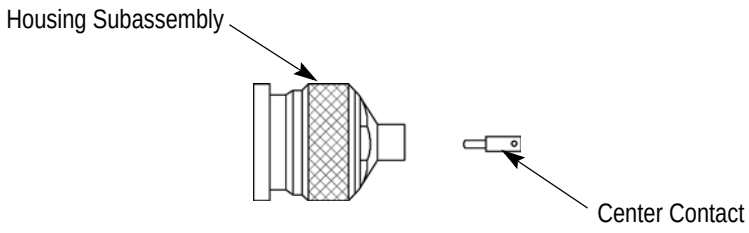

Figure 1

1. INTRODUCTION

TNC Straight Cable Plug (Direct Solder Attachment) 1057631-1 is designed to be crimped onto .141 semi-rigid coaxial cable or microporous cable using the following tools:

TOOL DECRIPTION	PART NUMBER CROSS-REFERENCE	
	TE CONNECTIVITY	M/A-COM
Fixture Base	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055440-1	2098-5207-54 (T-4700-1)
Center Contact Holder	1055474-1	2098-5279-10 (T-4580)
Solder Gage	1055475-1	2098-5281-02 (T-4562-6)
Locator Tool	1055476-1	2098-5282-02 (T4596)

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.

2. DESCRIPTION

The plug consists of a housing subassembly and center contact. Refer to Figure 1.

3. ASSEMBLY PROCEDURE

DANGER

Follow safety precautions included with the tools used for assembly.

1. Insert squared end of cable into Hole Pattern 2 of the fixture base. Place a saw in the saw slot, and cut through the outer conductor and into the dielectric while rotating the cable.

2. Remove the cable from the fixture base, and continue cutting the dielectric with a cutting blade. Remove the cut outer conductor and dielectric from the cable to expose the inner conductor. See Figure 2.

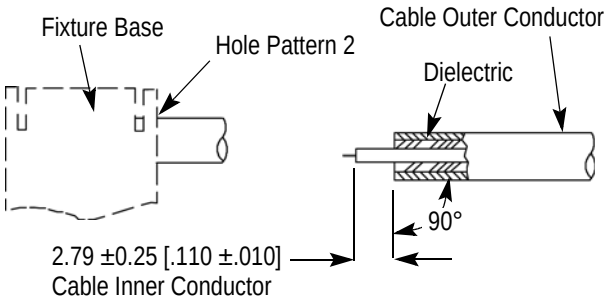

Figure 2

3. Tin the inner conductor. Place the solder gage on the inner conductor so that it is flush with the outer conductor. See Figure 3.

CAUTION

For microporous cable, do not use flux or solvent near cable dielectric.

4. Place the center contact in the center contact holder. Heat the center contact, and slide it onto the inner conductor until it butts firmly against the solder gage. See Figure 3.

5. Remove solder gage and excess solder.

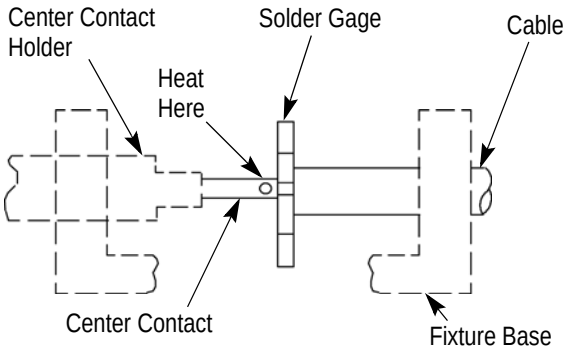

Figure 3

6. Insert center contact into housing subassembly. Place assembly into fixture base as shown in Figure 4. Tighten the clamp screw to secure the cable. Tighten the locator tool to seat the cable firmly against the housing subassembly.

NOTE

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

7. Join the cable to the housing subassembly using solder of 60% tin and 40% lead at the location shown in Figure 4.

8. Adherence to assembly procedure should yield tolerances shown in Figure 5.

4. REVISION SUMMARY

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

- Updated document to corporate requirements.

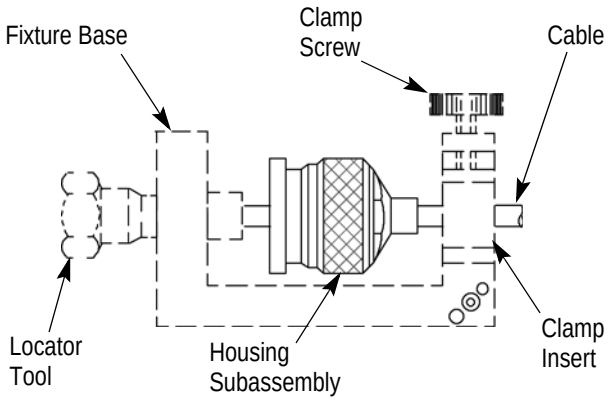

Figure 4

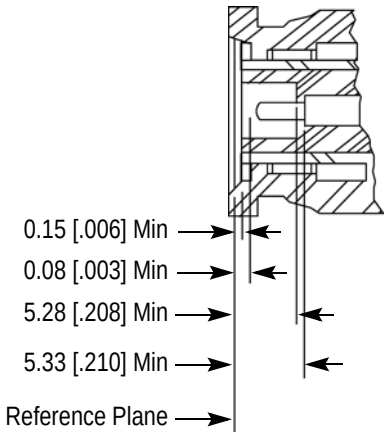

Figure 5