

OSP Floating Panel Feedthrough Cable Jack Connector

TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	CABLE TYPE
1059467-1	4510-7985-00	.085 Semi-Rigid Coaxial Cable
1274938-1	—	
1361379-1	4510-5021-00	
1363618-1	4510-5022-00	

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the OSP Floating Panel Feedthrough Cable Jack Connectors shown in Figure 1. These connectors are direct solder attachment type connectors that attach to the cable type listed in Figure 1. Figure 1 also contains the previous OSP jack connector part numbers.

NOTE

Dimensions on this sheet are in millimeters [with inches in brackets], unless otherwise specified. Figures are not drawn to scale.

Tool Description	Tyco Electronics Part Number	Previous Part Number
Fixture Base	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055441-1	2098-5208-54 (T-4700-2)
Locator Tool	1059769-1	4598-5004-02

Figure 2

The table in Figure 2 references the tools required to apply these connectors. The table includes tool descriptions, current Tyco Electronics part numbers, and the corresponding (previous) part numbers.

Reasons for re-issue can be found in Section 3, REVISION SUMMARY.

Read and understand these instructions thoroughly before proceeding.

2. ASSEMBLY PROCEDURES

2.1. Preparing the Coaxial Cable End (Figure 3)

1. Insert the squared semi-rigid cable end into the fixture base (hole pattern No. 2).
2. Place saw in saw slot of fixture base and cut through the outer conductor and into the cable dielectric while rotating the cable.

CAUTION

Do not nick the inner conductor of the cable.

3. Remove the cable from the fixture base and finish trimming the dielectric with a cutting blade.

DANGER

To avoid personal injury, be sure to follow all local safety precautions (including the use of gloves) when handling a cutting blade.

4. Bare the inner conductor by prying the cut outer conductor and dielectric from the cable.
5. Complete the trimming of the inner conductor to the dimensions shown in Figure 3.

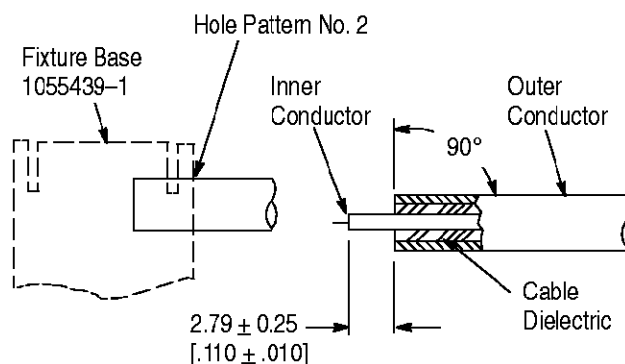


Figure 3

2.2. Shaping the Inner Conductor

File the square end of the inner conductor to an 85° to 90° cone. Refer to Figure 4.

2.3. Soldering the Connector to the Cable

1. Carefully insert the inner conductor of the cable into the pre-assembled center contact of the connector assembly.
2. Place the cable and connector (loosely) in the fixture base as shown in Figure 5.
3. Tighten the clamp screw to secure the cable.
4. Tighten Locator Tool 1059769-1 to seat the connector firmly in the tool.

DANGER

To avoid personal injury, be sure to follow all local safety practices when working with soldering equipment.

5. With the connector held firmly against the locator tool and the cable in the connector, solder the connector to cable (with 60/40 solder) as shown in Figure 5.

NOTE

The fixture base should be clamped in vise vertically to keep the connector seated against the locator tool.

3. REVISION SUMMARY

The following revisions were made per EC 0990-0111-02:

- Added connectors 1274938-1, 1361379-1, and 1363618-1
- Added Tyco Electronics part numbers to the tooling numbers previously listed
- Updated format to current corporate requirements

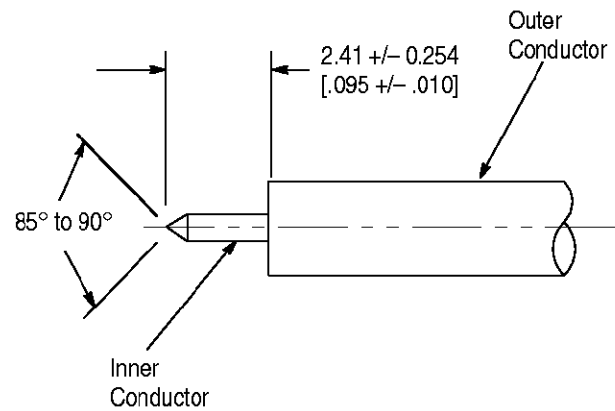


Figure 4

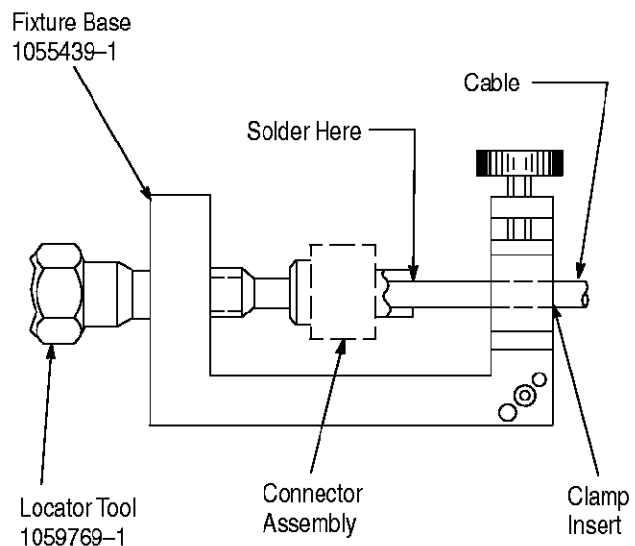


Figure 5