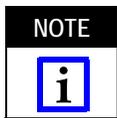


Figure 1

1. INTRODUCTION

SSMA Straight Cable Plugs (Direct Solder Attachment) 1058588-1, 1045350-1, 1045351-1, and 1062250-1 are designed to be installed onto .085 semi-rigid coaxial cable size RG 405 using the following tools:

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	CURRENT	PREVIOUS
Fixture Base	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055441-1	2098-5208-54 (T-4700-2)
Solder Gage	91362-1	2098-5212-02 (T-4562-1)
Center Contact Holder	1055463-1	2098-5237-10 (T-4579)
Locator Tool	1055457-1	2098-5232-02 (T-4570)
Dielectric Bushing Insert Tool	1055459-1	2098-5234-02 (T-4559)



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 cable plug consists of a dielectric bushing, housing subassembly, and center contact. See Figure 1.

3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

3.1. Prepare Cable

1. Insert the squared end of the cable into Hole Pattern 2 of the fixture base. See Figure 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 fixture base, and finish cutting the dielectric with a cutting blade.

4. Bare the inner conductor by prying the cut outer conductor and dielectric from the cable.

3.2. Solder Center Contact to Cable

1. Tin the inner conductor of the cable.

2. Insert the inner conductor into the solder gage so that it is flush with the edge of the solder gage. See Figure 3.

3. Place the center contact in the center contact holder, heat the center contact, then push it over the inner conductor of the cable so that it rests firmly against the solder gage. See Figure 3.

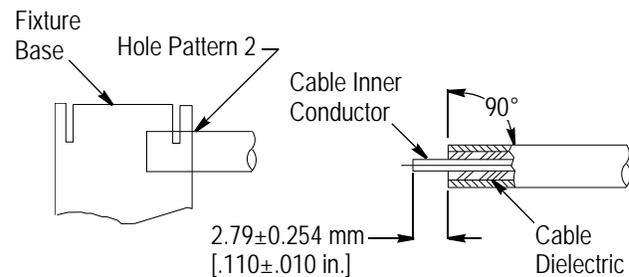


Figure 2

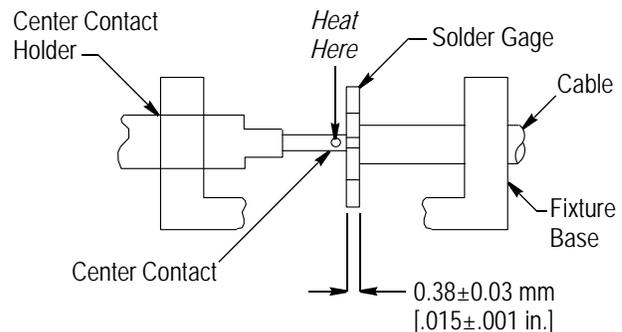
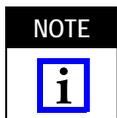


Figure 3

4. Remove the center contact from the solder gage.
Remove excess solder.

3.3. Solder Cable to Housing

1. Place housing subassembly onto the end of the cable subassembly.
2. Place the housing subassembly and cable into the fixture base as shown in Figure 4. Ensure that:
 - a. the center contact is in the nest of the locator tool,
 - b. the clamp screw is tight enough to secure the cable, and
 - c. the locator tool is tight enough to seat the cable firmly.
3. Slide the housing subassembly over the locator tool so that it is firmly against the locator tool, and using 60/40 solder, solder the housing subassembly to the cable.



The fixture should be clamped vertically in a vise to keep the housing subassembly seated against the locator tool.

3.4. Install Dielectric Bushing into Housing Subassembly

1. Thread the housing subassembly onto the dielectric bushing insert tool. See Figure 5.
2. Insert the dielectric bushing into the housing of the dielectric bushing insert tool.
3. Place the plunger of the dielectric bushing insert tool into position, and press it until the flange bottoms on the housing of the tool.

3.5. Inspection

Adherence to assembly procedure will yield tolerances given in Figure 6.

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company logo
- Updated instruction sheet to corporate requirements
- Changed OSSM to SSMA
- Added cable size and current tool part numbers to Section 1

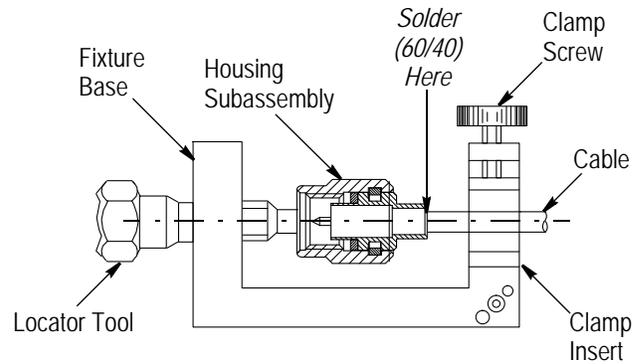


Figure 4

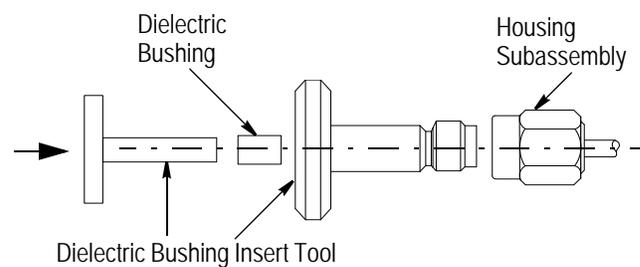


Figure 5

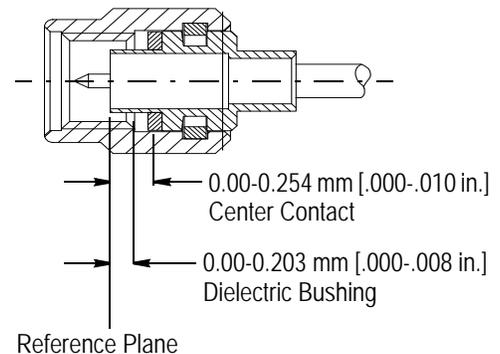


Figure 6