

Figure 1

1. INTRODUCTION

This instruction sheet provides assembly procedures for Type N Straight Cable Plug Connector 1057088-1 (3001-7941-00) shown in Figure 1. This solder attachment-type plug is used on .141-inch semi-rigid coaxial cable.

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 4, REVISION SUMMARY.

Figure 2 lists tools applicable for assembly of the plug connector.

TOOL

DESCRIPTION	CURRENT PART NUMBER	PREVIOUS PART NUMBER
Center Contact Holder	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055440-1	2098-5207-54 (T-4700L)
Center Contact Holder	1055472-1	2098-5277-10 (T-4581)
Solder Gage	1055271-1	2098-0327-02 (T-4562-3)
Locator Tool	1055470-1	2098-5275-02 (T-4571)
Dielectric Insert Tool	1055473-1	2098-5278-02 (T-4584)

Figure 2

2. DESCRIPTION

The plug connector consists of a dielectric, housing subassembly, and center contact. See Figure 1.

3. ASSEMBLY PROCEDURE

3.1. Prepare Coaxial Cable End (Figure 3)

1. Insert the squared cable end into the fixture base hole pattern no. 2.
2. Place a saw in the saw slot, and cut through the outer conductor and into the dielectric while rotating the cable.
3. Remove the cable from the fixture, and finish cutting the dielectric with a cutting blade.

DANGER



To avoid personal injury, be sure to follow all local safety standards (including wearing gloves) when handling a knife.

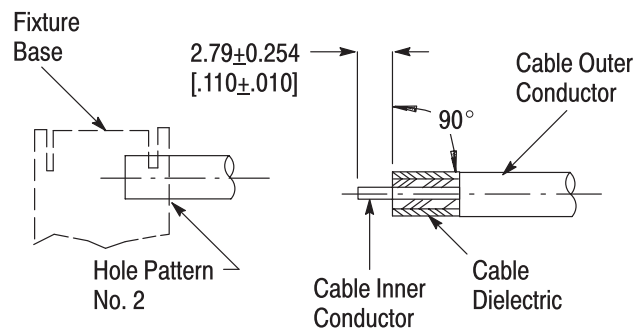


Figure 3

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

3.2. Solder Center Contact to Cable Inner Conductor

DANGER



To avoid personal injury, exercise caution when using soldering equipment.

1. Tin the inner conductor of the cable.
2. Place the solder gage on the inner conductor flush with the end of the outer conductor.
3. Place the center contact in the center contact holder, heat the center contact, and push it over the inner conductor so that it rests firmly against the solder gage. See Figure 4.
4. Remove the solder gage and the excess solder.

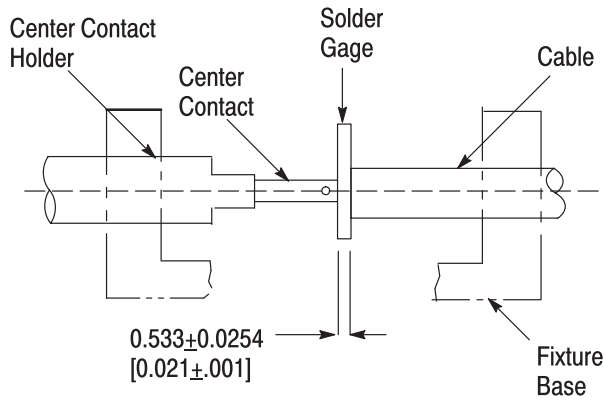


Figure 4

3.3. Solder Cable Subassembly to Housing

1. Place the connector housing on the cable.
2. Place the assembly in the fixture base as shown in Figure 5.
 - a. Nest the center contact in the locator tool.
 - b. Tighten the clamp screw to secure the cable subassembly.
 - c. Tighten the locator tool to seat the cable firmly.

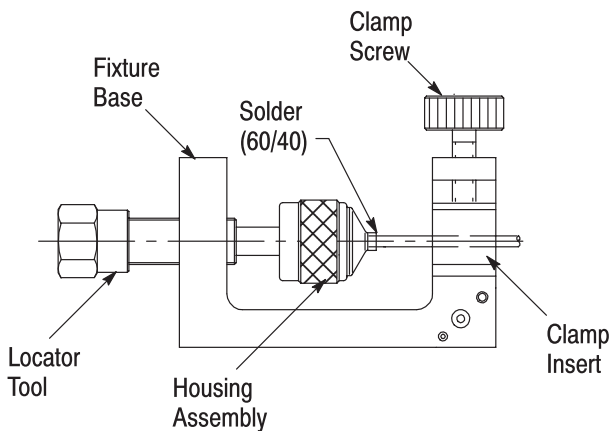


Figure 5

3. Slide the housing over the locator tool.
4. Solder the cable to the housing while maintaining the position of the housing against the locator tool.



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

3.4. Press Dielectric Busing into Housing Subassembly

1. Thread the insert tool into the housing subassembly. See Figure 6.
2. Insert the dielectric into the insert tool housing.

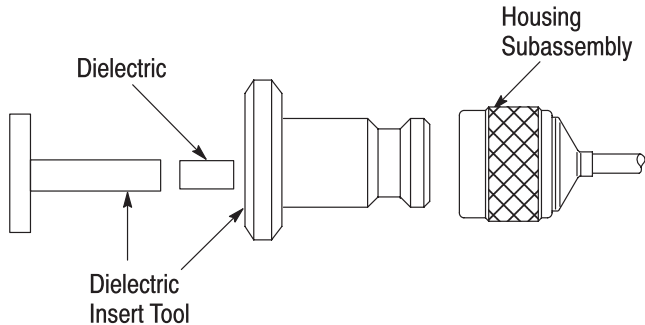


Figure 6

3. Place the insert tool plunger into position and press it until the flange bottoms on the tool housing. Assembly is now complete.

3.5. Inspect Completed Connector Assembly

Adherence to the preceding steps should yield the tolerances shown in Figure 7.

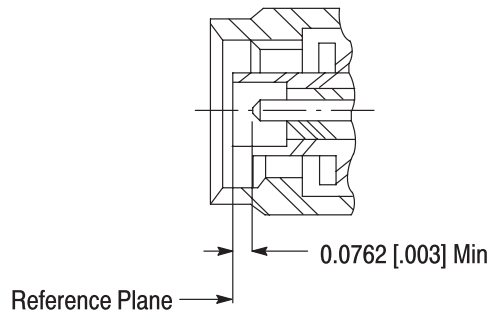


Figure 7

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements
- Corrected dimension in Figure 4