

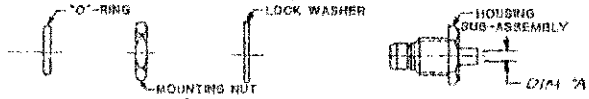


**OSP Bulkhead Feedthrough Cable Plug
Rear Mount Direct Solder Attachment
1059386-1 and 1059384-1**

Instruction Sheet
408-8291
(was A.P. 45-164)
01 MAR 00 Rev O
EC 0990-0249-00

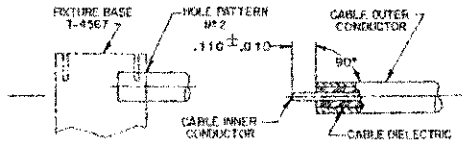
CONNECTOR TYPE OSP BULKHEAD FEEDTHROUGH CABLE PLUG-REAR MOUNT DIRECT SOLDER ATTACHMENT	CABLE TYPE RG405/U .085 SEMI-RIGID COAXIAL CABLE	TOOLS REQUIRED: FIXTURE BASE: 2088-5208-54 (T-4567) CLAMP INSERT: 2088-5208-54 (T-4708-2) LOCATOR TOOL: 4598-6005-02
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CONNECTOR

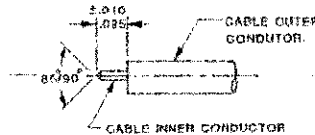


ASSEMBLY OPERATIONS

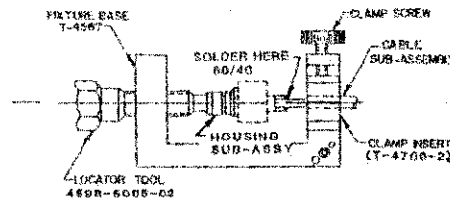
- 1.0 PREPARATION OF CABLE**
- 1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #2.
 - 1.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
 - 1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.
 - 1.4 BARE INNER CONDUCTOR BY FRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.
 - 1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR TO DIMENSION SHOWN.



- 2.0 SHAPE INNER CONDUCTOR OF CABLE**
- 2.1 TRIM INNER CONDUCTOR TO LENGTH AS SHOWN.
 - 2.2 FILE BEAMT END OF INNER CONDUCTOR TO AN 85°-90° CONE.



- 3.0 SOLDERING OF CABLE TO HOUSING SUB-ASSEMBLY**
- 3.1 ASSEMBLE CABLE INTO HOUSING SUB-ASSEMBLY.
 - 3.1.1 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE-ASSEMBLED CENTER CONTACT OF HOUSING SUB-ASSEMBLY.
 - 3.2 PLACE LOCATOR ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 3.2.1 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 3.2.2 TIGHTEN LOCATOR TOOL TO SEAT HOUSING SUB-ASSEMBLY FIRMLY.
 - 3.3 MAINTAIN POSITION OF HOUSING SUB-ASSEMBLY FIRMLY AGAINST LOCATOR TOOL AND SOLDER.



NOTE: FIXTURE BASE SHOULD BE CLAMPED VERTICAL IN A VISE TO KEEP HOUSING SUB-ASSEMBLY SEATED AGAINST LOCATOR TOOL.

ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN ON DESC DRAWINGS

DESC P/N	M/A-COM P/N	CABLE TYPE	DIM 'A'
85072ZSGA	4503-5022-00	RG402	.144MIN
85072ZSGB	4503-5023-00	RG405	.088MIN