

TE PART NO.	PREVIOUS PART NO.	CABLE TYPE
1059378-1	4503-5009-00	RG405/U .085 Semi-Rigid Coaxial Cable
1059404-1	4503-7985-00	

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for the OSP Bulkhead Feedthrough Rear Mount Cable Plugs shown in Figure 1. These connectors are rear mount, direct solder attachment type connectors that attach to the cable type listed in Figure 1. Also contained in Figure 1 are the "previous" OSP Bulkhead Feedthrough Cable Plug part numbers.

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

The table below references the tools required to apply these connectors. The table includes tool descriptions, current TE part numbers, and the corresponding (previous) part numbers.

TOOL DESCRIPTION	PART NO. CROSS-REFERENCE	
	TE NO.	PREVIOUS NO.
Fixture Base	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055441-1	2098-5208-54 (T-4700-2)
Locator Tool	1059770-1	4598-5005-2

Reasons for reissue can be found in Section 3, REVISION SUMMARY.

Read and understand these instructions thoroughly before proceeding.

## 2. ASSEMBLY PROCEDURES

### 2.1. Preparing the Cable (Figure 2)

1. Insert the squared cable end into the fixture base hole (pattern number two).
2. Place saw in the saw slot and cut through the outer conductor and into the cable dielectric while rotating the cable.
3. Remove the cable from the fixture and finish trimming the dielectric with a cutting knife.

**DANGER** Be sure to wear gloves and observe all local safety practices when handling a cutting knife.

4. Bare the cable inner conductor by prying the outer conductor and dielectric from the cable.

5. Trim the inner conductor to the dimensions shown in Figure 2.

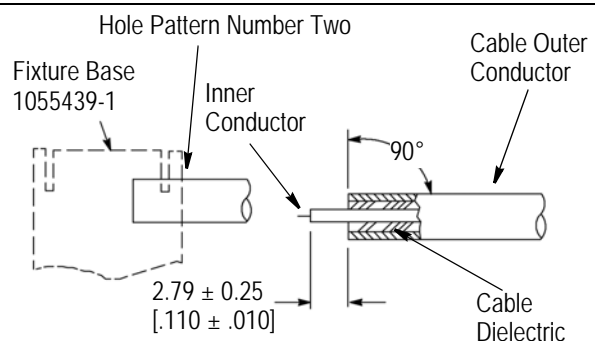


Figure 2

## 2.2. Shaping the Inner Conductor (Figure 3)

1. Trim the inner conductor to the length shown in Figure 3.

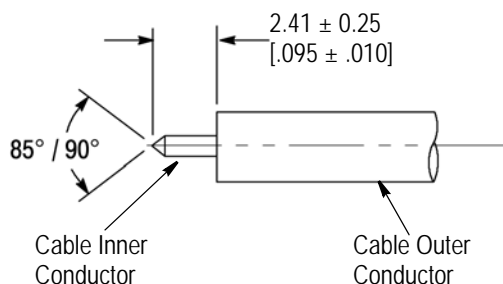


Figure 3

2. File the blunt end of the inner conductor to an 85° to 95° cone.

## 2.3. Soldering Cable to Housing Sub-Assembly

1. Carefully insert the cable inner conductor into the pre-assembled center contact of the housing sub-assembly.
2. Place the loose assembly in the fixture base as shown in Figure 4.

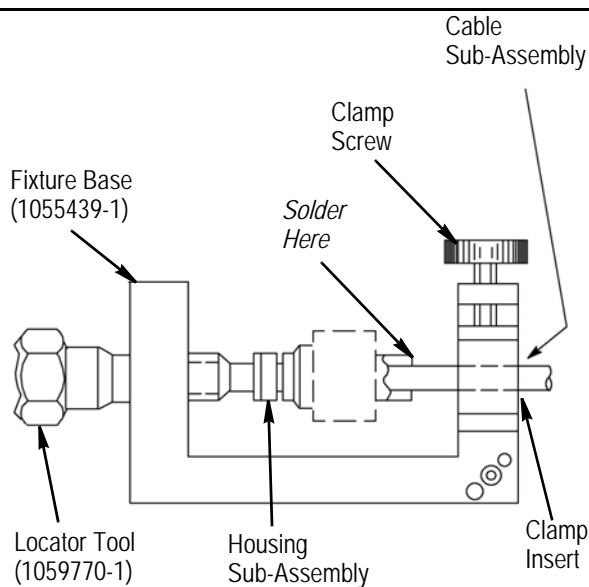
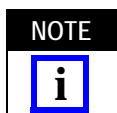


Figure 4

3. Tighten the clamp screw to secure the cable.
4. Tighten the locator tool to seat the housing sub-assembly firmly.
5. Maintain the position of the housing sub-assembly firmly against the locator tool.



*The fixture base should be clamped vertically in a vise to keep the housing sub-assembly seated against the locator tool.*

6. Solder the cable to the housing sub-assembly with 60/40 solder.

## 3. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo