

RG/U Cable	PLUG		BULKHEAD JACK		RIGHT-ANGLE PLUG		Crimping Tool	
	Govt Desig M39012/	TE Part No.	Govt Desig M39012/	TE Part No.	Govt Desig M39012/	TE Part No..	Braid Crimp	TE Part No.
58A, 58C	55B3021	225532-1	--	--	56B3021	225609-1	A	220061-1 (408-2392)
142, 142A, 142B	55B3022	225532-3	--	--	--	225609-3	A	
174, 188A,316	55B3019	225532-4	--	225608-4	56B3019	225609-4	B	
180B, 195A	--	--	--	--	--	--	A	
179B, 187A	--	225532-8	--	--	--	--	B	
141, 141A, 303	55B3024	225532-9	--	--	--	--	A	
55A, 223	55B3023	1-225532-0	--	--	--	--	A	
188, 316, Double Braid	--	1-225532-1	--	--	--	--	A	59962-1 (408-6750)
142, 142A, 142B	--	1-225532-4	--	--	--	--	A	220061-1 (408-2392)
179B, 187A	--	5-225532-8	--	--	--	--	B	

Figure 1

1. INTRODUCTION

This instruction sheet deals with SMA Series 50–Ohm Connectors for flexible cable listed in Figure 1.

Reasons for re–issue can be found in Section 3, REVISION SUMMARY.

NOTE *Dimensions on this sheet are in millimeters [with inch equivalents provided in brackets]. Figures and illustrations are for identification only and are not drawn to scale.*

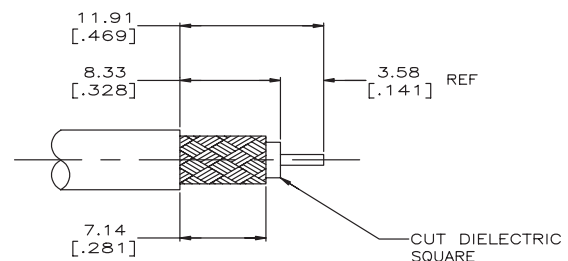
NOTE *Examine the braid wires and center conductor of the cable under 10 X magnification for nicks or damage. Be sure that the center conductor is straight and free of burrs.*

2. Crimp the center contact onto the center conductor using the tool listed in Figure 1.

2. ASSEMBLY PROCEDURE

Select the appropriate cable size and connector. Refer to the table in Figure 1.

1. Slide the ferrule onto the cable, then strip the cable according to the dimensions shown in Figure 2.



RECOMMENDED STRIP LENGTH

Figure 2

3. Insert the crimped contact into the connector with the braid over the support sleeve. Pull back lightly on the cable to ensure that the contact is

held captive by the contact's internal locking features. Refer to Figure 3.

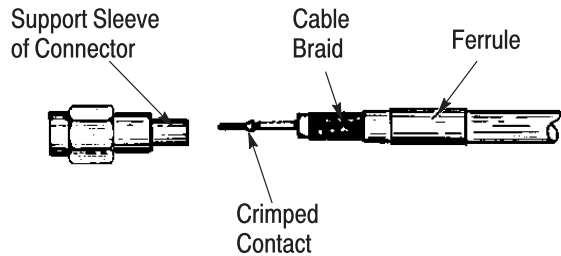


Figure 3

NOTE



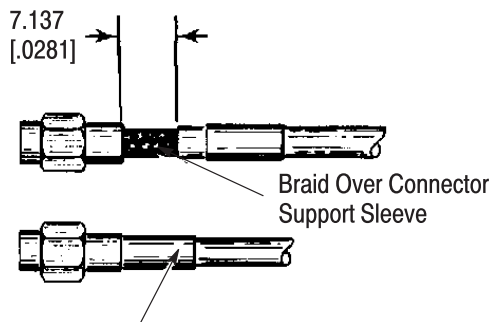
Due to the size and smoothness of certain cables (RG 316 188A), wrapping masking tape temporarily around the cable jacket will aid in gripping the cable jacket while pushing the contact in to engage the internal locking feature. Also grip the cables close to the connector to prevent the cable from buckling.

NOTE



If the cable jacket moves on short lengths of cable (such as RG 316 and 188A), trim the end of the jacket as shown in Figure 4.

If the Cable Has Moved on the Braid During Contact Insertion, Trim the End of the Jacket as Shown.



Slide the Ferrule Forward Over the Braid and Support Sleeve

Figure 4

4. Slide the ferrule over the braid as shown in Figure 4.
5. Crimp the ferrule onto the braid using the tool listed in Figure 1.
6. Examine the crimps under magnification for damage or irregularities. Periodically inspect the die closure of the hand tool (see 408-2392)
7. Torque the mated connectors seven to ten inch pounds.

3. REVISION SUMMARY

Since the previous release of this instruction sheet, the following changes have been made:

- Steps have been added to the assembly procedure;
- The TE logo has been applied; and
- Added three SMA Plugs;
- The format has been updated to the current corporate requirements.