

JACK PART NUMBER			CABLE SIZE	TOOLING		JACK DIMENSION (mm [In.])		
CURRENT (TE)	PREVIOUS	MILITARY M390121/57B-		CRIMP CLOSURE	PART NUMBER	A	B	C
1051906-1	2032 8013 92	3013	RG122/U	D	Current 1055236-1 Previous 2098-0105-54	2.54 [.100]	0.89 [.035]	4.44 [.175]
1051907-1	2032 8114 92	3014	RG 58/U	B		3.10 [.122]	1.04 [.041]	5.21 [.205]
1051908-1	2032 8015 92	3015	RG142/U					5.56 [.219]
1051909-1	2032 8116 92	3016	RG223/U					5.56 [.219]
1051910-1	2032 8117 92	3017	RG303/U					5.21 [.205]

Figure 1

1. INTRODUCTION

This instruction sheet covers the assembly procedures for the SMA Straight Cable Jacks listed in the table in Figure 1. The table also includes the cable type and crimp tooling required for these connectors.

NOTE Dimensions in these instructions are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

2. ASSEMBLY PROCEDURES

2.1. Coaxial Cable Preparation

Slide the ferrule over the cable. Trim the cable to the dimensions shown in Figure 2.

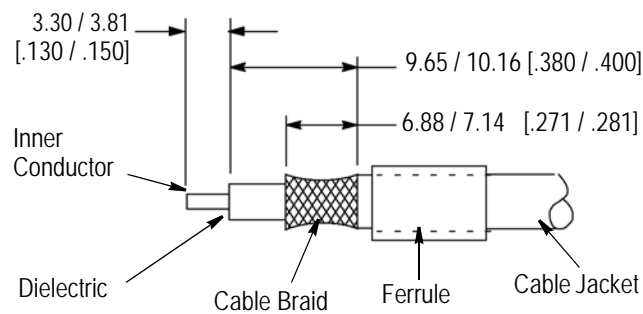


Figure 2

2.2. Soldering the Center Contact to the Cable Inner Conductor (Figure 3)

DANGER Soldering equipment is hot. To avoid personal injury, be sure to follow all local and safety practices (including wearing gloves).

1. Tin the center conductor of the cable.
2. Place the center contact in Center Contact Holder 1055463-1 (optional).
3. Heat center contact and push it over the inner conductor of the cable to rest firmly against the cable dielectric.
4. Remove excess solder.

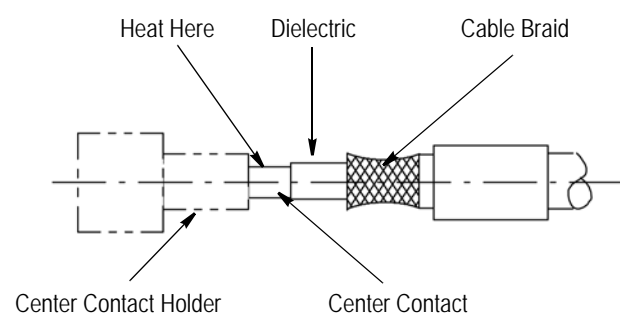


Figure 3

2.3. Crimping the Connector to Cable (Figure 4)

1. Position and secure the housing assembly in a small bench vise.
2. Insert cable into the housing subassembly and seat the cable firmly.
3. Slide the ferrule over the flared portion of the cable outer conductor (braid).
4. Hold the cable firmly seated and crimp the ferrule in place.
5. Trim and remove the excess outer conductor (cable braid).

3. REPLACEMENT AND REPAIR

Do NOT re-use a soldered contact, housing, or crimped ferrule by removing the cable.

Components of the jack are not repairable. Remove and replace any defective or damaged components.

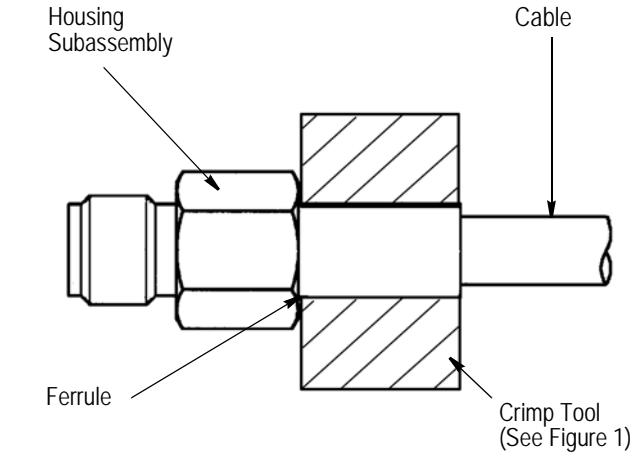


Figure 4

4. REVISION SUMMARY

Since the previous release of this document, the current TE logo has been applied.