



**OSMM Right Angle Cable Plug
Direct Solder Attachment
1058993-1**

Instruction Sheet

408-8252

(was A.P. 40-004)

02 MAR 00 Rev O

EC 0990-0250-00

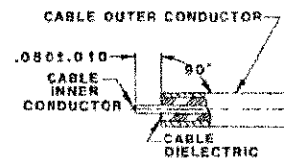
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSMM RIGHT ANGLE CABLE PLUG DIRECT SOLDER ATTACHMENT	.034 SEMI-RIGID COAXIAL CABLE .047 SEMI-RIGID COAXIAL CABLE	LOCATOR TOOL 4098-5015-02

CONNECTOR

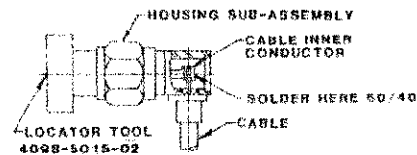


ASSEMBLY OPERATIONS

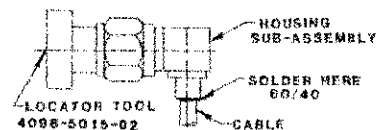
- 1.0 PREPARATION OF CABLE
1.1 TRIM CABLE TO DIMENSION SHOWN.



- 2.0 SOLDERING OF CABLE INNER CONDUCTOR TO HOUSING SUB-ASSEMBLY
2.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
2.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY, IN A SMALL BENCH VISE.
2.3 TIN INNER CONDUCTOR OF CABLE.
2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY.
2.4.1 NEST INNER CONDUCTOR IN CONTACT SLOT
2.4.2 HOLD DIELECTRIC FLUSH AS SHOWN.
2.5 PLACE SOLDERING IRON ON TIP OF CONTACT AND SOLDER.



- 3.0 SOLDERING OF HOUSING SUB-ASSEMBLY TO CABLE
3.1 SOLDER HOUSING SUB-ASSEMBLY TO CABLE AS SHOWN.



- 4.0 SEAL OPENING IN HOUSING
4.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY
4.2 REMOVE LOCATOR TOOL.
OPTION 1: TIN PERIMETER OF OPENING AND PRESS DISC INTO POSITION; APPLY HEAT TO CAP. DO NOT ALLOW SOLDER TO PENETRATE HOUSING.
OPTION 2: DISC MAY BE EPOXIED INTO PLACE, DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.

