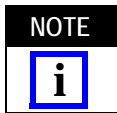


TE CONNECTIVITY PART NUMBER	PREVIOUS PART NUMBER	CABLE TYPE
1059402-1	4503-7941-00	RG402/U Semi-Rigid Coaxial Cable

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for OSP Bulkhead Feedthrough Cable Plug Connector 1059402-1. Refer to Figure 1. This connector is a rear mount, direct solder attachment type connector that attaches to the cable listed in Figure 1. Figure 1 also contains the previous part number of this OSP Bulkhead Feedthrough Cable Plug.



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

The table in Figure 2 references the special tools required to apply these connectors. The table includes tool descriptions, TE part numbers, and the corresponding previous part number.

APPLICATION TOOLING		
Tool Description	TE Part Number	Previous Part Number
Fixture Base	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055440-1	2098-5207-54 (T-4700-01)
Locator Tool	1059770-1	4598-5005-02

Figure 2

Reasons for reissue are provided in Section 3, REVISION SUMMARY.

## 2. ASSEMBLY PROCEDURES

### 2.1. Preparing Cable (Figure 3)

1. Insert the squared semi-rigid coaxial cable end into the fixture base designated in Figure 2. Be sure the cable end is inserted into the hole marked "Hole Pattern No. 2."
2. Place saw in the saw slot and cut through the outer conductor and into the dielectric while rotating the cable.
3. Remove the cable from the fixture base and finish cutting the dielectric with a cutting knife.



*To avoid personal injury, be sure to use personal protection, including gloves, when handling a knife.*

4. Bare the inner conductor by prying the cut outer conductor and dielectric from the cable.
5. Trim the cable inner conductor to the dimension shown in Figure 3.

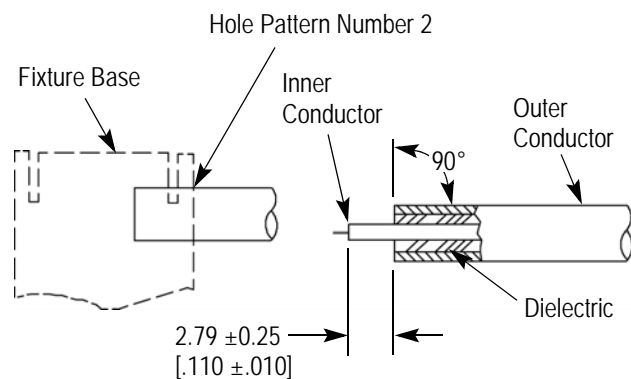


Figure 3

## 2.2. Shaping the Inner Conductor

1. Trim the inner conductor to the length shown in Figure 4.
2. File the blunt end of the inner conductor to an 85° to 90° cone.

## 2.3. Soldering the Cable to the Connector Subassembly

1. Assemble the cable in the housing subassembly. Carefully insert the (cable) inner conductor into the pre-assembled center contact of the housing subassembly.
2. Place the loose assembly in the fixture base as shown in Figure 5.
3. Tighten the clamp screw to secure the cable.
4. Tighten the locator tool to seat the housing subassembly firmly.
5. Maintain the position of the housing subassembly firmly against the locator tool and solder (with 60/40 solder) where indicated in Figure 5.



*The fixture base should be clamped in a vice in a vertical position to keep the housing subassembly seated against the locator tool.*

## 3. REVISION SUMMARY

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

- Updated document to corporate requirements.

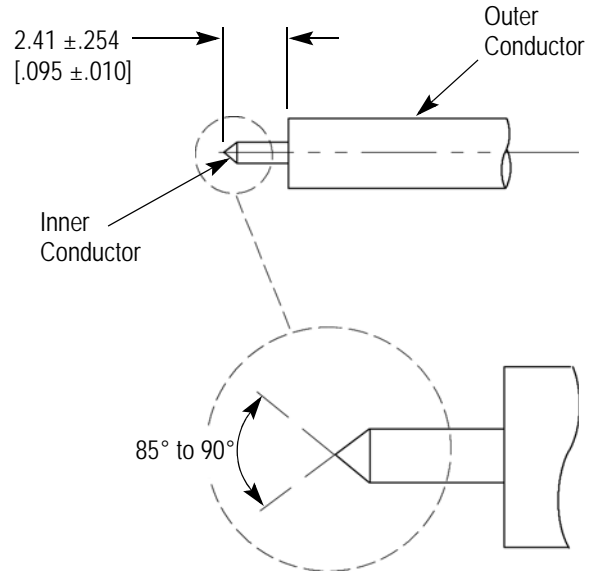


Figure 4

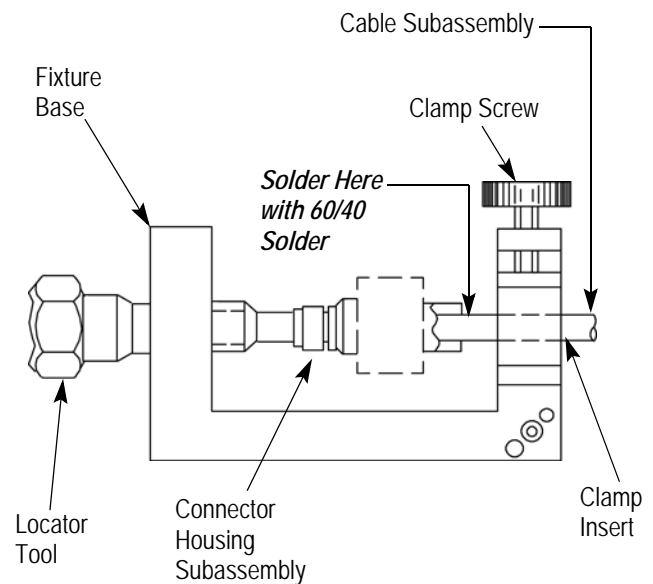


Figure 5