

Figure 1

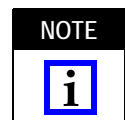
## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for the OSP Panel Feedthrough Cable Jack (Floating Direct Solder Attachments 1059505-1, which is applied to RG 402/U .141 semi-rigid coaxial cable. See Figure 1.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the previous part number to the TE Connectivity part number.

TOOL DESCRIPTION	TE PART NUMBER	PREVIOUS PART NUMBER
Fixture Base	1055439-1	2098-5206-54
Clamp Insert	1055441-1	2098-5208-54
Locator Tool	1059770-1	4598-5005-02

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. ASSEMBLY PROCEDURES

### 2.1. Preparing the Cable (Figure 3)

1. Insert squared cable end into fixture base hole pattern No. 2.
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.



*Follow all local safety practices when handling a knife.*

4. Bare inner conductor by prying the cut outer conductor and dielectric from cable.

5. Complete trimming of cable inner conductor to dimension shown in Figure 3.

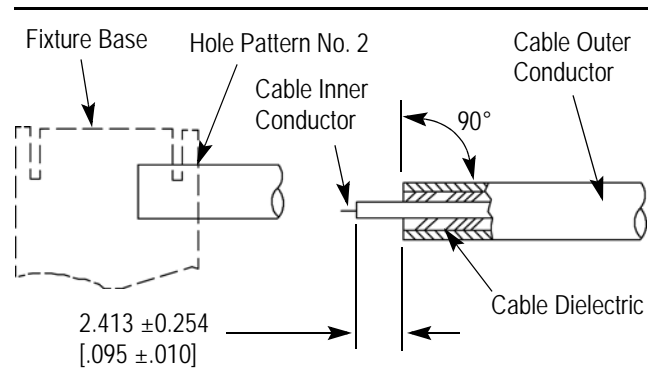


Figure 3

### 2.2. Shaping the Inner Conductor of the Cable (Figure 4)

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.

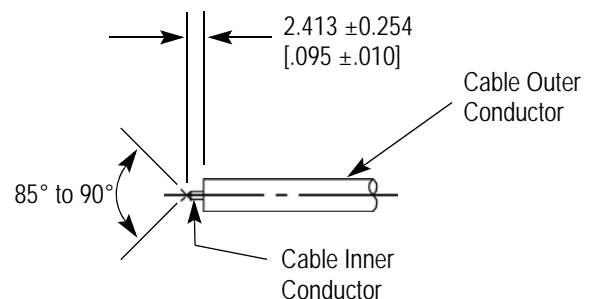


Figure 4

### 2.3. Soldering the Cable to the Housing Subassembly

1. Assemble the cable into the housing subassembly by carefully inserting 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.
  - a. Tighten the clamp screw to secure the cable.
  - b. Tighten the locator tool to seat the housing subassembly firmly.
3. Maintain the position of the housing subassembly firmly against the locator tool and solder (as shown in Figure 5).

### 3. REVISION SUMMARY

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

- Updated document to corporate requirements.

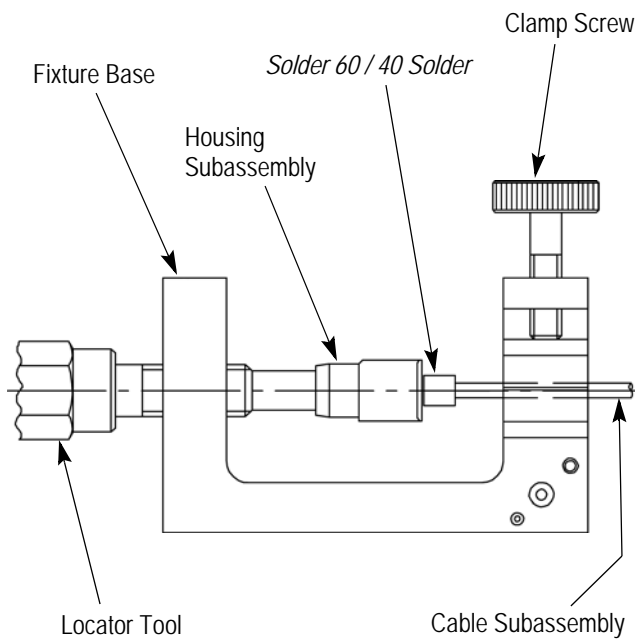


Figure 5