

Figure 1

**1. INTRODUCTION**

SMA Straight Cable Jack (Solder Attachment) 1051852-1 is designed to be soldered onto coaxial cable sizes RG 55/U, 58, 141, 142, 223, 303, and 400 using the following tools:

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	TYCO ELECTRONICS	M/A-COM
Center Contact Holder	1055454-1	2098-5221-10 (T-4578)
Locator Tool	1055446-1	2098-5213-02 (T-948)
Solder Gauge	1055445-1	2098-5212-02 (T-4562-1)

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

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

**2. DESCRIPTION**

The jack consists of a housing subassembly, center contact, outer sleeve, and sheath. Refer to Figure 1.

**3. ASSEMBLY PROCEDURE**

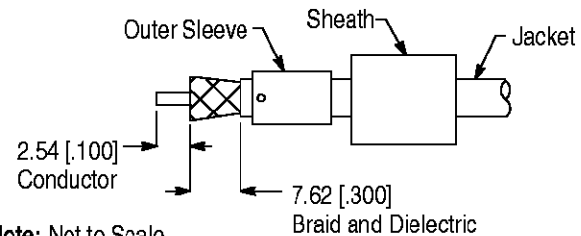
**DANGER** Follow safety precautions included with the tools used for assembly.

- Slide the sheath, then the outer sleeve onto the cable. Strip the cable to the dimensions shown in Figure 2. Take care not to nick the conductor. Flare the braid.
- Slide the solder gauge over the conductor until it butts against the dielectric. Tin the conductor.
- Place the center contact in the center contact holder. Heat the center contact with a soldering iron, then carefully push the center contact over

the conductor until it rests firmly against the solder gage. See Figure 3, Detail A. Remove the solder gage from the cable. Remove excess solder and splatter.

4. Secure the threaded end of the housing subassembly onto the locator tool. Secure the assembly in a small bench vise.

5. Insert the center contact into the back of the housing subassembly until the center contact is seated firmly. Make sure that the braid does not enter the housing subassembly. See Figure 3, Detail B.



Note: Not to Scale

Figure 2

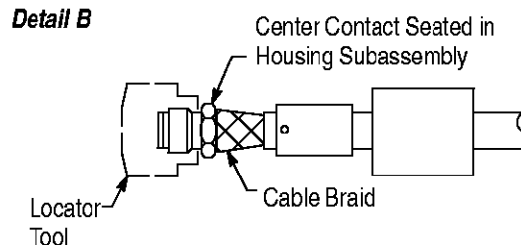
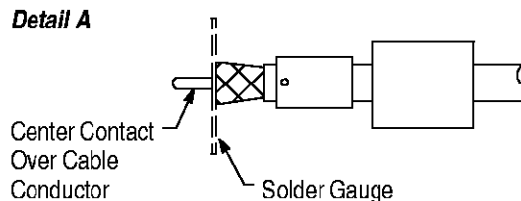


Figure 3

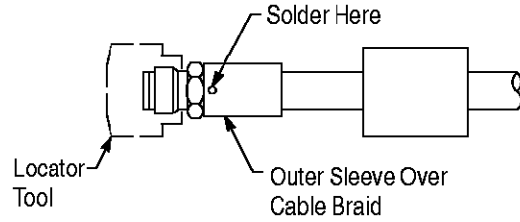
6. Slide the outer sleeve over the braid. Holding the cable in place, solder through the holes in the outer sleeve. Trim excess braid strands. Refer to Figure 4, Detail A.
7. Slide the sheath over the outer sleeve until the ends are aligned. Using a heat gun, apply indirect heat to the sheath until the sheath has shrunk and is secured to the cable. Refer to Figure 4, Detail B.
8. Remove the assembly from the locator tool.
9. Adherence to assembly procedure should yield tolerances shown in Figure 5.

**4. REVISION SUMMARY**

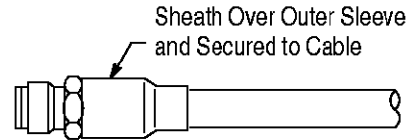
Revisions to this instruction sheet per EC 0990-1448-00 include:

- Updated document to corporate requirements

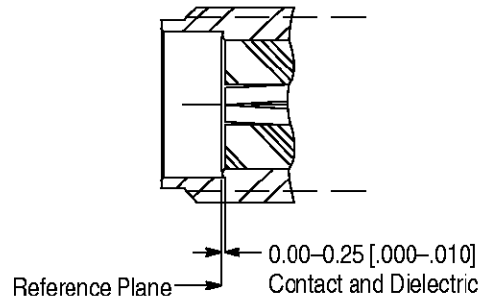
**Detail A**



**Detail B**



*Figure 4*



*Figure 5*