

OSM Straight Cable Plug Retractable Coupling Nut Direct Solder Attachment 1050537-1, 1050559-1, 1050560-1, 1045437-1, 1050422-1, 1050536-1, and 1050537-1

Instruction Sheet 408–4778 16 FEB 00 Rev O EC 0990-0174-00

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CONNECTOR TYPE

OSM STRAIGHT CABLE PLUG, RETRACTABLE COUPLING NUT DIRECT SOLDER ATTACHMENT

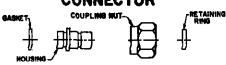
CABLE TYPE

.141 SEML-RIGID COAXIAL CABLE

TOOLS REQUIRED:

FIXTURE BASE:2096-5206-54 (T-4567) CLAMP MISERT:2098-5207-54 (T-4700-1) LOCATOR TOOL:2008-5209-02(T-4575) DIELECTRIC RECESS TOOL 2096-5217-54(T-4582) TRM TOOL(OPTIONAL):2098-5222-02(T-5899)

CONNECTOR



ASSEMBLY OPERATIONS

0 SOLDERING OF CABLE TO HOUSING
2.1 PLACE CONNECTOR HOUSING ON END OF CABLE
2.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.

2.2.1 NEST CABLE END IN LOCATOR TOOL,

2.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.

2.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE

1.0 TRIN CABLE END SQUARE AND DEBURR

2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
2.3 SLEDE HOUSING AGAINST LOCATOR TOOL.
2.4 MAINTAIN POSITION OF HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.
NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP HOUSING SEATED.
AGAINST LOCATOR TOOL.

3.0 COMPRESS EXPANDED DIELECTRIC
3.1 TRIM EXTENDED OR EXPOSED DIELECTRIC FLUSH
WITH END OF THE CABLE OUTER COMPUTED
3.2 PLACE DIELECTRIC RECESS TOOL ON DIELECTRIC AND PUSH TO RECESS DIELECTRIC WITHIN
CARLE OUTER CONTIN CABLE OUTER CONDUCTOR.

0 REMOVE OUTER CONDUCTOR AND BIELECTRIC
4.1 INSERT SQUARED CABLE END INTO FIXTURE BASE MOLE PATTERN #1
4.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
4.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.
4.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.

5.0 TRIM END OF HOUSING SUB-ASSEMBLY (OPTIONAL)
5.1 PLACE TRIM TOOL OVER IMMER CONDUCTOR
PROJECTION AND ROTATE TO FACE OFF FRONT FACE.
5.2 INSPECT FOR DIMENSIONAL TOLERANCE.
1994±1904.

6.0 SHAPE INNER CONDUCTOR
6.1 TRIM TO LENGTH AS SHOWN.

6.2 FILE BLUNT END OF INNER CONDUCTOR TO AN 75° - 90° CONE.

7.0 SECURE COUPLING NUT TO HOUSING
7.1 PLACE GASKET ON HOUSING.
7.2 SLIDE COUPLING NUT ONTO HOUSING.
7.3 SMAP RETAINING RING IN HOUSING GROOVE
JUST BEHIND COUPLING NUT.
7.4 COUPLING NUT SHOULD ROTATE FREELY,

CLAMP SCREW SOLDER HERE HOLISING P NSERT T-4700-1 LOCATOR TOOL T-4575

