

TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	CABLE TYPE	CRIMP TOOL		CRIMP DIE	
			TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER
1058572-1	4536 5014 02	178/U Double Braid	1060713-1	5698 5014 (T-4718)	1055277-1	2098 0370 54 (.118 Hex)

Figure 1

## 1. INTRODUCTION

This instruction sheet covers the assembly procedures for the OSP Flange Mount Cable Jack Connector shown in Figure 1.

The table in Figure 1 also includes the cable type and crimp tooling required for this connector.

This connector is a floating rear mount, crimp-type attachment connector.

### NOTE

Dimensions in this instruction sheet are in U.S. customary units unless otherwise specified. Figures are not drawn to scale.

## 2. ASSEMBLY PROCEDURES

### 2.1. Preparing the Coaxial Cable

- Slide the heat-shrink tubing and outer sleeve (ferrule) on the cable.

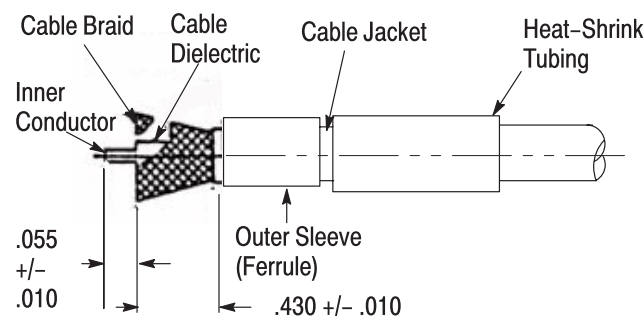


Figure 2

- Remove the end portion of the cable jacket (according to Figure 2) to expose the cable braid.
- Trim the cable braid to length.
- Trim the cable dielectric to length.
- Trim the inner conductor to length.
- Flare the cable braid.

### 2.2. Soldering the Center Contact to the Inner Conductor

- Tin the inner conductor.

### DANGER

To avoid personal injury, always follow all local and safety practices (including wearing gloves) when working with soldering equipment.

- Heat the center contact with a soldering iron and carefully push it over the inner conductor to rest firmly against the dielectric. See Figure 3.
- Remove excess solder or splatter.

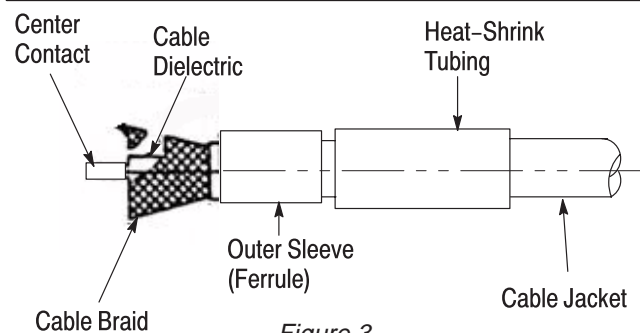


Figure 3

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

1. Be sure the center contact enters the pre-assembled housing contact.
2. Insert the cable into the housing subassembly and seat the cable firmly.
3. Slide the outer sleeve (ferrule) over the flared portion of the cable braid.
4. With the cable firmly seated, crimp the cable braid in place. See Figure 4.
5. Trim and remove excess cable braid strands.

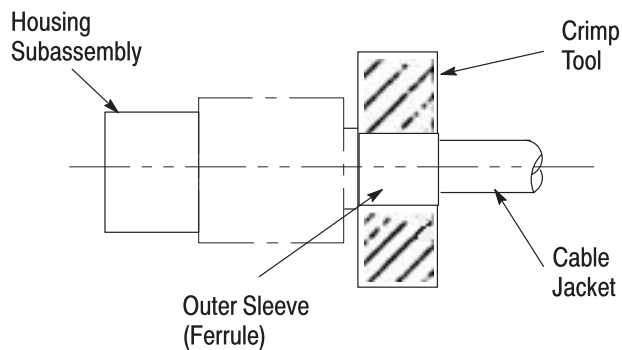


Figure 4

### 2.4. Applying the Heat-Shrink Tubing to the Cable

1. Position the heat-shrink tubing over the cable as shown in Figure 5.
2. Apply indirect heat with a heat gun to shrink the heat-shrink tubing.

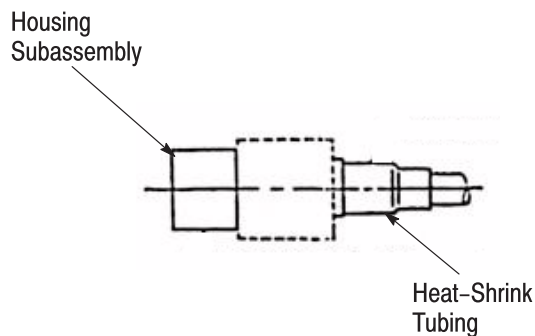


Figure 5

The assembly is now complete.

## 3. REVISION SUMMARY

Initial release of 408-8978