

TYCO ELECTRONICS PART NUMBER	DESCRIPTION	CABLE
1060772-1	MCX Straight Cable Plug	.085 S/R
1060772-2	MCX Straight Cable Plug	.047 S/R

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedure for the MCX Straight Cable Plugs shown in Figure 1. These connectors are solder attachment type connectors that attaches to .085 S/R and .047 S/R cable.

No special tools (other than soldering equipment and cutting equipment) are required.

Revision information can be found in Section 3.

NOTE *Dimension on this sheet are in millimeters [with inches in brackets], unless otherwise specified.*

2. ASSEMBLY PROCEDURE

2.1. Preparing the Coaxial Cable End

1. Remove the end portion of the cable jacket to expose the cable dielectric and cable inner conductor.
2. Trim the dielectric and inner conductor as shown in Figure 2.

2.2. Soldering the Center Contact to the Cable Inner Conductor

DANGER *To avoid personal injury, exercise all local and safety practices when working with the soldering equipment.*

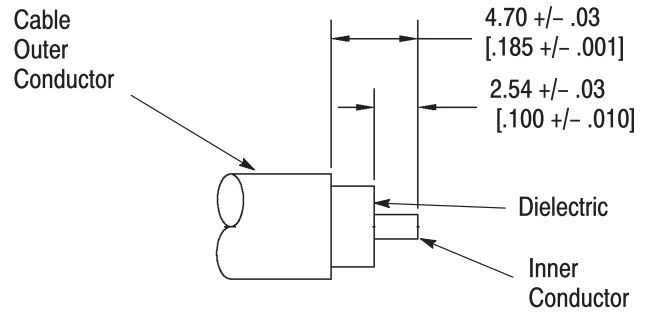


Figure 2

1. Tin the inner conductor.
2. Heat the center contact with the soldering equipment and carefully push it over the center conductor so that it butts against the dielectric. It should appear as shown in Figure 3.

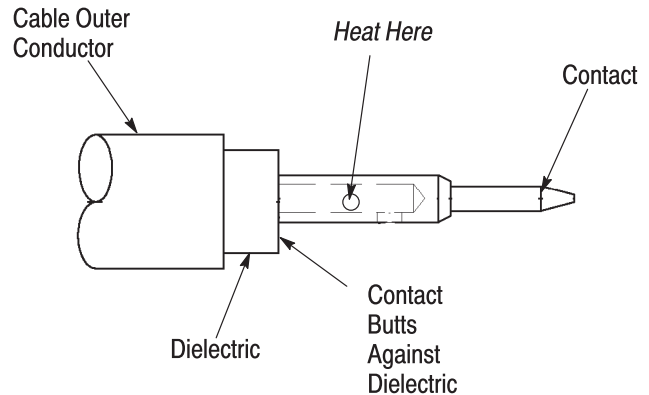


Figure 3

3. Remove excess solder and splatter.
- ### 2.3. Soldering the Housing Assembly to the Cable
1. Position and secure the housing in a small bench vise.
 2. Insert the cable into the housing assembly, and seat it against the inside of the housing.

DANGER *To avoid personal injury, exercise all local and safety practices when working with the soldering equipment.*

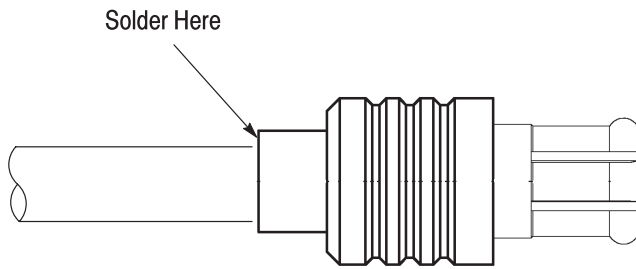


Figure 4

3. Solder the cable to the housing as shown in Figure 4.
4. Remove excess solder and splatter.

2.4. Inspection

Adherence to the previous steps should result in the tolerances shown in Figure 5.

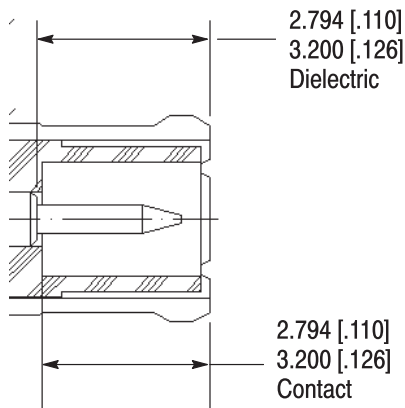


Figure 5

3. REVISION SUMMARY

Since the previous release, the following revisions were made:

- Updated format to current corporate requirements
- Added .047 S/R Cable
- Removed “previous part numbers”