

TE PART NO.	PREVIOUS PART NO.	CABLE TYPE
1059540-1	4536-7341-02	RG55/U, 142, 223, 400

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedure for OSP Flange Mount Cable Jack Connector 1059540-1. Refer to Figure 1. These connectors are floating rear mount, crimp attachment type connectors that attach to the cable listed in Figure 1. Figure 1 also contains the previous part number for the flange mount cable jack connector.



*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 this connector. The table includes tool description, TE part number, and the corresponding "previous" part number.

TOOL DESCRIPTION	PART NO. CROSS-REFERENCE	
	TE NO.	PREVIOUS NO.
Crimping Tool	1060713-1	5698-5014-54 (T-4718)
Crimping Die	1060714-1	5698-5015-54 (T-4702-1 Die No. B)
Contact Holder	1055454-1	2098-5221-10 (T-4578)

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

## 2. ASSEMBLY PROCEDURES

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

1. Place the heat-shrink tubing and outer sleeve on the cable.

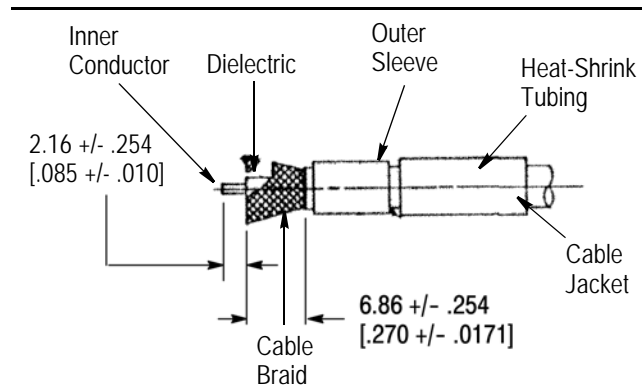


Figure 2

2. Using a knife, remove the end portion of the cable jacket.



*To avoid personal injury, be sure to use personal protection, including gloves, when handling a knife.*

3. Trim the cable braid to length.
4. Trim the cable dielectric to length.
5. Trim the inner conductor to length.
6. Flare the cable braid.

### 2.2. Soldering Center Contact to Cable Inner Conductor (Figure 3)



*The soldering equipment is hot. To avoid personal injury, be sure to exercise caution when working around soldering equipment.*

1. Tin the inner conductor of the cable.

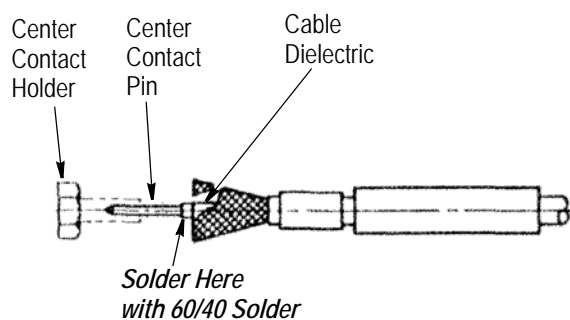


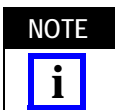
Figure 3

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

3. Remove excess solder.

### 2.3. Crimp the Cable Subassembly to Housing Subassembly (Figure 4)

1. Insert the cable into the housing subassembly and seat the cable firmly in the housing



*Be sure that the center contact enters the pre-assembled housing contact.*

2. Slide the outer sleeve over the flared portion of the cable braid.

3. Hold the assembly securely (with the cable seated in the housing) and crimp the outer sleeve in place using the appropriate crimping tool and crimping die.

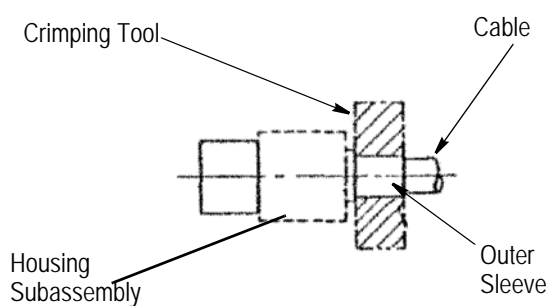


Figure 4

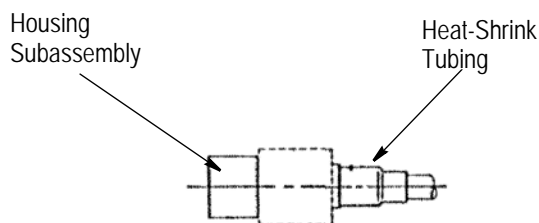
4. Trim and remove excess cable braid.

### 2.4. Completing the Termination

1. Slide the heat-shrink tubing over the cable and housing subassembly as shown in Figure 5.

2. Apply indirect heat to the heat-shrink tubing with a heat gun.

3. Assembly is now complete.



Completed Assembly

Figure 5

### 3. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo