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PLUG PART NUMBER		MILITARY PART NUMBER M39012/56-	CABLE (RG/U)	CRIMP TOOL MILITARY PART NUMBER M22520/5-	CRIMP DIE		PLUG DIMENSION mm [in.]	
CURRENT	PREVIOUS				MILITARY PART NUMBER M22520/5-	DIE CLOSURE	A	B
1052171-1	2037-8025-92	3025	178	01	03	B	0.94 [.037]	2.57 [.101]
1052201-1	2037-8125-92	3125■			33			
1052173-1	2037-8026-92	3026	174	01	03	A	1.70 [.067]	3.25 [.128]
1052203-1	2037-8126-92	3126			35	B		
1052174-1	2037-8027-92	3027	122	01	05	B	2.54 [.100]	4.45 [.175]
1052204-1	2037-8127-92	3127■			09	A		
1052176-1	2037-8028-92	3028	142	01	05	A	3.10 [.122]	5.56 [.219]
1052206-1	2037-8128-92	3128■			11			
1052177-1	2037-8029-92	3029	58	01	19	B	3.10 [.122]	5.21 [.205]
1052207-1	2037-8129-92	3129■			303	57		

■ No Safety Wire Holes

Figure 1

1. INTRODUCTION

SMA right-angle cable plugs (crimp attachment) listed in Figure 1 are designed to be soldered to the appropriate cable sizes using the corresponding tools.

The following tool is optional:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Locator Tool	1055451-1	2098-5218-02 (T-2367)

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 5, REVISION SUMMARY.

2. DESCRIPTION

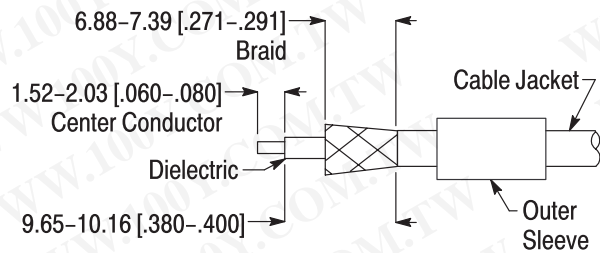
The plug consists of the components shown in Figure 1. The housing subassembly contains a contact.

3. ASSEMBLY PROCEDURE

DANGER

Follow safety precautions included with the tools used for assembly.

- Slide the outer sleeve onto the cable.
- Strip the cable to the dimensions shown in Figure 2. Flare the cable braid.
- Secure the housing subassembly to the locator tool as shown in Figure 3. Secure the housing subassembly in a small bench vise.
- Tin the cable center conductor.
- Insert the center conductor into the housing subassembly making sure that the center conductor sits in the contact slot and is flush to below the contact. See Figure 3.



Note: Not to Scale

Figure 2

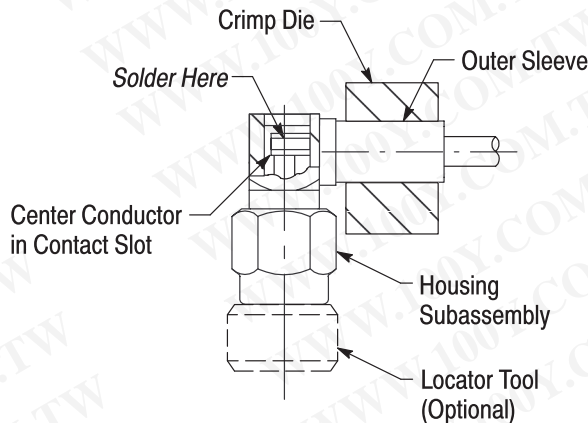


Figure 3

- Place the soldering iron on the tip of the contact, and solder. Refer to Figure 3.
- Slide the outer sleeve over the cable braid, and crimp the outer sleeve in place. Trim excess braid strands. Refer to Figure 3. Remove the assembly from the crimp tool.

- Press the disc into the opening at the back of the housing subassembly. See Figure 4. Remove the assembly from the locator tool. If preferred, apply epoxy to the disc to hold it in place. DO NOT allow epoxy to penetrate the housing subassembly.

NOTE

Adherence to steps given will yield tolerances provided in military document MIL-PRF-39012/56.

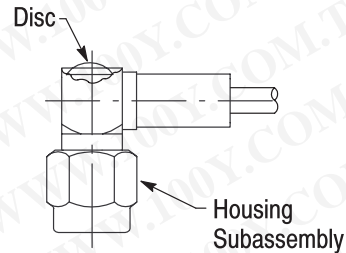


Figure 4

4. REPLACEMENT AND REPAIR

DO NOT re-use any crimped or soldered components by removing the cable. DO NOT re-use the disc after it has been assembled to the plug.

Components of the plug are not repairable. DO NOT use any defective or damaged components.

5. REVISION SUMMARY

Since the previous revision of this document, Figure 4 was corrected.

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