

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for the OSMM Straight Cable Plug Direct Solder Attachments 1996942-1, which is applied onto .086 semi-rigid coaxial cable.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the previous part number to the TE Connectivity part number.

TOOL DESCRIPTION	TE PART NUMBER
Fixture Base	1055439-1
Clamp Insert	1055441-1
Center Contact Holder	1059108-1
Solder Gage	91362-6
Locator Tool	1059110-1

Figure 2



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

## 2. DESCRIPTION

The OSMM straight cable plug direct solder attachments consist of a dielectric, housing sub-assembly, and center contact.

## 3. ASSEMBLY PROCEDURES

### 3.1. Preparing the Cable

1. Insert squared cable end into fixture base hole pattern No. 2.
2. Place saw in saw slot and cut through outer conductor and into dielectric while rotating cable.

3. Remove cable from fixture and finish cutting dielectric with cutting blade.
4. Bare inner conductor by prying cut outer conductor and dielectric from cable.
5. Complete trimming of cable inner conductor to dimension shown in Figure 3.

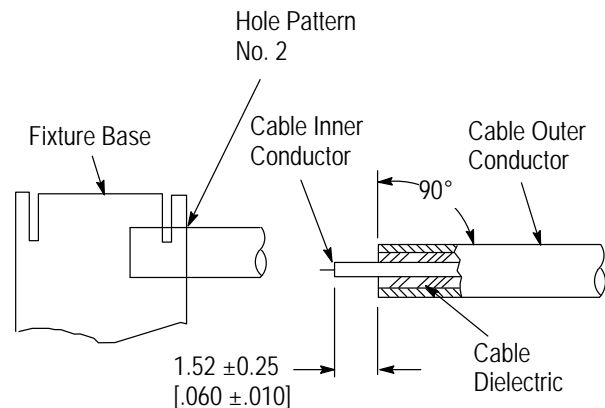


Figure 3

### 3.2. Soldering of Center Contact to Cable Inner Conductor (Figure 4)

1. Tin inner conductor of cable.
2. Place solder gage on inner conductor, flush with end of outer conductor.
3. Place center contact in holder. Heat center contact and push it over inner conductor of cable to rest firmly against solder gage.
4. Remove solder gage and excess solder.

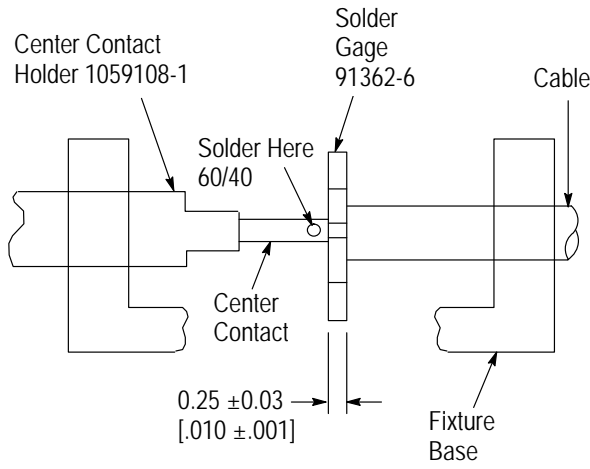


Figure 4

### 3.3. Soldering of Cable Sub-Assembly to Housing (Figure 5)

1. Place connector housing on end of cable sub-assembly.
2. Place loose assembly in fixture base as shown in Figure 5.
  - a. Nest center contact in locator tool.
  - b. Tighten clamp screw to secure cable.
  - c. Tighten locator tool to seat cable firmly.
3. Maintain position of housing firmly against locator tool and solder.

**NOTE** *Fixture base should be clamped vertically in vise to keep housing seated against locator tool.*



**CAUTION** *Damaged components must not be used. They must be replaced with new components.*



### 3.4. Inspection

Inspection of completed assembly will yield tolerances as provided in Figure 6.

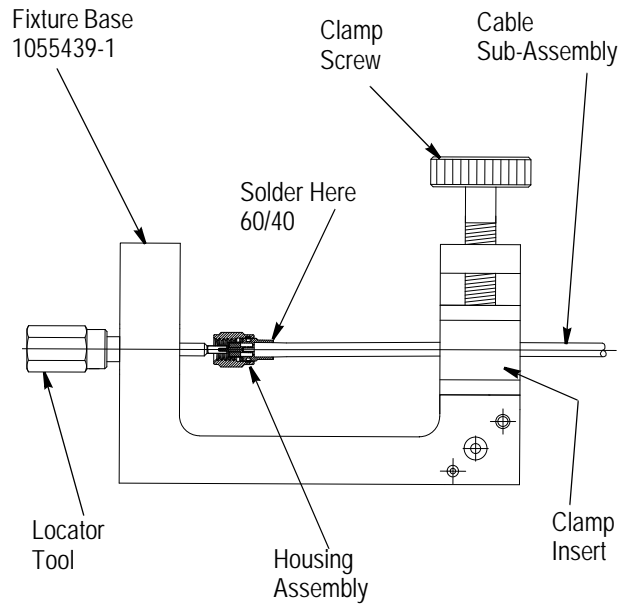


Figure 5

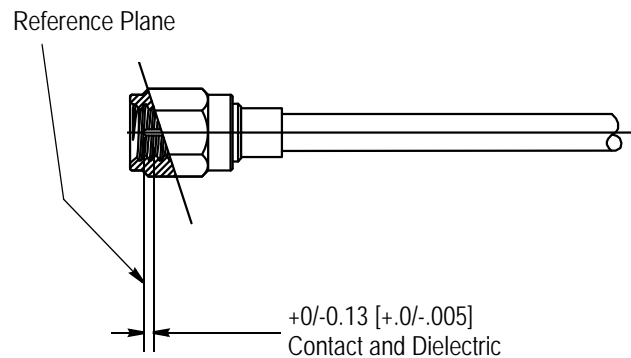


Figure 6

### 4. REVISION SUMMARY

- Initial release of document