

TE PART NUMBER	PREVIOUS PART NUMBER	CABLE TYPE
1057245-1	3031-7358-10	RG58/U, 141, 303

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for Type N Straight Cable Plug 1057245-1, shown in Figure 1. This connector is a crimp attachment type connector that attaches to the cable type listed in Figure 1. Figure 1 also contains the previous Type N Straight Cable Plug part number.



Dimensions on this sheet are in millimeters [with inches in brackets], unless otherwise specified. Figures are not drawn to scale.

The table in Figure 2 references the tools required to apply this connector. The table includes tool descriptions, TE Connectivity part numbers, and the corresponding M/A-COM part numbers.

APPLICATION TOOLING		
Tool Description	TE Part No.	M/A-COM Part No.
Center Contact Holder	1055472-1	2098-5277-10 (T-4581)
Crimp Tool	1055236-1	2098-0105-54 (Die Set B)

Figure 2

Reasons for reissue are provided in Section 3, REVISION SUMMARY.

2. ASSEMBLY PROCEDURES

2.1. Preparing the Cable (Figure 3)

- Place the heat shrink tubing and the outer sleeve on the cable.
- Using a knife, remove the end portion of the cable jacket to expose the cable braid.



To avoid personal injury, be sure to adhere to all local safety practices (including gloves and eye protection) when handling a knife.

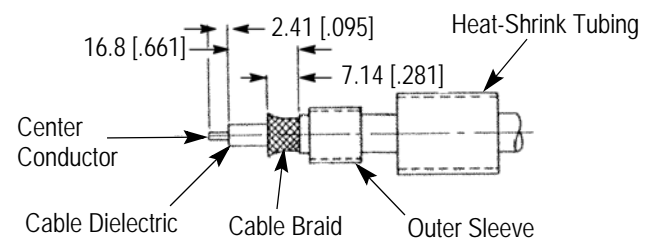


Figure 3

- Trim the cable braid to length.
- Trim the cable dielectric to length.
- Trim the center conductor to length.
- Flare the cable braid.

2.2. Crimping the Cable to the Inner Sleeve (Figure 4)



To avoid personal injury, be sure to exercise caution when operating soldering equipment.

- Tin the center conductor of the cable.
- Assemble the inner sleeve into the clamp nut.
- Position and secure the inner sleeve in a bench vise.
- Insert the cable dielectric into the inner sleeve and seat firmly.
- Slide the outer sleeve over the flared portion of the cable braid.
- Ensure that the cable is firmly seated and crimp the outer sleeve in place.
- Trim and remove excess cable braid.
- If necessary, trim the dielectric so that it is flush to the face of the inner sleeve.

2.3. Soldering the Center Contact to the Cable Center Conductor (Figure 5)

1. Assemble the rear dielectric onto the inner conductor of the cable and seat it against the inner sleeve.



To avoid personal injury, be sure to exercise caution when operating soldering equipment.

2. Place the center contact in the holder, heat the center contact, and push it over the center conductor of the cable. The large diameter of the contact should rest firmly against the rear dielectric.

3. Remove excess solder.

2.4. Completing the Assembly (Figure 6)

1. Carefully insert the center contact into the dielectric bushing inside of the housing subassembly.
2. Engage the threads of the retaining nut to the housing and tighten to 25 Inch-Pounds.
3. Position the heat-shrink tubing over the outer sleeve as shown in Figure 6.
4. Heat (and shrink) the tubing over the outer sleeve.

2.5. Inspecting the Completed Connector Assembly

Inspect the completed connector assembly using the dimensions in Figure 7.

3. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.

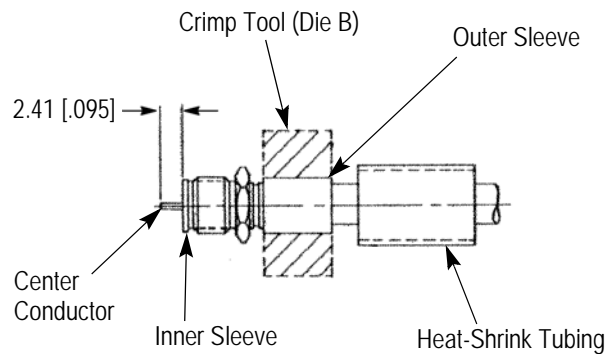


Figure 4

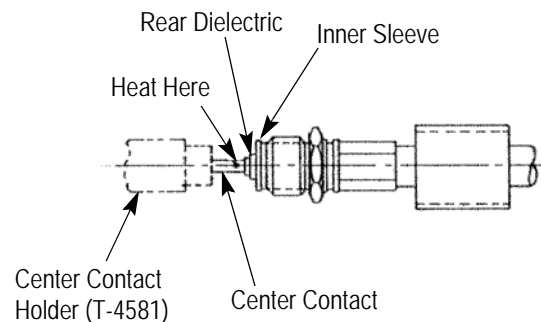


Figure 5

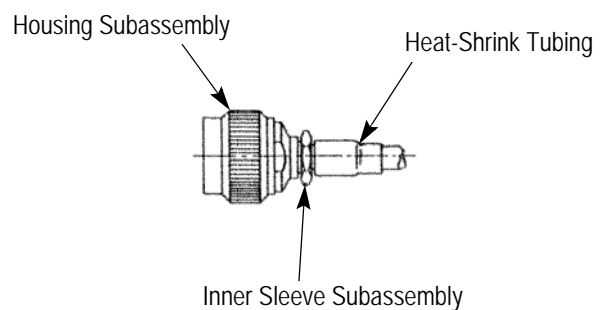


Figure 6

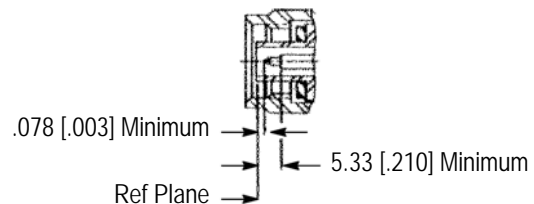


Figure 7