

CABLE PLUG PART NUMBER		
CURRENT	MILITARY M39012/79	PREVIOUS
1050777-1	B3003	2001-8003-92
1050787-1	B3103 †	2001-8103-92
1050781-1	-3007	2001-8007-92
1329374-1		
1050789-1	-3107 †	2001-8107-92

† No safety wire holes

Figure 1

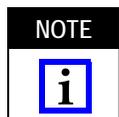
1. INTRODUCTION

This instruction sheet contains the assembly procedure for SMA Straight Cable Plug Solder Clamp Attachments 1050777-1, 1050781-1, 1050787-1, 1050789-1, and 1329374-1, which are applied onto RG 405/U (.085) semi-rigid coaxial cable. See Figure 1.

Figure 2 represents tools applicable to these cable plugs.

DESCRIPTION	PART NUMBER	
	CURRENT	PREVIOUS
Fixture Base	1055439-1	2098-5206-54
Clamp Insert	1055441-1	2098-5208-54
Center Contact Holder	1055454-1	2098-5221-10
Locator Tool (Optional)	1055507-1	2098-5605-02

Figure 2



Dimensions in this instruction sheet are in metric units [with U.S. customary units 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 straight cable plug consists of a housing subassembly, dielectric, center contact, rear dielectric, inner sleeve, and clamp nut.

3. ASSEMBLY PROCEDURE

3.1. Prepare the Cable

1. Insert the squared cable end into the fixture base hole pattern No. 2.
2. Place the saw in the saw slot and cut through the outer conductor and into the dielectric while rotating the cable.
3. Remove the cable from the fixture and finish cutting the dielectric with the cutting blade.
4. Bare the inner conductor by prying the cut outer conductor and dielectric from the cable.
5. Complete trimming of the cable inner conductor to the dimension given in Figure 3.

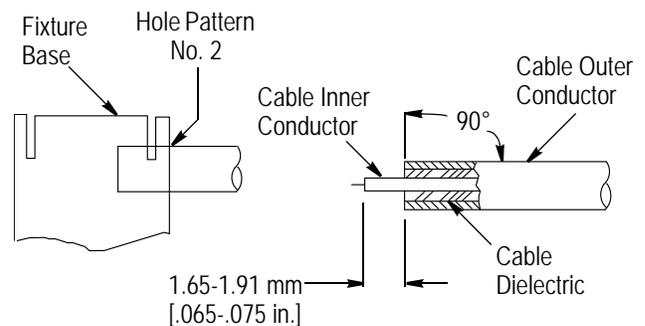
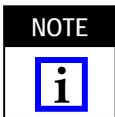


Figure 3

3.2. Solder Inner Sleeve to Cable (Figure 4)

1. Place the clamp nut and inner sleeve on the end of the cable.
2. Place the loose assembly in the fixture base as shown in Figure 4 (slide the clamp nut back out of the way).
 - a. Nest the cable in the locator tool.
 - b. Tighten the clamp screw to secure the cable.
 - c. Tighten the locator tool to seat the cable firmly.
3. Slide the inner sleeve against the locator tool.
4. Maintain the position of the inner sleeve firmly against the locator tool, and solder.



The fixture base should be clamped vertically in the vise to keep the inner sleeve seated against the locator tool.



Do not use damaged or defective components. Replace damaged or defective components with new components.

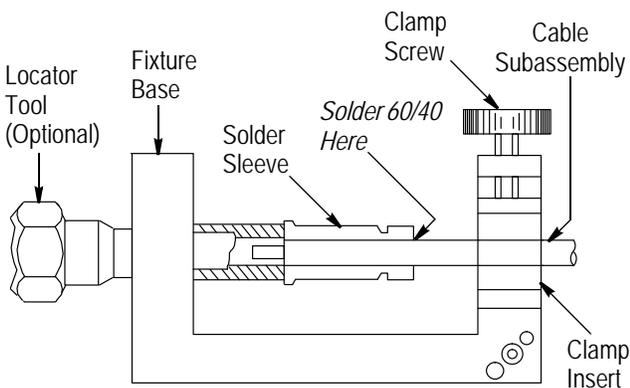


Figure 4

3.3. Solder Center Contact to Cable Inner Conductor (Figure 5)

1. Tin the inner conductor of the cable.
2. Place the rear dielectric onto the cable inner conductor.
3. Place the center contact in the holder. Heat the center contact and push it over the inner conductor of the cable with the large diameter of the contact resting firmly against the rear dielectric.
4. Remove excess solder.

3.4. Secure Inner Sleeve Subassembly to Housing (Figure 6)

1. Assemble the front dielectric onto the center contact.

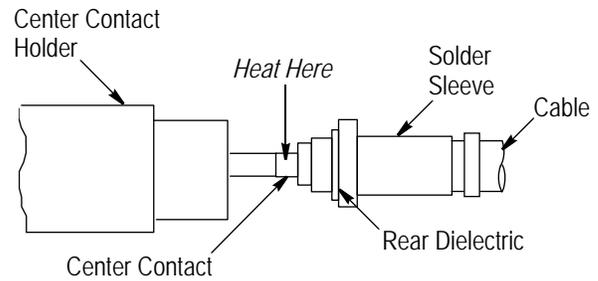


Figure 5

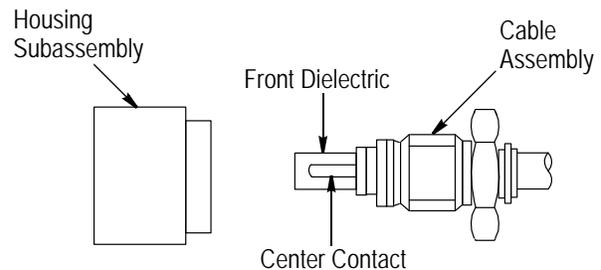


Figure 6

2. Slide the clamp nut over the inner sleeve and engage the threads of the clamp to the housing. Torque between 2.83 and 3.39 Nm [25 and 30 in-lb].

Assembly is now complete. Refer to Figure 7.

Note: Not to Scale

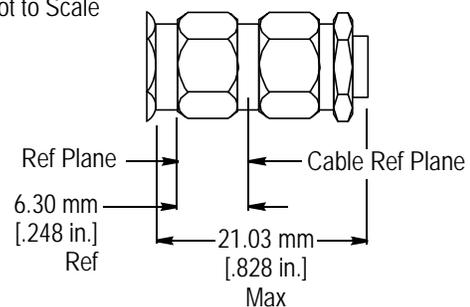


Figure 7

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo