

Figure 1

**1. INTRODUCTION**

This instruction sheet contains the assembly procedures for the OSX Right-Angle Cable Plug Connector 1060888-1. Refer to Figure 1. These connectors are solder-center contact/crimp outer sleeve attachment type connectors that attach to RG 178/U, 196/U and OSMT cable.

The table in Figure 2 references the crimp tooling used to apply these connectors. The table includes crimp tooling descriptions, as well as the Tyco Electronics part number.

TOOL DESCRIPTION	PART NUMBER CROSS-REFERENCE	
	CURRENT (TE) PART NUMBER	PREVIOUS PART NUMBER
Economy Crimp Tool Kit	1055779-1	2598-5005-54 (Die No. A)

Figure 2



*Dimension on this sheet are in millimeters [with inches in brackets] unless otherwise specified.*

Reasons for revision can be found in Section 4, REVISION SUMMARY.

**2. DESCRIPTION**

The plug kit consists of the components shown in Figure 1. The housing assembly contains a contact.

**3. ASSEMBLY PROCEDURE**



*Follow safety precautions included with the tools (as well as local safety practices) used for assembly.*

**3.1. Preparation of Coaxial Cable End (Figure 3)**

1. Slide the outer sleeve on the cable.

2. Remove the end portion of the cable jacket to expose the cable braid.
3. Trim the cable braid to length.
4. Trim the cable dielectric to length.
5. Trim the inner conductor to length.
6. Flare the cable braid.

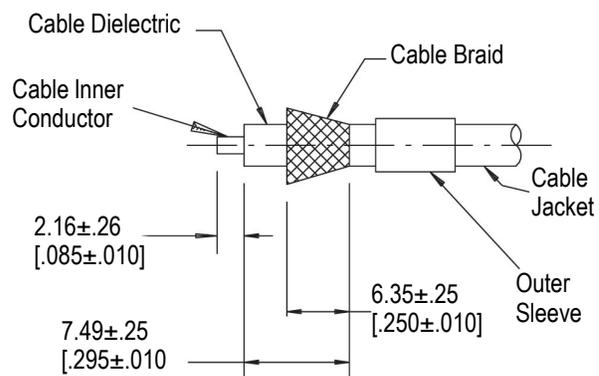


Figure 3

**3.2. Soldering of Cable Inner Conductor to Center Contact (Figure 4)**

1. Position and secure housing subassembly in a small bench vice.
2. Tin the inner conductor of the cable.
3. Insert the cable into the housing subassembly.
  - a. Nest the cable inner conductor in the center contact slot.
  - b. Hold the cable dielectric flush with the inner diameter of the housing.
4. Place soldering iron on the tip of the center contact and solder.

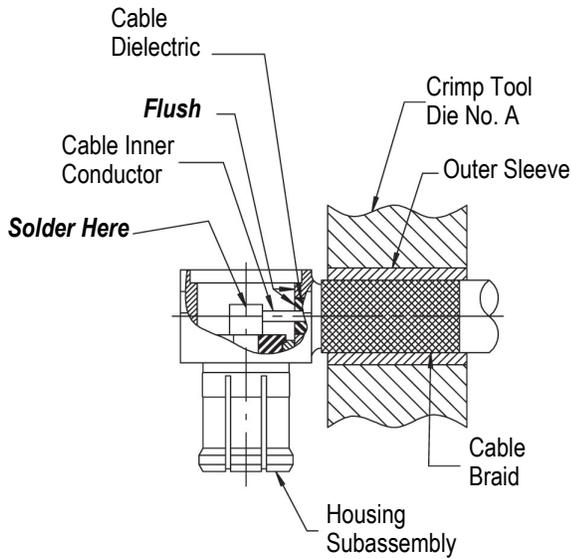


Figure 4



To avoid damage to the OSMT cable, minimize the time and temperature when soldering. And minimize the heat when applying heat-shrink tubing.

### 3.3. Crimping the Cable Subassembly to the Housing Subassembly (Figure 4)

1. Slide the outer sleeve over the flared portion of the cable braid.
2. Crimp the Outer sleeve in place (refer to Figure 4).
3. Trim and remove excess braid strands.

### 3.4. Sealing the Opening in the Housing (Figure 5)

1. Press the dielectric into the opening in the rear of the housing subassembly.

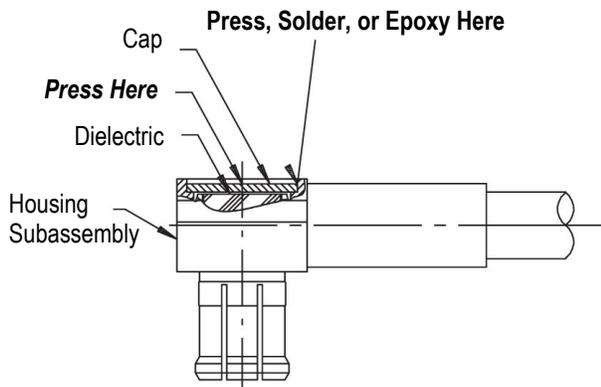


Figure 5

2. Place the cap into the opening in the rear of the housing subassembly and either press, solder, or epoxy the cap into place.

## 4. REVISION SUMMARY

Since the previous release, the TE logo has been applied.