

OSM Right Angle Cable Plugs (Direct Solder Attachment) 1051114-1 and 1051113-1

Detail A

Detail B

Locato

Locator

Locator

4. REVISION SUMMARY

requirements

Tool

Tool

Detail D

Tool

Detail C

Cable Inner

Conductor

1.143-1.397 mm

[.045-.055 in.]

1.397 mm [.055 in.]

Note: Not to Scale

Cable



Cable Outer

Conductor

**Cable Dielectric** 

Cable Inner Conductor

Solder Here

Flush with

Cable Dielectric

Center Contact

Solder Here

Housing

Cap

Sub-Assembly

577 **\* 177 \* 177** \* 27, 41, - 111

90<sup>°</sup>



Sub-Assembly

Housing

TOOL DESCRIPTION	PART NUMBER	
	TYCO ELECTRONICS	PREVIOUS
Locator Tool	1055451-1	2098-5218-02 (T-2367)

Figure 1

## **1. INTRODUCTION**

OSM Right Angle Cable Plugs (direct solder attachment)1051114-1 and 1051113-1 are designed to be soldered onto .085-in. semi-rigid coaxial cable using the tool listed in Figure 1.

## 2. DESCRIPTION

Each cable plug consists of a housing sub-assembly and cap.

## 3. ASSEMBLY PROCEDURE

1. Trim the cable to the dimensions given in Figure 2, Detail A.

2. Secure the locator tool to the threads of the housing sub-assembly. Refer to Figure 2, Detail B. then, position and secure the housing sub-assembly in a small bench vise.

3. Insert the cable inner conductor into the housing sub-assembly so that it is located in the center contact slot. Hold the cable dieletric flush with the center contact. Refer to Figure 2, Detail B.

4. Tin the inner conductor of the cable using 60/40 solder.

5. Place a pre-heated soldering iron on top of the contact of the housing sub-assembly, then solder.

6. Solder the housing sub-assembly to the cable. Refer to Figure 2, Detail C.

7. Press the cap into the opening at the rear of the housing sub-assembly. Refer to Figure 2, Detail D.

8. Remove the locator tool from the housing sub-assembly; then either:

— tin the perimeter of the opening, and press the cap into position and apply heat the cap (do not allow the solder to penetrate the housing); or

TOOLING ASSISTANCE CENTER 1-800-722-1111 PRODUCT INFORMATION 1-800-522-6752



Figure 2

use epoxy to hold the cap into place (do not

allow the epoxy to penetrate the housing)

· Updated instruction sheet to corporate

Added cross-reference tool to Figure 1

Revisions to this instruction sheet include:

**1** of 1

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