

Figure 1

1. INTRODUCTION

SMA right-angle cable plugs (crimp attachment) 1052071-1 and 1052072-1 are designed to be attached to coaxial cable sizes RG 55/U, 142, 223, and 400 using the following tools:

TOOL DESCRIPTION	PART NUMBER	
	CURRENT	PREVIOUS
Locator Tool	1055451-1	2098-5218-02 (T-2367)
Crimp Tool	1055236-1	2098-0105-54 Die B

Figure 2

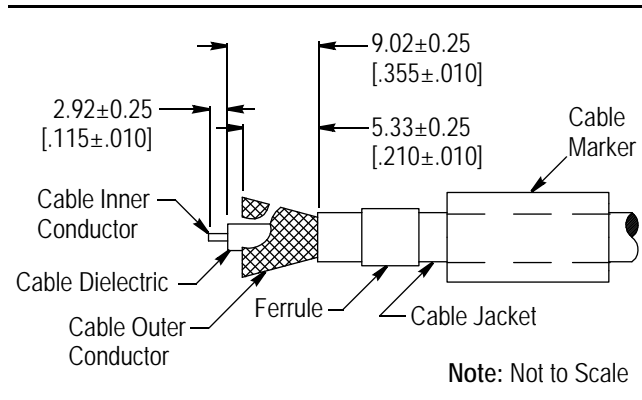
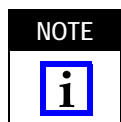


Figure 3

In addition, a small bench vice, soldering iron, and thermo gun will be needed for assembly of the cable plug.



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

Each cable plug consists of the components shown in Figure 1.

3. ASSEMBLY PROCEDURE

3.1. Prepare Cable End

1. Place the cable marker, then the ferrule onto the cable.
2. To expose the cable outer conductor, remove the end portion of the cable jacket to the dimension given in Figure 3.
3. Trim the cable outer conductor, dielectric, and inner conductor to the dimensions given in Figure 3.
4. Flare the cable outer conductor.

3.2. Solder Housing Subassembly to Cable Inner Conductor

1. Secure the threads of the housing subassembly to the locator tool. See Figure 4.
2. Secure the housing subassembly in a small bench vice.
3. Tin the cable inner conductor.
4. Insert the cable inner conductor into the contact slot of the housing subassembly.
5. Hold the cable dielectric and inner conductor flush as shown in Figure 4.
6. Place the soldering iron on the tip of the contact, then solder. Remove excess solder and splatter.

3.3. Crimp Housing Subassembly onto Cable

1. Slide the ferrule over the flared portion of the cable outer conductor. See Figure 4.
2. Using the crimp tool, crimp the ferrule in place.
3. Trim and remove excess cable outer conductor strands.

3.4. Install Cap onto Housing Subassembly

Manually press the cap into the opening at the back of the housing subassembly. See Figure 5.



The cap and housing subassembly are not made of solderable material. Do NOT solder or epoxy the cap to the housing subassembly.

3.5. Shrink Cable Marker to Cable

1. Position the cable marker over the ferrule. See Figure 6.
2. Using a thermo gun, apply indirect heat to the cable marker.
3. Remove the locator tool.

Assembly is now complete.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo
- Updated instruction sheet to corporate requirements
- Changed OSM to SMA
- Removed obsolete cable jacks
- Clarified Paragraph 3.4 (previous Step 4.1 and removed Steps 4.2 and 4.3)
- Removed solder from Figure 5

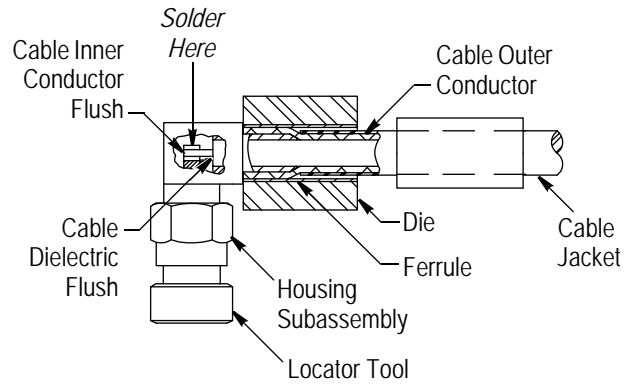


Figure 4

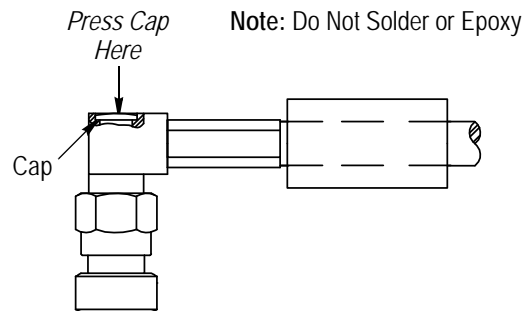


Figure 5

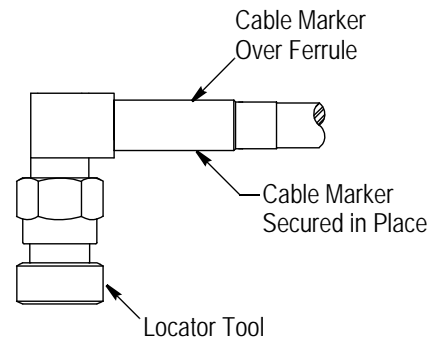


Figure 6