

JACK PART NUMBERS		MILITARY PART NUMBER M39012/59- (Category B)	CABLE (RG/U)	CRIMP TOOL DIE CLOSURE	JACK DIMENSION		
CURRENT	PREVIOUS				A	B	C
1083993-1	2034-8013-92	3013	122	D	2.54 [.100]	0.89 [.035]	4.45 [.175]
1253627-1	2034-8015-92	3015	142	B	3.10 [.122]	1.04 [.041]]	5.56 [.219]
1221165-1	2034-8016-92	3016	223	B	3.10 [.122]	1.04 [.041]	5.56 [.219]
1484542-1	2034-8017-92	3017	303	B	3.10 [.122]	1.04 [.041]	5.21 [.205]

Figure 1

## 1. INTRODUCTION

SMA straight bulkhead feed-through cable jacks (crimp attachment) listed in Figure 1 are designed to be terminated to the corresponding coaxial cable using the following tools:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Center Contact Holder	1055463-1	2098-5237-10 (T-4579)
Crimp Tool	1055236-1	2098-0105-54

### NOTE



Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

## 2. DESCRIPTION

The jack consists of a ferrule, center contact, housing, O-ring, lockwasher, and jam nut. See Figure 1.

## 3. ASSEMBLY PROCEDURE

### DANGER



Follow safety precautions included with the tools used for assembly.

- Slide the ferrule onto the cable.

- Strip the cable to the dimensions shown in Figure 2. Take care not to nick any part of the cable. Flare the braid.

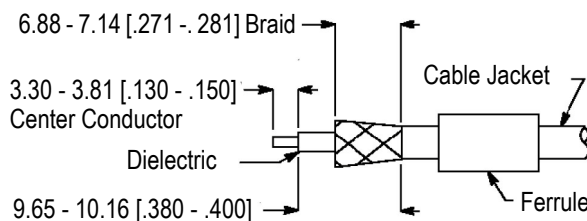


Figure 2

- Tin the cable center conductor.
- Place the center contact in the center contact holder. Heat the contact with a soldering iron, then carefully push the contact over the center conductor until it rests firmly against the dielectric. See Figure 3. Remove excess solder and splatter.
- Secure the housing in a small bench vise.
- Insert the center contact into the back of the housing until it is firmly seated. DO NOT allow the cable braid to enter the housing. Refer to Figure 4, Detail A.

7. Slide the ferrule over the cable braid and against the housing. Hold the cable firmly in position, and crimp the ferrule. Trim excess cable braid strands. See Figure 4, Detail B.

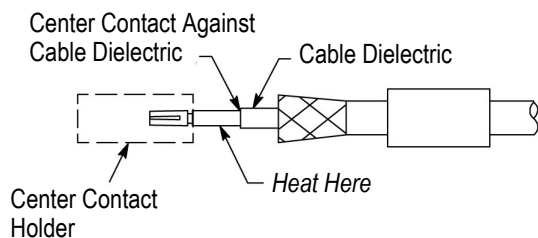
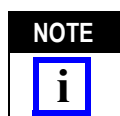
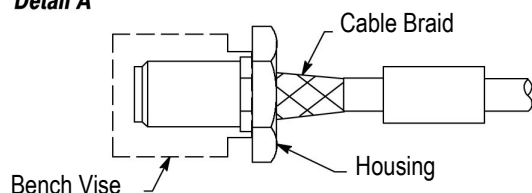


Figure 3



Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/79.

**Detail A**



**Detail B**

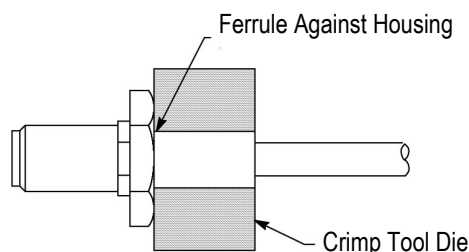


Figure 4

## 4. PANEL MOUNTING

1. Cut the panel using the dimensions provided in Figure 5.
2. Install the O-ring onto the front of the housing. Insert the housing through the panel cutout until the O-ring is flat against the panel. Install the lockwasher and jam nut onto the front of the jack. Tighten the jam nut. Refer to Figure 5.

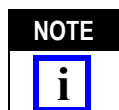
## 5. REPLACEMENT AND REPAIR

DO NOT re-use any soldered or crimped components by removing the cable.

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

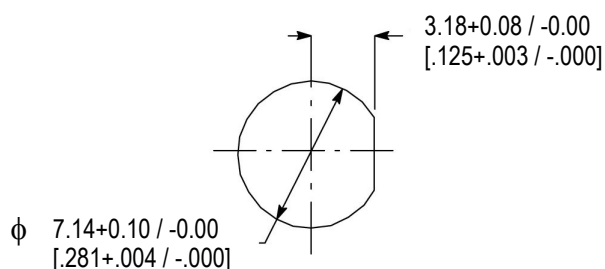
## 6. REVISION SUMMARY

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



Not to Scale

### Recommended Panel Cutout



### Panel Mounting

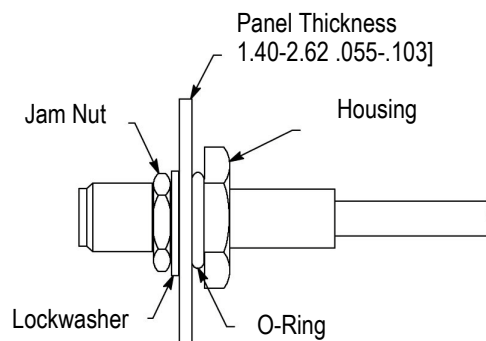


Figure 5