



Figure 1: D38999 Connector with Pin and Socket

1. INTRODUCTION

SMPM contacts shown in Figure 1 are designed to be soldered to semi-rigid, conformable, or flexible coaxial cable, and assembled into D38999 connectors.



Part Numbers	Type
2389332-1	Socket Contact 
2389333-1	Pin Contact 

Table 1: SMPM High Speed Contact Types

i NOTE:
Dimensions in this instruction sheet are in inches

2. DESCRIPTION

The cable pin consists of a front shell (interface), rear shell, spring loaded sleeve and loose center conductor. The cable socket consists of a front shell (interface), rear shell, and captivated center conductor.

! CAUTION
*Do Not nick the center conductor of the cable.
Take care not to cut the cable braid.*

3. ASSEMBLY PROCEDURE

- Strip the cable to the dimensions shown in Figure 2.
- For flexible cable, tin the cable braid. Be careful not to overheat the cable. Remove portion of jacket to

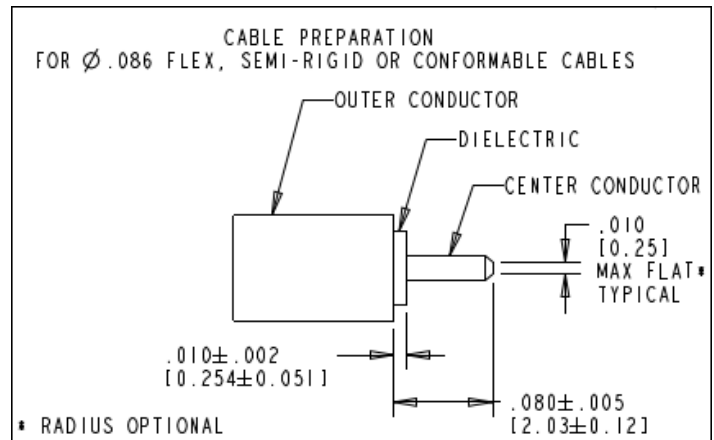


Figure 2: Coaxial Cable Stripping Dimensions

dimension shown in Figure 3

- Shape the blunt end of the center conductor to a cone between 70° and 90°. See Figure 2.
- For socket contact 2389332-1 (only), assemble center conductor onto cable center conductor. See Figure 3.
- Insert the cable center conductor into the rear shell of the SMPM contact until the cable bottoms in the contact.
- Center and secure the coaxial cable to prevent movement, and solder the outer conductor to the inside the rear shell of the contact using SN60 or SN63 solder as shown in Figure 4.
- A fixture as shown in figure 5 can assist with the soldering process.

5. REPLACEMENT AND REPAIR

The contacts are not repairable. DO NOT use any defective or damaged contacts.

6. REVISION SUMMARY

- REVISION A: RELEASE TO PRODUCTION.

DANGER



To avoid personal injury, make sure to follow all local practices and safety precautions when working with soldering equipment.

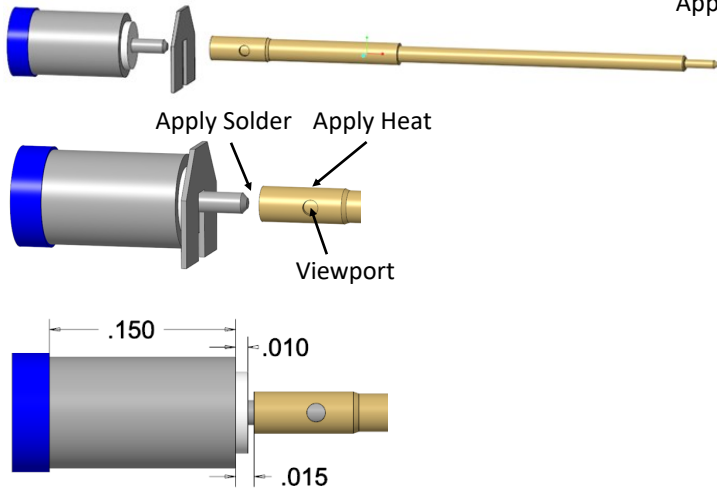


Figure 3: Center Conductor Attachment
(2389332-1 only)

1. Prepare cable as shown in figure 2.
2. Gently secure coaxial cable in a small vice or soldering fixture.
3. Place a shim on cable center conductor.
4. Tin the cable center conductor, or put a small piece of solder in contact center conductor.
5. Apply heat on the contact center conductor near the viewport to reflow the solder, and push lightly towards shim.
6. Look for wetting in viewport while maintaining pressure until center conductor touches shim.
7. Maintaining pressure, remove heat and wait 3 seconds.
8. Remove Shim.

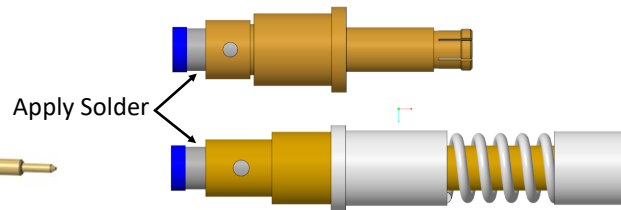


Figure 4: Finished assemblies after soldering.

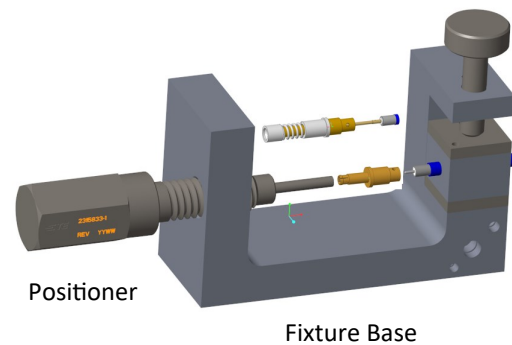


Figure 5: Soldering Fixture.



NOTE:

A positioner can help to maintain concentricity of the center conductor and contact during installation of the coaxial cable into the rear shell.

Contact your local TE Connectivity sales representative for any inquiries about soldering fixtures and positioners.