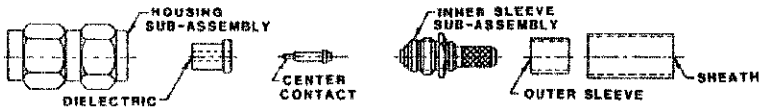
AMP

OSM Straight Cable Plug
Crimp Attachment 1066344–1

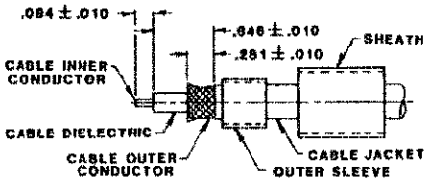
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE PLUG CRIMP ATTACHMENT	RAYCHEM 9530G1018	CENTER CONTACT HOLDER:2098-5221-0(T-4578) CRIMP TOOL:2098-0105-54 DIE NO.C

CONNECTOR

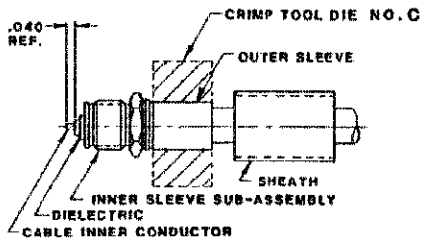


ASSEMBLY OPERATIONS

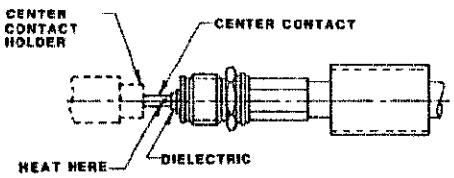
1.0 PREPARE COAXIAL CABLE END.
- 1.1 PLACE SHEATH AND SLEEVE ON CABLE.
- 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
- 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
- 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
- 1.5 TRIM INNER CONDUCTOR TO LENGTH.
- 1.6 FLARE OUTER CONDUCTOR.



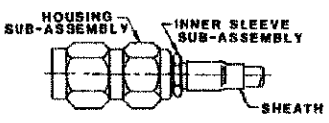
2.0 CRIMP CABLE TO INNER SLEEVE SUB-ASSEMBLY.
- 2.1 TIN INNER CONDUCTOR.
- 2.2 POSITION AND SECURE INNER SLEEVE SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 2.3 INSERT CABLE INTO INNER SLEEVE SUB-ASSEMBLY AND SEAT FIRMLY.
- 2.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 2.5 HOLD CABLE FIRMLY SEATED AND CRIMP OUTER SLEEVE IN PLACE.
- 2.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



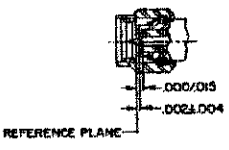
3.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.
- 3.1 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST REAR DIELECTRIC.
- 3.2 REMOVE EXCESS SOLDER.



4.0 SECURE HOUSING TO INNER SLEEVE SUB-ASSEMBLY AND SHRINK SHEATH
- 4.1 ASSEMBLE DIELECTRIC OVER CENTER CONTACT.
- 4.2 ENGAGE THREADS OF INNER SLEEVE SUB-ASSEMBLY TO HOUSING AND TORQUE TO 25-30 IN. LBS.
- 4.3 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
- 4.4 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.



5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY
- 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.



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