

Connector Assembly

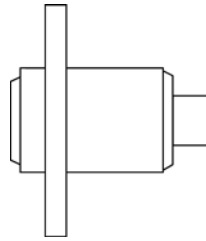


Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for OSP Flange Mount Cable Jack Floating Rear-Mount Direct Solder Attachment Connector 1059453-1. See Figure 1. This connector is applied to RG402/U .141 inch semi-rigid coaxial cable.

The table in Figure 2 references the special tools required to apply these connectors. The table includes tool descriptions, M/A-COM part numbers, and TE Connectivity part numbers.

APPLICATION TOOLING		
Tool Description	TE Part Number	M/A-COM Part Number
Fixture Base	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055440-1	2098-5207-54 (T-4700-01)
Locator Tool	1059769-1	4598-5004-02

Figure 2

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

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

2. ASSEMBLY PROCEDURES

2.1. Preparing Cable (Figure 3)

NOTE To prevent personal injury, be sure to follow all local safety practices when cutting the cable.

1. Insert the squared cable end into the fixture base, hole pattern number 2.
2. Place the saw in the saw slot. Cut through the outer conductor and into dielectric while rotating the cable.
3. Remove the cable from fixture base and finish cutting dielectric with cutting blade.
4. Bare the inner conductor by prying the cut outer conductor and dielectric from cable.
5. Trim the inner conductor to the dimension shown in Figure 3.
6. File the blunt end of the inner conductor to an 85° to 95° cone. Refer to Figure 4.

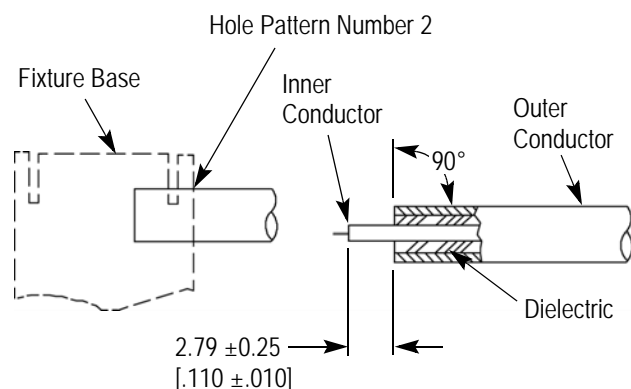


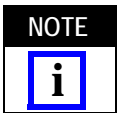
Figure 3

2.2. Soldering the Cable to the Connector Subassembly



To prevent personal injury, be sure to follow all local safety practices when soldering the connector subassembly to the cable.

1. Carefully insert the cable inner conductor into the pre-assembled center contact of the connector 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 connector subassembly firmly in the fixture base.
5. With the connector subassembly firmly against the locator tool, solder the cable to the connector subassembly. See Figure 5.



Use 60% tin / 40% lead solder.



It is recommended that the fixture base be clamped vertically in a vise, in order to keep the connector subassembly seated against the locator tool.

6. Remove the excess solder.

3. REVISION SUMMARY

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

- Updated document to corporate requirements.

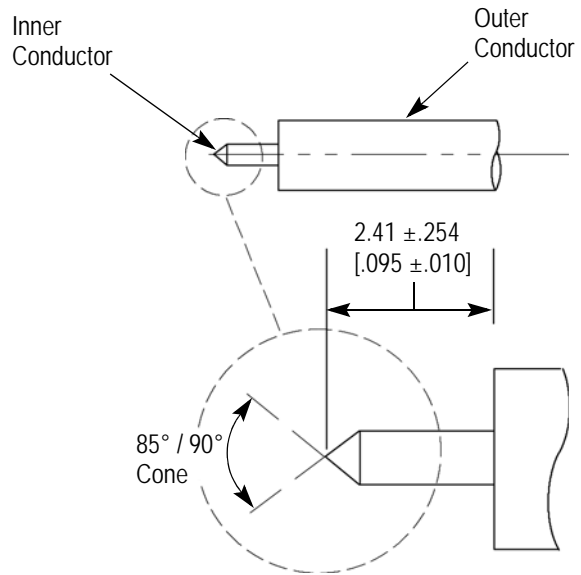


Figure 4

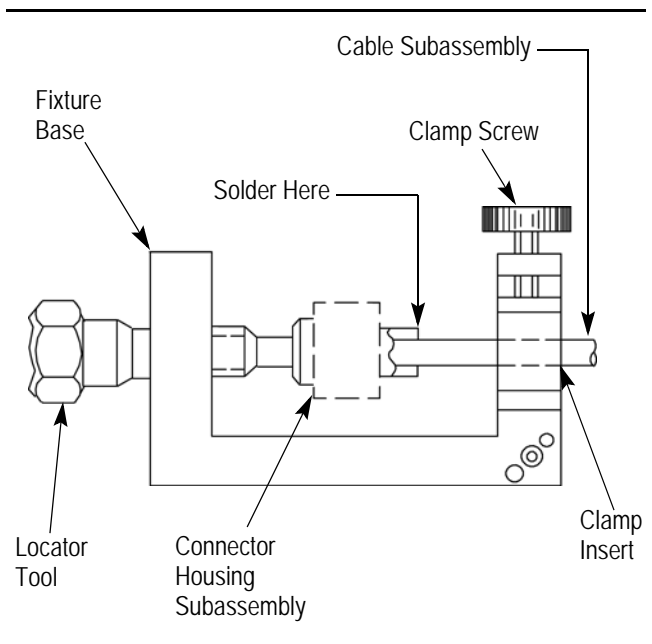


Figure 5