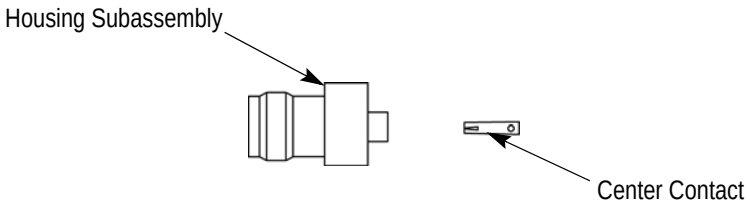

Figure 1

1. INTRODUCTION

TNC Straight Cable Jacks (Direct Solder Attachment) 1057697-1 and 2157977-1 are designed to be soldered onto .141 semi-rigid coaxial cable or microporous cable using the following tools:

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	TE CONNECTIVITY	M/A-COM
Fixture Base	1055439-1	2098-5206-54 (T-4574)
Clamp Insert	1055440-1	2098-5207-54 (T-4700-1)
Center Contact Holder	1055474-1	2098-5279-10 (T-4580)
Solder Gage	91362-3	2098-5281-02)T-4562-6)
Locator Tool	1055477-1	2098-5283-02 (T-4574)

NOTE

Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

The jack 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 the cable end into Hole Pattern 2 of the fixture base. Refer to Figure 2.

2. While rotating the cable, cut through the cable jacket and into, but not through, the dielectric. Remove the cable from the fixture base, and finish cutting the dielectric with a blade.

3. Pry the jacket and dielectric from the cable to expose the center conductor. Make sure that the center conductor meets the dimension shown in Figure 2.

4. Tin the center conductor.

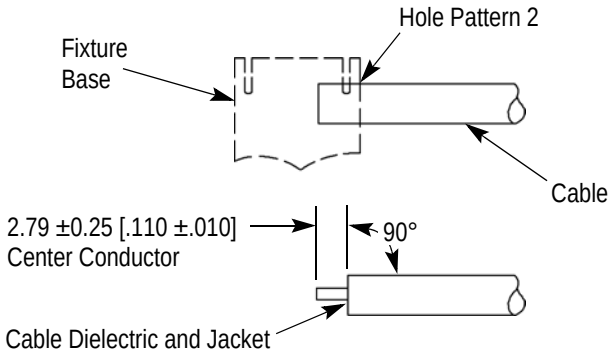

Figure 2

5. Place the center conductor in the solder gage. Align the end of the jacket with the solder gage. See Figure 3.

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

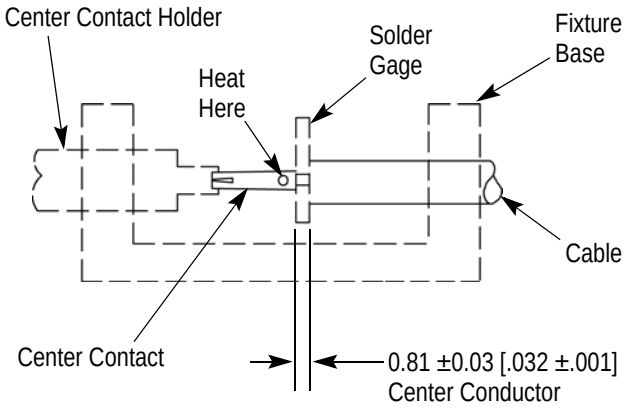

Figure 3

7. Remove the solder gage and center contact holder. Remove excess solder from the center contact.

CAUTION

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

8. Insert the center contact into the housing subassembly.

9. Clamp the fixture base vertically in the vise. Place the cable in the clamp insert and the housing subassembly in the fixture base as shown in Figure 4. Tighten the clamp screw to secure the cable. Tighten the locator tool to seat the housing subassembly firmly against the cable.

NOTE

The fixture base should be clamped vertically so that the housing subassembly stays against the locator tool.

10. Using solder made of 60% tin and 40% lead, join the housing subassembly to the cable at the location shown in Figure 4.

11. 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:

- Added new part number to title and Section 1, INTRODUCTION

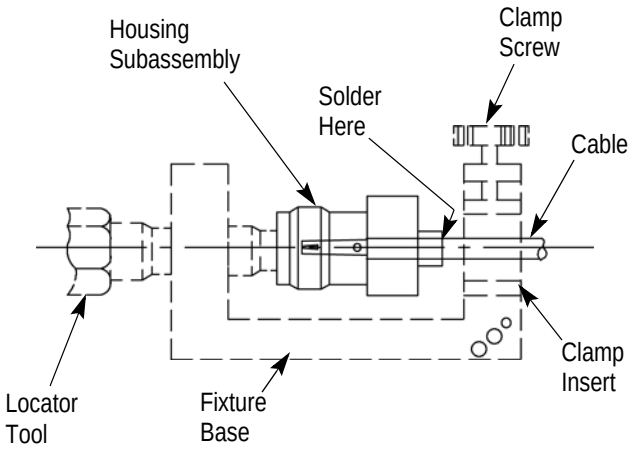

Figure 4

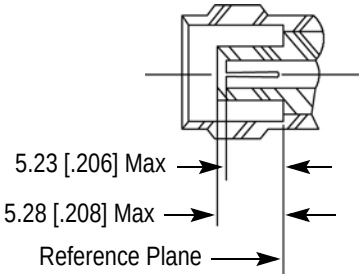

Figure 5