

Figure 1

## 1. INTRODUCTION

OSSM right-angle cable plug (crimp attachment) shown in Figure 1 is designed to be crimped to flexible cable sizes RG 136/U and 174/U using the following tools:

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Locator Tool	1055461-1	2098-5236-02 (T-1888)
"D" Crimp Frame	1055780-1	2598-5006-54
Hex Die Set (Die Closure C)	1055781-1	2598-5007-54

### 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 the components shown in Figure 1. The housing assembly contains a contact.

## 3. ASSEMBLY PROCEDURE

### DANGER



Follow safety precautions included with the tools used for assembly.

- Slide the shrink tubing, then the outer sleeve onto the cable.
- Strip the cable to the dimensions shown in Figure 2. Flare the cable braid.

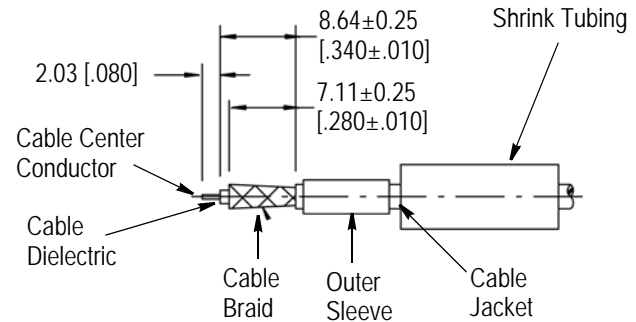


Figure 2

3. Secure the housing assembly to the locator tool as shown in Figure 3. Secure the housing assembly in a small bench vise.

4. Tin the cable center conductor.

5. Insert the center conductor into the housing assembly, making sure that the center conductor sits in the contact slot and the cable dielectric is flush. See Figure 3, View A.

6. Holding the cable in position, place the soldering iron on the tip of the contact, and solder.

7. Slide the outer sleeve over the cable braid. Crimp the outer sleeve. Trim excess braid strands. Refer to Figure 3.

8. Press the disc into the opening at the back of the housing assembly. Epoxy the disc into place. DO NOT allow the epoxy to penetrate the housing assembly. Refer to Figure 4.

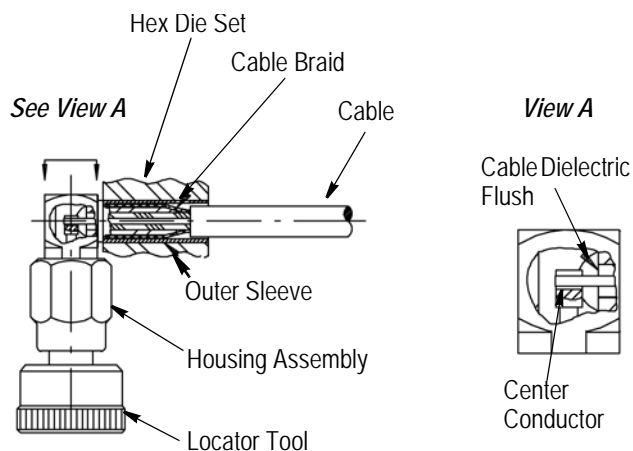


Figure 3

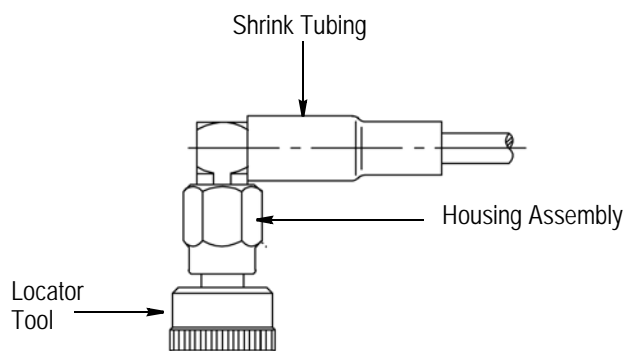


Figure 5

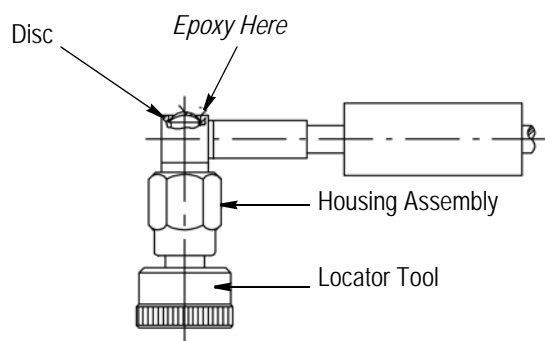


Figure 4

9. Slide the shrink tubing over the outer sleeve until it is against the housing assembly. Using a thermo gun, apply indirect heat to secure the shrink tubing. See Figure 5. Remove the assembly from the locator tool.

#### 4. REPLACEMENT AND REPAIR

DO NOT re-use any crimped components by removing the cable. DO NOT re-use the disc or shrink tubing after it has been assembled to the plug.

Components of the plug are not repairable. DO NOT use any defective or damaged components.

#### 5. REVISION SUMMARY

Since the previous release of this instruction sheet, the company logo has been updated.