

TOOL DESCRIPTION	PART NUMBER	
	TYCO ELECTRONICS	PREVIOUS
Locator Tool	1055451-1	2098-5218-02 (T-2367)

Figure 1

1. INTRODUCTION

OSM Right Angle Cable Plugs (direct solder attachment) 1051114-1 and 1051113-1 are designed to be soldered onto .085-in. semi-rigid coaxial cable using the tool listed in Figure 1.

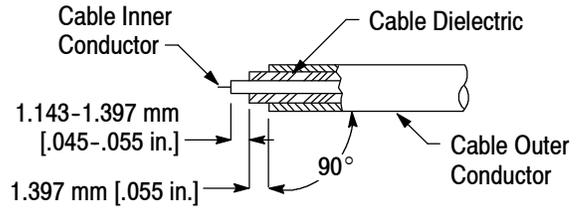
2. DESCRIPTION

Each cable plug consists of a housing sub-assembly and cap.

3. ASSEMBLY PROCEDURE

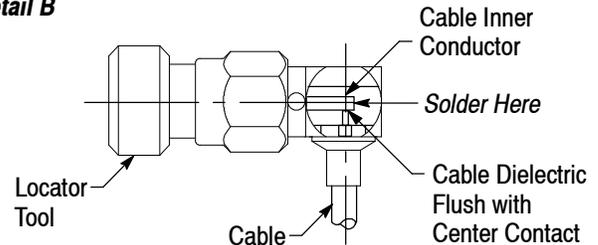
- Trim the cable to the dimensions given in Figure 2, Detail A.
- Secure the locator tool to the threads of the housing sub-assembly. Refer to Figure 2, Detail B. then, position and secure the housing sub-assembly in a small bench vise.
- Insert the cable inner conductor into the housing sub-assembly so that it is located in the center contact slot. Hold the cable dielectric flush with the center contact. Refer to Figure 2, Detail B.
- Tin the inner conductor of the cable using 60/40 solder.
- Place a pre-heated soldering iron on top of the contact of the housing sub-assembly, then solder.
- Solder the housing sub-assembly to the cable. Refer to Figure 2, Detail C.
- Press the cap into the opening at the rear of the housing sub-assembly. Refer to Figure 2, Detail D.
- Remove the locator tool from the housing sub-assembly; then either:
 - tin the perimeter of the opening, and press the cap into position and apply heat the cap (do not allow the solder to penetrate the housing); or

Detail A

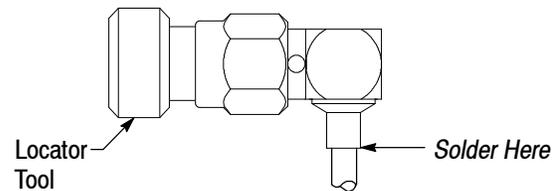


Note: Not to Scale

Detail B



Detail C



Detail D

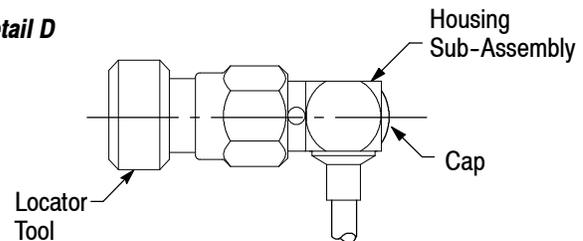


Figure 2

— use epoxy to hold the cap into place (do not allow the epoxy to penetrate the housing)

4. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Added cross-reference tool to Figure 1