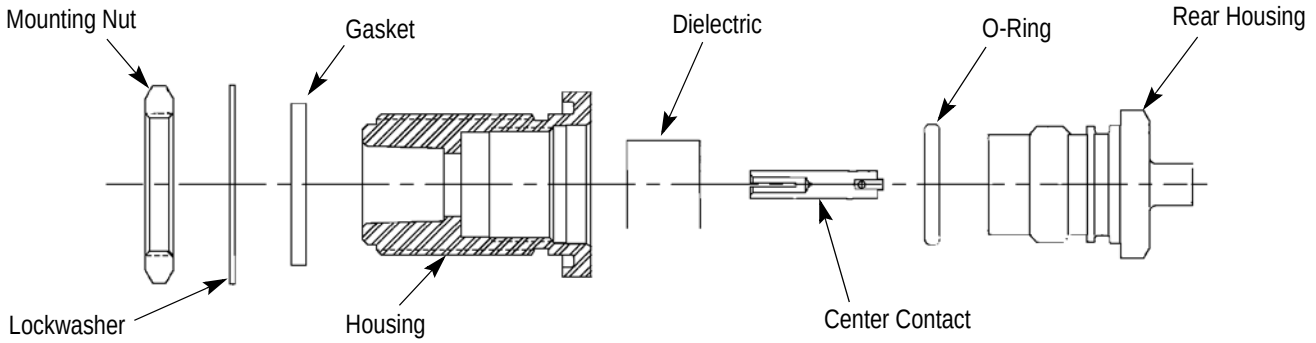

TE CONNECTIVITY PART NUMBER	PREVIOUS PART NUMBER	DESCRIPTION	CABLE TYPE
1057160-1	3004-7941-01	Type N Bulkhead Feedthrough Cable Jack	- .141 Semi-Rigid Coaxial Cable - .141 Semi-Rigid Microporous Cable
1057159-1	3004-7941-00		

Figure 1

1. INTRODUCTION

These instructions cover the application of the Type N Bulkhead Feedthrough Cable Jack Connectors listed in the table in Figure 1. These connectors are used in direct solder attachment type applications.

NOTE

Dimensions in these instructions are in metric units [with U.S. customary units in brackets], unless otherwise indicated. Figures are for identification only and are not drawn to scale.

The table in Figure 2 indicates the tooling required for the application of these connectors. The TE part numbers are listed, along with the previous part numbers, and the tooling description.

TE PART NUMBER	PREVIOUS PART NUMBER	DESCRIPTION
1055439-1	2098-5206-54 (T-4567)	Cable Fixture Subassembly
1055440-1	2098-5207-54 (T-4700-1	Clamp Insert Assembly
1055472-1	2098-5277-10 (T-4561)	Center Contact Holder
91362-1	- -	Solder Gage
1055471-1	2098-5276-02 (T-4572)	Locator Tool

Figure 2

Reasons for revision can be found in Section 3, REVISION SUMMARY.

2. ASSEMBLY

2.1. Cable Preparation (See Figure 3)

1. Insert the squared end of the cable into the fixture base hole pattern #2.

2. Place the saw in the saw slot and cut through the outer conductor and into the dielectric while rotating the cable.

DANGER

To avoid personal injury, always use caution and follow all local practices when using a cutting blade.

3. Remove the cable from the fixture and finish cutting the cable with a cutting blade.

4. Bare the inner conductor by prying the outer conductor and dielectric from the cable.

2.2. Soldering the Center Contact to the Cable Inner Conductor (See Figure 4)

DANGER

To avoid personal injury, always use caution and follow all local practices when using soldering equipment.

1. Tin the inner conductor of the cable.

2. Place the solder gage on the inner conductor flush with end of the outer conductor.

3. Place the center contact in the holder, heat the center contact and push it over the inner conductor of the cable to rest firmly against the solder gage.

4. Remove solder gage and excess solder.

NOTE

DO NOT use flux or solvent in the cable dielectric area of micro-porous cable.

2.3. Soldering Cable Sub-Assembly to Rear Housing

1. Place the rear housing on the end of the cable sub-assembly.

2. Place loose assembly in fixture base as shown in Figure 5

   a. Nest the center contact in the locator tool.

   b. Tighten the clamp screw to secure the cable.

   c. Tighten the locator tool to seat the cable firmly.

3. Slide the rear housing over the locator tool.

4. Maintain the position of the rear housing firmly against the locator tool.

5. Solder.

NOTE

Keep the fixture clamped vertically in a vice to keep the rear housing seated against the locator tool.

2.4. Assembling the Connector

1. Insert the dielectric bushing (counterbore toward the front) over the center contact into the housing.

2. Assemble the O-ring onto the rear housing as shown in Figure 6.

3. Secure the housing to the threads of the rear housing sub-assembly.

4. Tighten to a torque of 2.82 to 3.39 N•m [25 to 30 in-lb].

5. These procedures should yield the tolerances in Figure 7.

3. REVISION SUMMARY

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

- Corrected wording of heading in Paragraph 2.2.
- Updated document to corporate requirements.

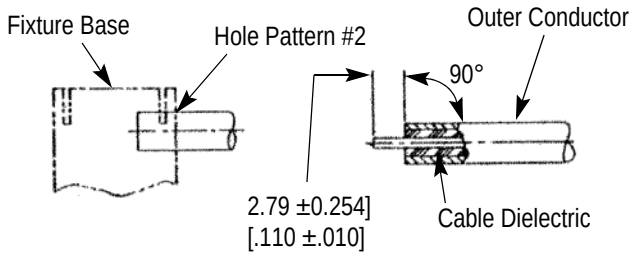

Figure 3

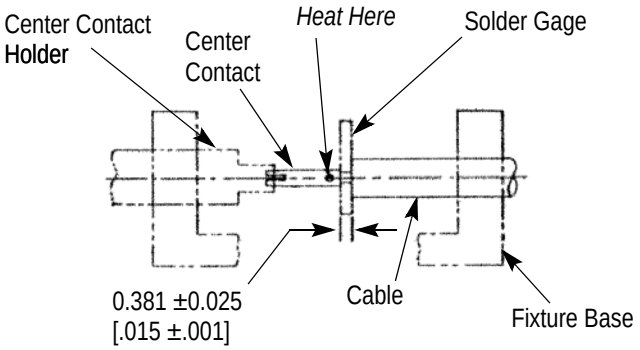

Figure 4

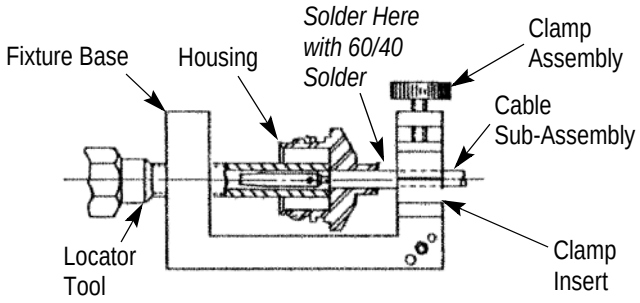

Figure 5

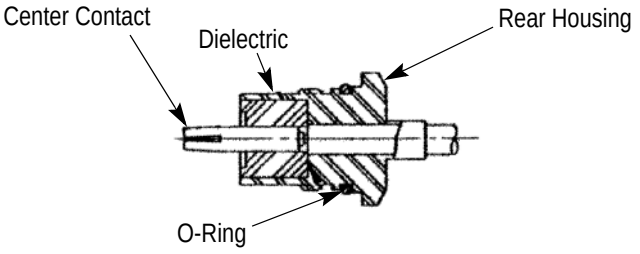

Figure 6

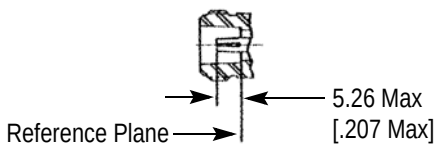

Figure 7