

JACK DESCRIPTION	JACK PART NUMBER		
	TE NUMBER	PREVIOUS NUMBER	MILITARY NUMBER M39012/81 (Category B)
Straight	1050933-1	2002-8204-92	3004
Flange Mount	1051096-1	2006-8204-92	

Figure 1

1. INTRODUCTION

SMA cable jacks (compression crimp attachment) listed in Figure 1 are designed to be crimped onto semi-rigid coaxial cable size RG 402/U with a diameter of 3.58 mm [.141 in.] using the following tool kit:

TOOL DESCRIPTION	TOOL PART NUMBER	
	TE PART NUMBER	PREVIOUS PART NUMBER
Compression Crimp Tool Kit (408-8536)	1055835-1	2598-5200-54

NOTE



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

2. DESCRIPTION

Each jack consists of a housing assembly and bushing. See Figure 1. The straight jack features a hex (shown in Figure 1). The flange mount jack features a flange for mounting the jack to a panel.

3. ASSEMBLY PROCEDURE

DANGER

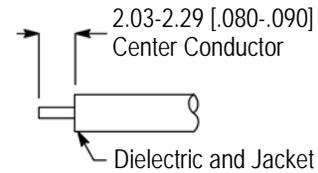


Follow safety precautions included with the tools used for assembly.

- Strip the cable to the dimensions shown in Figure 2, Detail A. Shape the blunt end of the center

conductor to an 85° to 90° cone as shown in Figure 2, Detail B.

Detail A



Note: Not to Scale

Detail B

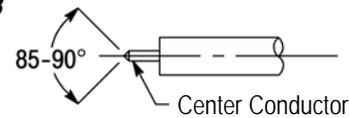


Figure 2

- Install the .141 S.R. lower cable support and the SMA/F anvil into the crimp tool. Set the tool crimp length to .530.

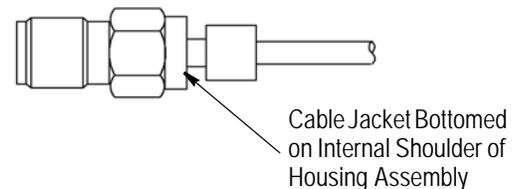
- Insert the center conductor through the bushing and into the center contact (inside the housing assembly) until the jacket bottoms on the internal shoulder in the housing assembly. See Figure 3, Detail A.

- Position the jack assembly in the crimp tool so that the reference plane of the housing assembly is against the anvil and the cable is seated in the lower cable support. See Figure 3, Detail B. Actuate the tool.



It is recommended to bend the cable before crimping.

Detail A



Detail B

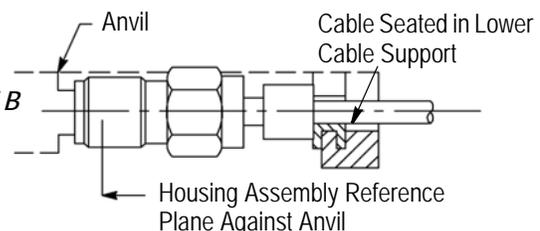


Figure 3

5. Remove the jack assembly from the crimp tool, and inspect the crimp according to Figure 4.



Adherence to steps given will yield tolerances provided in the military document listed in Figure 1.

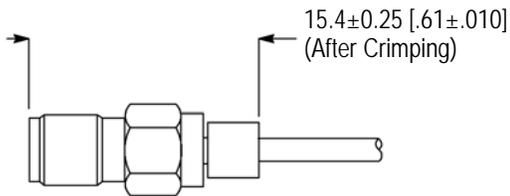


Figure 4

4. PANEL MOUNTING

1. Cut the panel using the dimensions provided in Figure 5.
2. Secure the jack to the panel using four commercially available screws.

5. REPLACEMENT AND REPAIR

DO NOT re-use any crimped jacks by removing the cable. The jack is not repairable. Replace any defective or damaged jacks.

6. REVISION SUMMARY

These instructions were revised to apply the latest company logo.

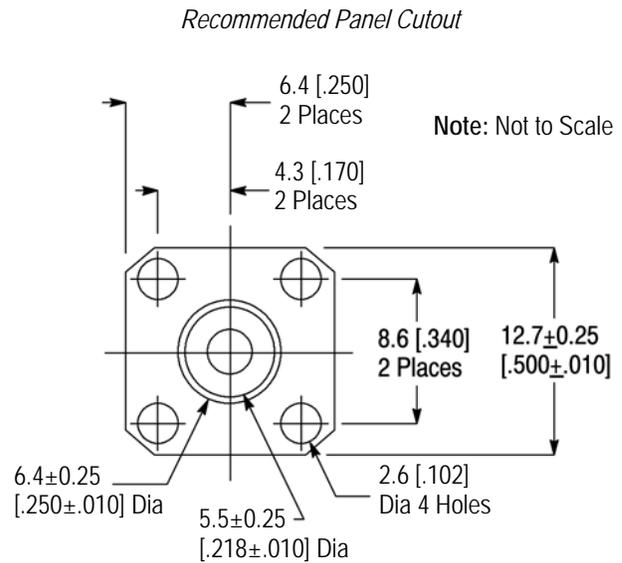


Figure 5