

Figure 1

1. INTRODUCTION

OSSM straight cable plug (direct solder attachment) 1045358-1 is designed to be soldered to semi-rigid coaxial cable size RG 405/U with a diameter of 2.16 mm [0.085 in.] using the following tools:

TOOL DESCRIPTION	TOOL PART NUMBERS	
	CURRENT	PREVIOUS
Cable Fixture Subassembly	1055439-1	2098-5206-54 (T-4567)
Solder Gage	91362-1	2096-512-02 (T-4562-1)
Contact Holder Assembly	1055463-1	2098-5237-10 (T-4579)
Insert Assembly	1055441-1	2098-5208-54 (T-4700-2)
Locator Tool	1055457-1	2098-5232-02 (T-4570)
Dielectric Insert Tool	1055459-1	2098-5234-02 (T-4559)

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 5, REVISION SUMMARY.

2. DESCRIPTION

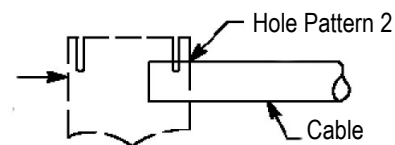
The plug consists of a dielectric, housing subassembly, and center contact. See Figure 1.

3. ASSEMBLY PROCEDURE

DANGER Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into Hole Pattern 2 of the cable fixture subassembly. Refer to Figure 2, Detail A.
2. Place a saw in the saw slot and while rotating the cable, cut through the cable jacket and into, but not through, the dielectric. Remove the cable from the cable fixture subassembly, 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, Detail B.

Detail A



Detail B

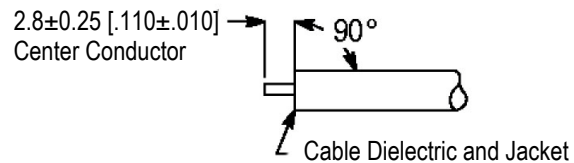


Figure 2

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

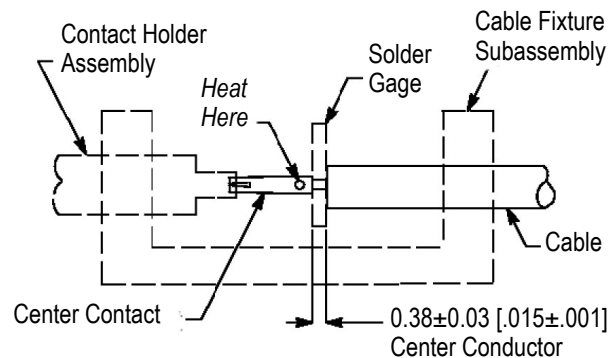


Figure 3

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

7. Remove the center contact from the solder gage. Remove excess solder.
8. Insert the center contact into the housing subassembly.
9. Place the assembly in the cable fixture subassembly as shown in Figure 4. Clamp the cable fixture subassembly vertically in the vise. Tighten the clamp screw to secure the cable. Tighten the locator tool to seat the housing subassembly firmly against the locator tool.

NOTE *The cable fixture subassembly 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.

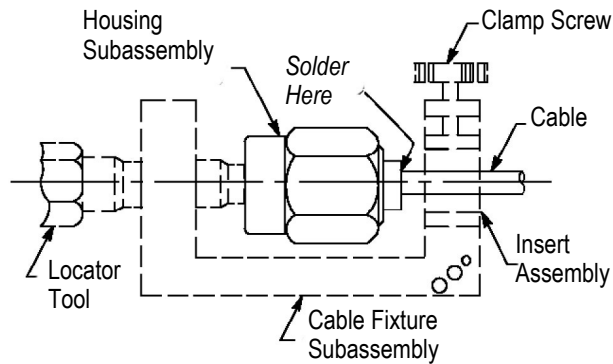


Figure 4

11. Thread the housing subassembly onto the dielectric insert tool.
12. Insert the dielectric into the housing of the dielectric insert tool. Place the plunger of the tool into position, and press it until the flange bottoms on the tool housing. See Figure 5.

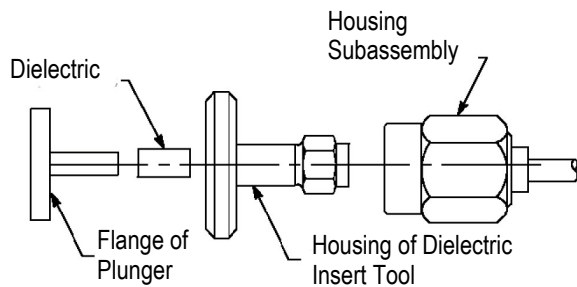


Figure 5

13. Adherence to the assembly procedure should yield the tolerances shown in Figure 6.

4. REPLACEMENT AND REPAIR

DO NOT re-use a soldered center contact or housing subassembly by removing the cable.

Components of the plug are not repairable. Replace any defective or damaged components.

5. REVISION SUMMARY

Since the previous release, the TE logo has been applied.

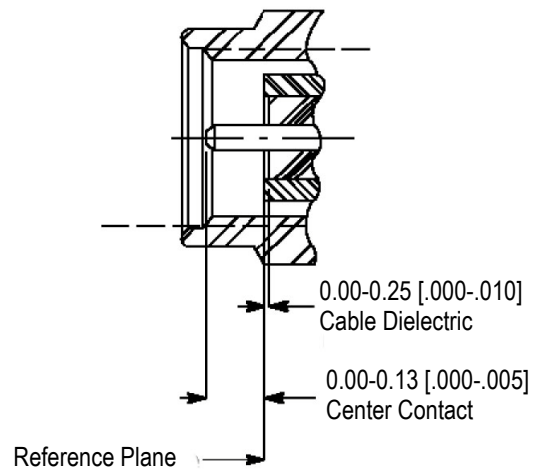


Figure 6