

JACK PART NUMBER	
CURRENT	PREVIOUS
1056522-1	2902-5006-62

Figure 1

1. INTRODUCTION

OSMP Jack (Direct Solder Attachment) 1056522-1 shown in Figure 1 is designed to be soldered to semi-rigid coaxial cable size RG 405/U with a diameter of 2.16 mm [.085 in.] using the following tools. See Figure 2.

TOOL DESCRIPTION	TOOL PART NUMBER	
	CURRENT	PREVIOUS
Cable Fixture Subassembly	1055439-1	2098-5206-54 (T-4567)
Locator Tool (For Center Contact)	1055888-1	2598-5407-02
Insert Assembly	1055441-1	2098-5208-54 (T-4700-2)
Locator Tool (For Housing Subassembly)	1055887-1	2598-5406-02

Figure 2



Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.

2. DESCRIPTION

The jack consists of a housing subassembly and center contact. See Figure 1.

3. ASSEMBLY PROCEDURE



Follow safety precautions included with the tools used for assembly.

1. Insert the squared cable end into Hole Pattern 2 of the cable fixture subassembly. Refer to Figure 2.

2. Place a saw in the saw slot and while rotating the cable, cut through the cable jacket and into, but not through, the dielectric. Remove the cable from the cable fixture subassembly, and finish cutting the dielectric with a blade.

3. Pry the jacket and dielectric from the cable to expose the center conductor. Make sure that the center conductor meets the dimension shown in Figure 3.

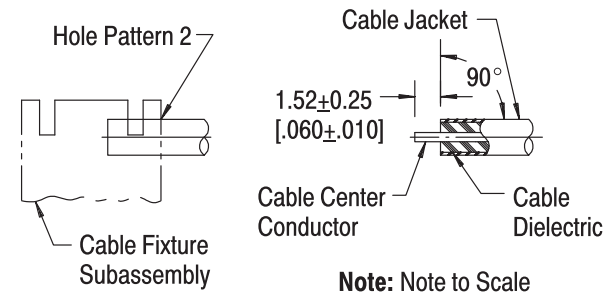


Figure 3

4. Tin the cable center conductor.

5. Place the cable in the cable fixture sub-assembly as shown in Figure 4.

6. Place the center contact in the locator tool (for center contact). Heat the center contact, and slide it onto the center conductor until it rests firmly against the cable dielectric. See Figure 4.

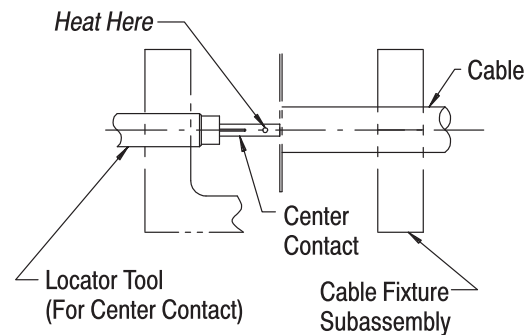


Figure 4

7. Remove excess solder.

8. Insert the center contact into the housing subassembly until it bottoms.

9. Place the assembly in the cable fixture subassembly as shown in Figure 5. Tighten the clamp screw to secure the cable, and tighten the locator tool to seat the housing subassembly firmly against the cable.

10. Using solder made of 60% tin and 40% lead, join the housing subassembly to the cable at the location shown in Figure 5.

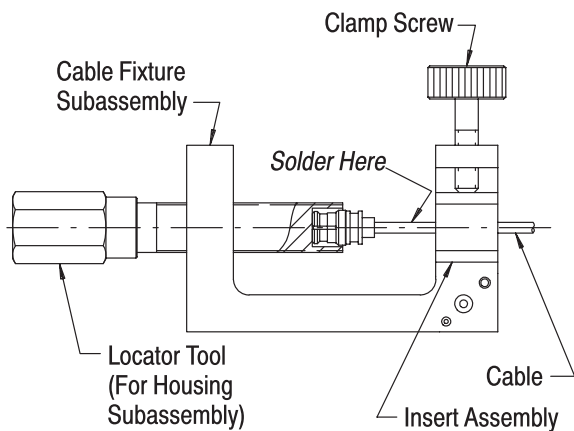


Figure 5

11. Adherence to assembly procedure should yield tolerances shown in Figure 6.

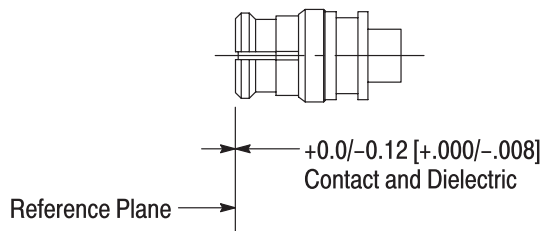


Figure 6

4. REPLACEMENT AND REPAIR

DO NOT re-use a soldered center contact or housing subassembly by removing the cable.

Components of the jack are not repairable. Replace any defective or damaged components.

5. REVISION SUMMARY

- Updated logo.