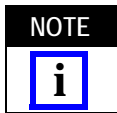


Figure 1

1. INTRODUCTION (Figure 1)

This instruction sheet contains the assembly procedures for TNC Bulkhead Feedthrough Cable Jack Direct Solder Attachment 1057676-1, which is applied onto .141 semi-rigid coaxial cable or .141 semi-rigid microporous cable.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the M/A-COM part number to the TE Connectivity part number.



Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue are provided in Section 4, REVISION SUMMARY.

2. DESCRIPTION

The direct solder attachment consists of a mounting nut, lockwasher, gasket, housing subassembly, center contact, and a rear housing.

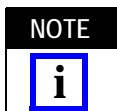
3. ASSEMBLY PROCEDURES

3.1. Preparing Cable (Figure 3)

Trim cable to the dimensions shown in Figure 3.

3.2. Soldering Cable to Rear Housing (Figure 4)

1. Position and secure rear housing in a small bench vise.
2. Tin inner conductor of cable.
3. Insert cable into rear housing.
4. Seat cable firmly against step in rear housing and solder.



It may be necessary to re-trim dielectric to dimension shown in Figure 4.

TOOL DESCRIPTION	TE PART NUMBER	M/A-COM PART NUMBER
Center Contact Holder	1055474-1	2098-5279-10 (T-4580)

Figure 2

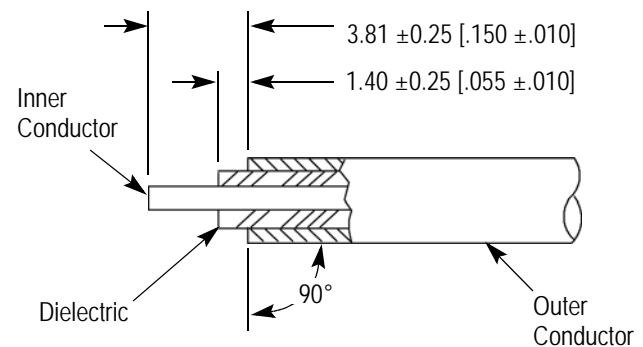


Figure 3

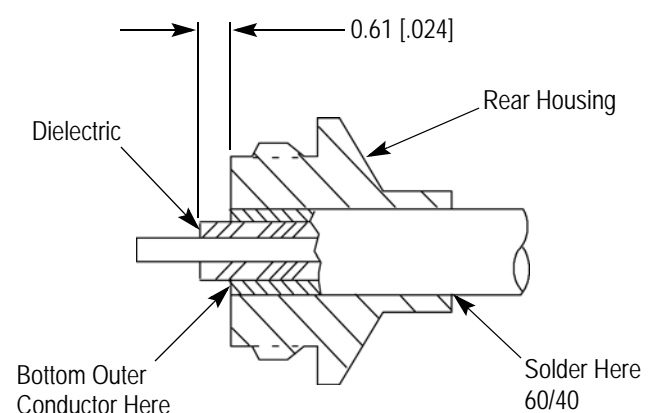
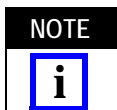


Figure 4

3.3. Soldering of Center Contact to Inner Conductor (Figure 5)

1. Place center contact in the center contact holder, heat center contact and push it over inner conductor of cable to rest firmly against dielectric.
2. Remove excess solder.



For microporous cable, do not use flux or solvent in dielectric area.

3.4. Assembling Housing Subassembly onto Rear Housing Subassembly (Figure 6)

1. Secure housing subassembly to threads of rear housing subassembly.
2. Tighten with a torque of 2.83 - 3.39 N•m [25 - 30 in-lb].

3.5. Inspecting Completed Connector Assembly

Following the assembly procedures in this instruction sheet should yield tolerances shown in Figure 7.

4. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.

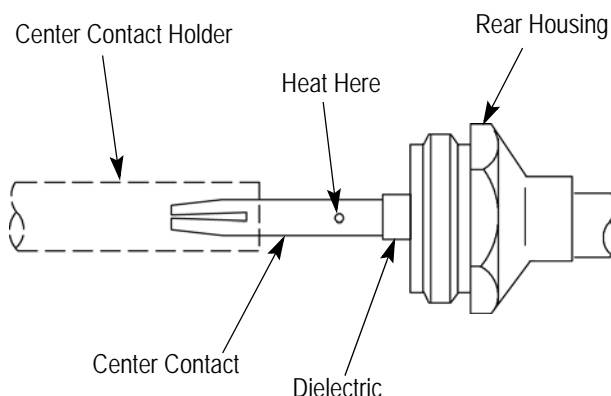


Figure 5

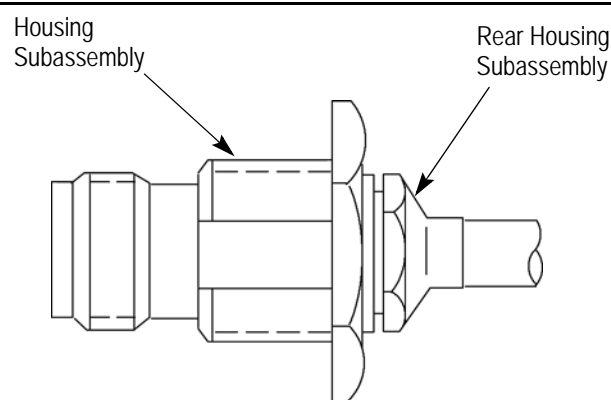


Figure 6

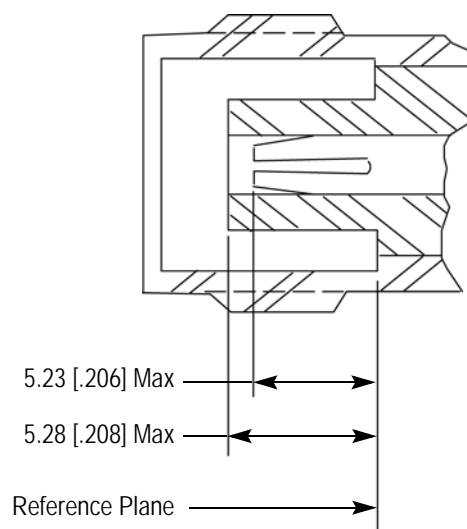


Figure 7