

Connector Assembly

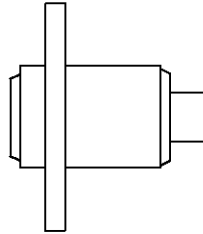


Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for AMP* 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 Tyco Electronics part numbers.

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.

APPLICATION TOOLING

| Tool Description | Tyco Electronics 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)

DANGER 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.

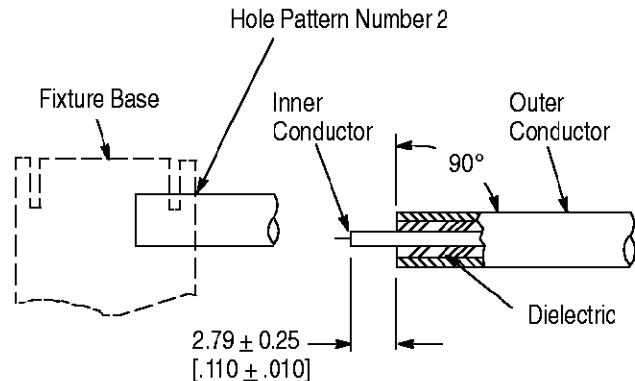


Figure 3

2.2. Soldering the Cable to the Connector Subassembly

DANGER 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.

NOTE Use 60% tin / 40% lead solder.

NOTE 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

Per EC 0990-1449-00, this document was updated to the current format. The document contains format and copy clarifications.

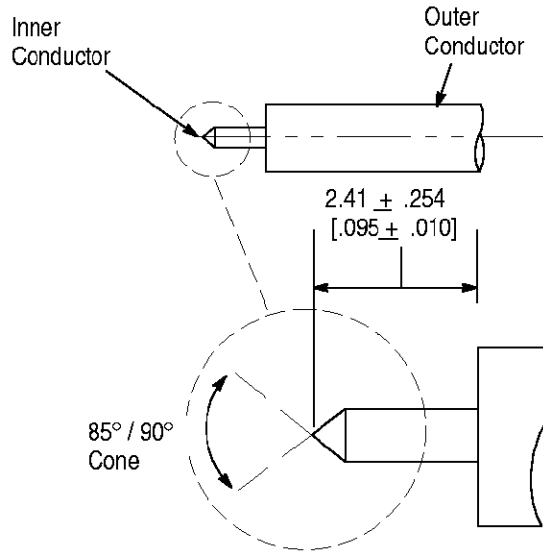


Figure 4

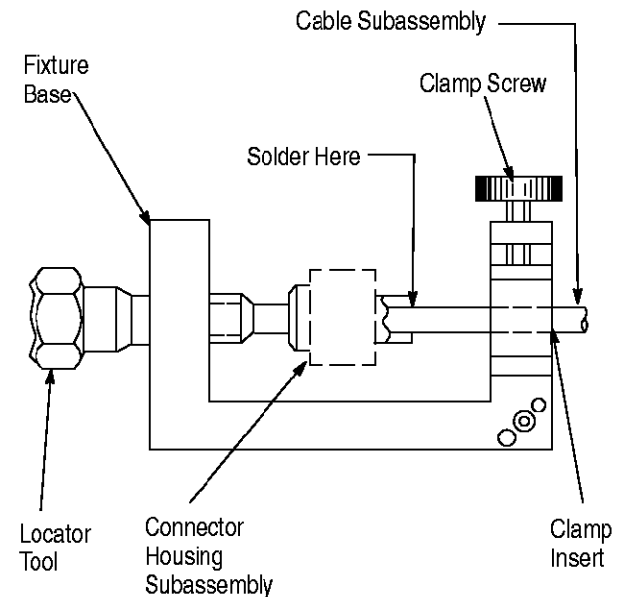


Figure 5