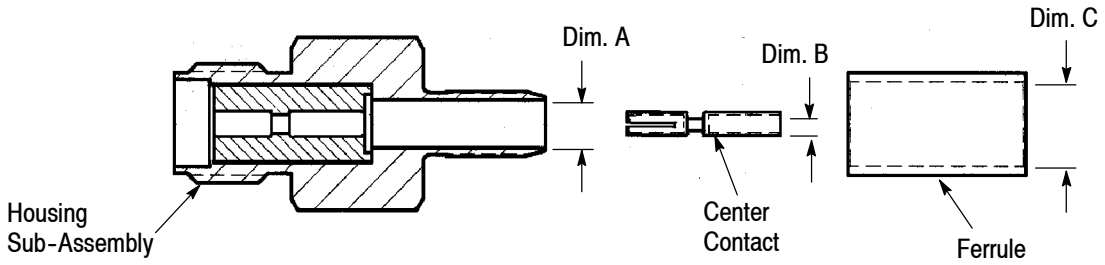
# SMA Straight Cable Jack Crimp Attachment




| JACK PART NUMBER | | | CABLE SIZE | TOOLING M22520/5-01- | | JACK DIMENSION (mm [In.]) | | |
|---|---|---|---|---|---|---|---|---|
| CURRENT | PREVIOUS | MILITARY M39012/57- | | CRIMP DIE M22520/5- | CRIMP CLOSURE | A | B | C |
| 1051913-1 | 2032 8020 92 | B 3020 | RG122/U | 05 | B | 2.54 [.100] | 0.89 [.035] | 4.44 [.175] |
| | | | | 09 | A | | | |
| | | | | 41 | B | | | |
| 1051914-1 | 2032 8021 92 | B 3021 | RG58/U | 05 | A | 3.10 [.122] | 1.04 [.041] | 5.21 [.205] |
| 1051915-1 | 2032 8022 92 | B 3022 | RG142/U | 11 | A | | | 5.56 [.219] |
| 1051916-1 | 2032 8023 92 | B 3023 | RG223/U | 19 | B | | | |
| 1051917-1 | 2032 8024 92 | B 3024 | RG303/U | 57 | A | | | 5.21 [.205] |
| 1051920-1 | 2032 8027 92 | 3027 | RG122/U | 05 | B | 2.54 [.100] | 0.89 [.035] | 4.44 [.175] |
| | | | | 09 | A | | | |
| | | | | 41 | B | | | |
| 1051921-1 | 2032 8028 92 | 3028 | RG142/U | 05 | A | 3.10 [.122] | 1.04 [.041] | 5.56 [.219 |
| | | | RG223/U | 11 | A | | | |
| 1051922-1 | 2032 8029 92 | 3029 | RG58/U | 19 | B | | | 5.31 [.209] |
| | | | RG303/U | 57 | A | | | |

*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.

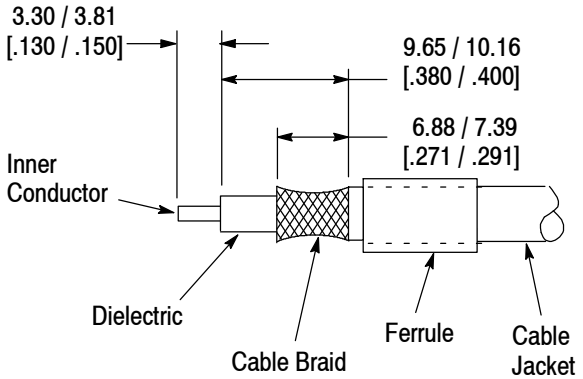



*Figure 2*

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


*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 1055454-1 (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.

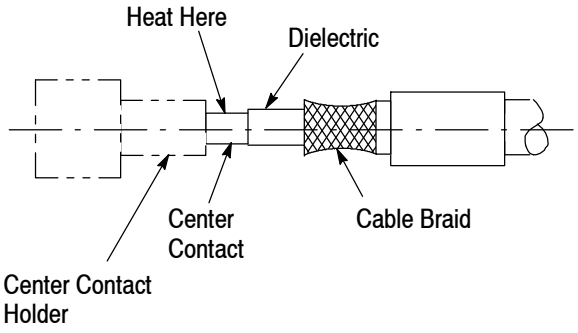



*Figure 3*

### 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.

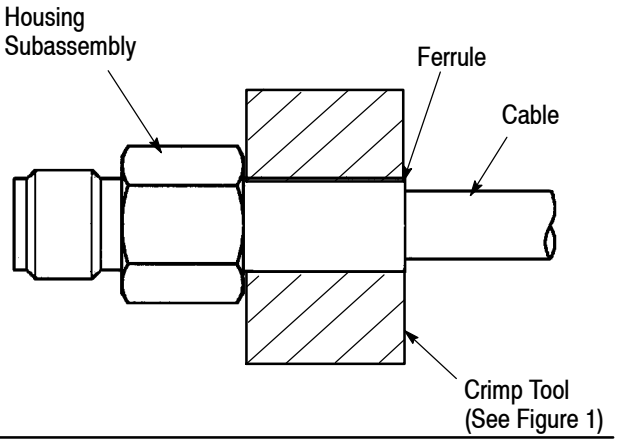



*Figure 4*

## 4. REVISION SUMMARY

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

- Updated document to corporate requirements.