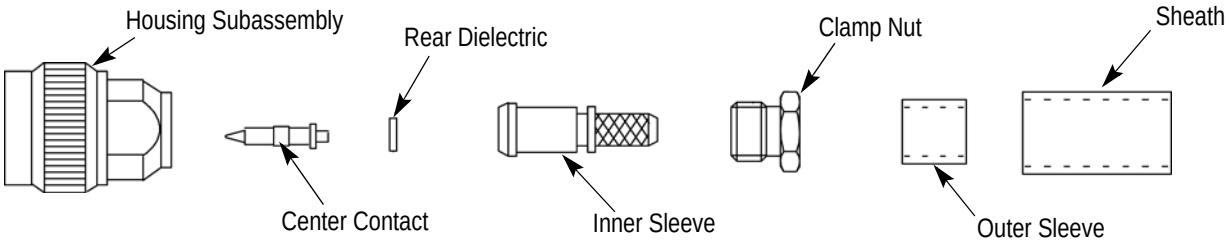

Figure 1

1. INTRODUCTION (Figure 1)

This instruction sheet contains the assembly procedures for Type N Straight Cable Plug Crimp Attachment 1057243-1, which is applied onto cable types RG55/U, 142, 223, or 400.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the M/A-COM part number to the TE Connectivity part number.

NOTE

Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

The cable plug crimp attachment consists of a housing subassembly, center contact, rear dielectric, inner sleeve, clamp nut, outer sleeve, and sheath.

3. ASSEMBLY PROCEDURES

3.1. Preparing Coaxial Cable End (Figure 3)

1. Place sheath and sleeve on cable.
2. Remove end portion of cable jacket to expose braid.
3. Trim braid, dielectric, and conductor to length shown in Figure 3.
4. Flare the braid.

3.2. Crimping Cable to Inner Sleeve (Figure 4)

1. Tin conductor of cable.
2. Assemble inner sleeve into clamp nut. Position and secure inner sleeve in a small bench vise.
3. Insert dielectric into inner sleeve and seat firmly.
4. Slide outer sleeve over flared portion of braid.

TOOL DESCRIPTION	TE PART NUMBER	M/A-COM PART NUMBER
Crimp Tool	1055236-1	2098-0105-54 Die No. B
Center Contact Holder	1055472-1	2098-5277-10 (T-4581)

Figure 2

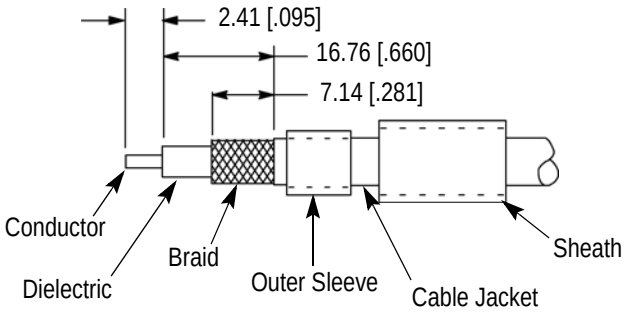

Figure 3

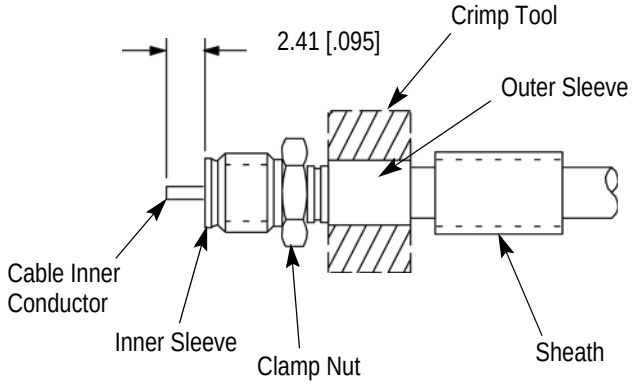

Figure 4

5. Hold cable firmly seated and crimp outer sleeve in place using the crimp tool, Die No. B.

6. Trim and remove excess braid.

7. If necessary, trim dielectric flush to face of inner sleeve.

3.3. Soldering of Center Contact to Conductor (Figure 5)

1. Assemble rear dielectric onto conductor of cable and seat against inner sleeve.

2. Place center contact in the center contact holder. Heat center contact, and push it over inner conductor of cable with the large diameter of contact resting firmly against rear dielectric.

3. Remove excess solder.

3.4. Securing Housing to Inner Sleeve Subassembly and Shrink Sheath (Figure 6)

1. Carefully insert the center contact into the dielectric bushing I.D. of the housing subassembly.

2. Engage threads of retaining nut to housing and torque to 2.83 - 3.39 N•m [25 - 30 in-lb].

3. Position sheath over outer sleeve as shown in Figure 6.

4. Apply indirect heat with thermo gun to shrink sheath.

3.5. Inspecting Completed Connector Assembly

Following the assembly procedures in this instruction sheet should yield tolerances shown in Figure 7.

4. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.

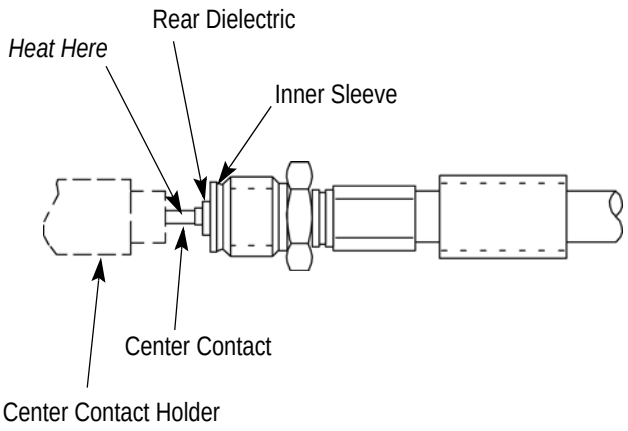

Figure 5

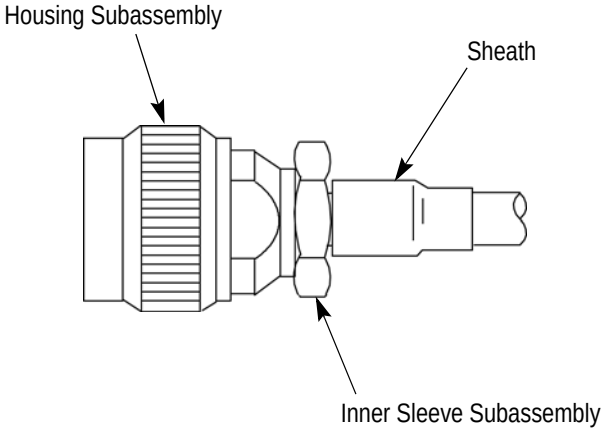

Figure 6

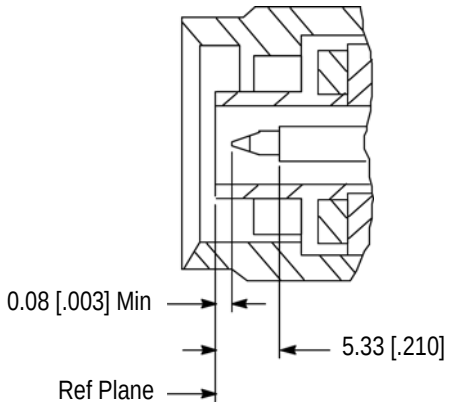

Figure 7