AMP

OSM Panel Feedthrough Hermetic Jack Receptacle
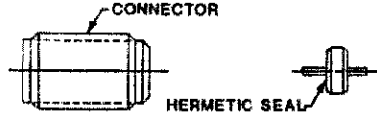## Two Piece Construction 1053264–1 and 1053265–1

CONNECTOR TYPE

OSM PANEL FEEDTHROUGH
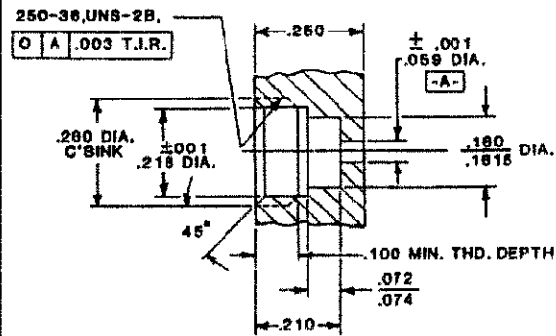HERMETIC JACK RECEPTACLE
TWO PIECE CONSTRUCTION

TOOLS REQUIRED:

.250–36,UNS–2B BOTTOMING TAP: 2098–6618–54
STEP REAMER: 2098–0443–54
HERMETIC SEAL SOLDERING FIXTURE: 2098–5614–54
TORQUE TOOL: 2098–0248–54
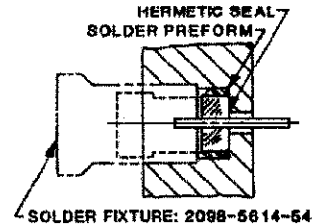
CONNECTOR

CONNECTOR

HERMETIC SEAL

ASSEMBLY OPERATIONS

1.0 MOUNTING HOLE PREPARATION
  1.1 DRILL .059 + .001 DIAMETER PILOT
       HOLE THROUGH PANEL.
  1.2 INSERT STEP REAMER INTO PILOT HOLE
       AND REAM TO DEPTH SHOWN.
  1.3 TAP .250–36 THREAD TO DEPTH SHOWN.

  1.4 PLATE PER CUSTOMER APPLICATION
       RECOMMENDED MAXIMUM TOTAL
       PLATING IS .00019.

  1.5 CLEAN IN SOLVENT.

250–36,UNS–2B.
O | A | .003 T.I.R.
.250
± .001
.059 DIA.
–A–
.280 DIA.
C'SINK ±.001
.218 DIA.
.160
.1615 DIA.
45°
.100 MIN. THD. DEPTH
.072
.074
.210

2.0 INSTALLATION OF HERMETIC SEAL ASSEMBLY
  2.1 ASSEMBLE APPROPRIATE SOLDER PREFORM
       INTO MOUNTING HOLE.
  2.2 ASSEMBLE HERMETIC SEAL ASSEMBLY
       INTO MOUNTING HOLE AS SHOWN.
  2.3 THREAD HERMETIC SEAL SOLDERING
       FIXTURE INTO MOUNTING HOLE AND
       BOTTOM.
  2.4 APPLY SUFFICIENT HEAT TO FLOW SOLDER.
  2.5 AFTER SOLDER HAS COOLED DISASSEMBLE
       HERMETIC SEAL SOLDERING FIXTURE.

HERMETIC SEAL
SOLDER PREFORM

SOLDER FIXTURE: 2098–5614–54

STEP   I – With one hand holding the collet and the other
           hand on the handle, turn the handle clockwise
           in reference to the collet until it stops. Then
           turn the handle counterclockwise to approximately
           ¼ to ½ of a complete turn.

STEP II – With one hand holding the collet, thread the
           connector all the way into the tool until it
           bottoms inside. Hand tighten the connector.

STEP III – Assemble metal gasket onto connector.

STEP IV – Thread the connector into the MIC housing using
           the handle of the tool, turning clockwise until
           the torque on the handle of the tool releases
           (torque adjusted to 16 ±1 inch–pounds).

STEP   V – Release the tool from the connector by turning
           the handle counterclockwise. The connector
           is now properly installed.

NOTE: The procedure generally works in most MIC housings.
If for some reason the collet does not release the connector,
use a 3/8" open wrench to hold the front collet, then turn the
handle of the tool counterwise.

TORQUE TOOL: 2098–0248–54

This controlled document is subject to change.
For latest revision call the AMP FAX* number.
Dimensions are in inches.

TOOLING ASSISTANCE CENTER 1–800–722–1111
AMP FAX/PRODUCT INFO 1–800–522–6752