

Previous Part No. 1007-5015-92

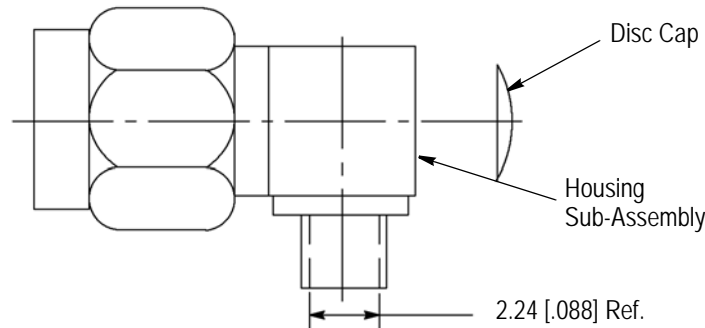


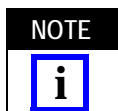
Figure 1

1. INTRODUCTION

SSMA Right-Angle Cable Plug (Direct Solder Attachment) 1045418-1 is designed to be crimped onto RG 405/U 2.16 [.085] diameter semi-rigid coaxial cable using the tools shown in Figure 2.

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	TE PART NUMBER	PREVIOUS PART NUMBER
Locator Tool	1055461-1	2098-5236-02
Fixture Base	1055439-1	2098-5206-54

Figure 2



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

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

2. DESCRIPTION

The plug connector consists of a coupling nut, housing assembly, and a disc cap. See Figure 1.

3. ASSEMBLY PROCEDURE

3.1. Preparation of Cable



Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into the fixture base hole pattern No. 2. as shown in Figure 3.

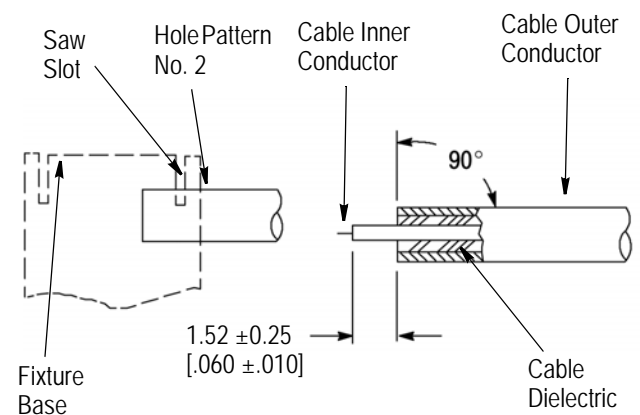


Figure 3

2. Place saw in saw slot and cut through outer conductor and into dielectric while rotating cable.
3. Remove cable from fixture and finish cutting dielectric with cutting blade.
4. Bare inner conductor by prying cut outer conductor and dielectric from cable.
5. Complete trimming of cable inner conductor to dimension shown Figure 3.

3.2. Soldering of Center Contact to Inner Conductor

1. Secure locator tool to threads of coupling nut as shown in Figure 4.
2. Tin inner conductor of cable.
3. Position cable inner conductor in center contact slot and outer conductor flush with housing inside diameter.

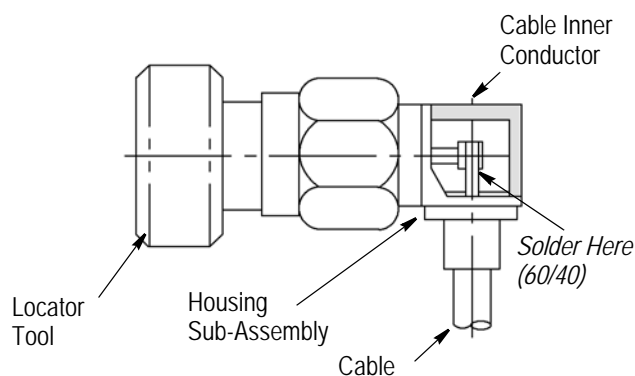


Figure 4

4. Place pre-heated soldering iron on tip of contact and solder as shown in Figure 4.

3.3. Soldering of Housing Sub-Assembly to Cable

Solder housing sub-assembly to cable as shown in Figure 5.

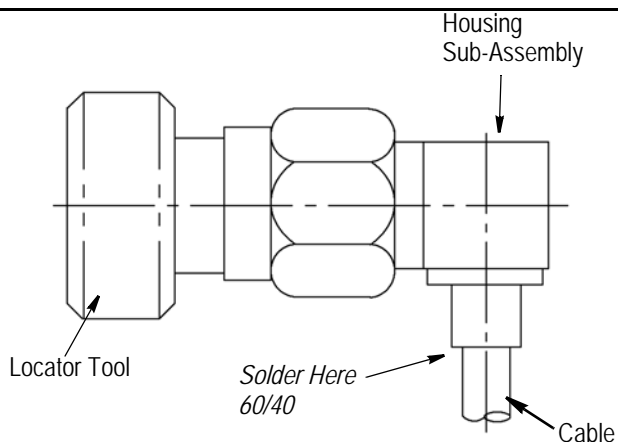


Figure 5

3.4. Seal Opening in Housing

1. Press disc cap into opening in rear of housing sub-assembly as shown in Figure 6.

2. Remove locator tool.

3. Two options of sealing the disc cap are:

a. Tin perimeter of opening and press disc cap into position. Apply heat to disc cap. Do not allow solder to penetrate housing.

b. Disc cap may be epoxied into place. Do not allow epoxy to penetrate inside housing.

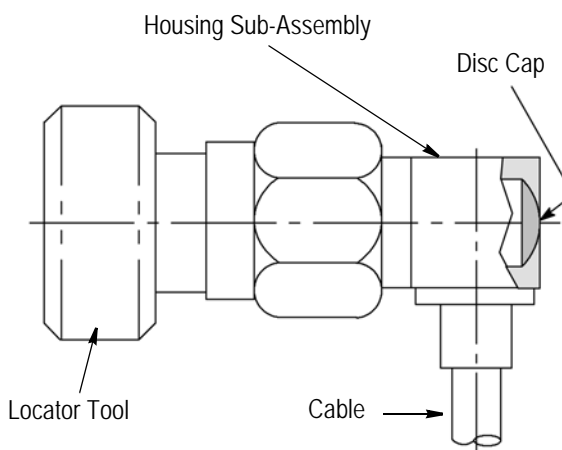


Figure 6

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo