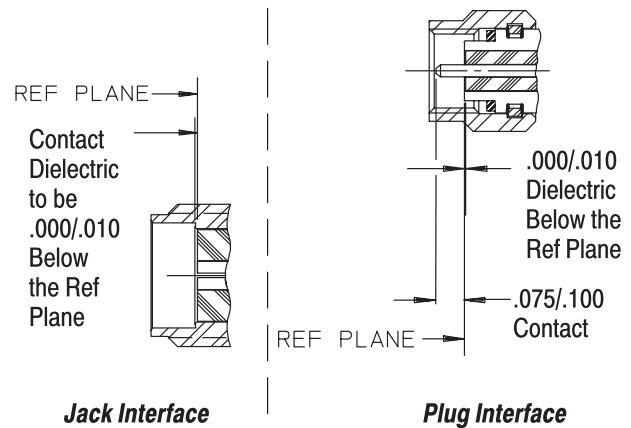


Figure 7

3. REVISION SUMMARY

Since the previous release of this document:

- Part number 1327758-1 was superseded by 1056443-1