



OSMM Straight Cable Plug  
Direct Solder Attachment  
1058955-1

Instruction Sheet

**408-8254**

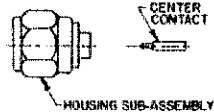
(was A.P. 40-007)

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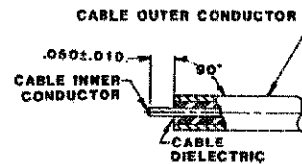
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSMM STRAIGHT CABLE PLUG DIRECT SOLDER ATTACHMENT	.047 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE:2098-5206-64(T-4567) CLAMP INSERT:2098-5797-64(T-4700-6) CENTER CONTACT HOLDER:4098-5012-10 SOLDER GAGE:4098-5013-02 (T-4562-10) LOCATOR TOOL:4098-5014-02

**CONNECTOR**

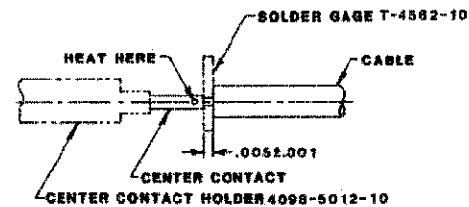


**ASSEMBLY OPERATIONS**

- 1.0 PREPARATION OF CABLE  
1.1 TRIM CABLE TO DIMENSIONS SHOWN.

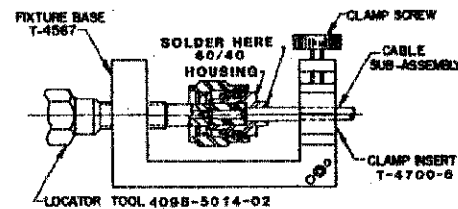


- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.  
2.1 TIN INNER CONDUCTOR OF CABLE.  
2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.  
2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.  
2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER.



- 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO HOUSING.  
3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.  
3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.  
3.2.1 TIGHTEN CLAMP SCREW TO SECURE CABLE.  
3.2.2 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY AGAINST HOUSING.  
3.3 SOLDER CABLE TO HOUSING SUB-ASSEMBLY AS SHOWN.

NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.



- 4.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY  
4.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

