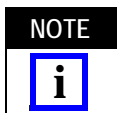


Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the OSP Bulkhead Feedthrough Cable Plug 1059523-1 Connector shown in Figure 1. This connector is a rear mount, crimp attachment type connector that attaches to the cable type listed in Figure 1. Also contained in Figure 1 is the previous OSP Bulkhead Feedthrough Plug part number.



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.
Crimp Tool	1060713-1	5698-5014-54 (T-4718)
Crimp Die (No. C)	1060714-1	5698-5015-54 (T-4702)

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)

- Slide the shrink sleeve and outer sleeve on the cable.



To avoid personal injury, be sure to wear gloves and adhere to all local safety practices when handling a cutting blade or knife.

- Remove the end portion of the cable jacket to expose the cable outer conductor (cable braid).
- Trim the dielectric to the length shown in Figure 2.
- Trim the outer conductor to the length shown in Figure 2.
- Trim the inner conductor to the length shown in Figure 2.
- Flare the cable outer conductor (cable braid).

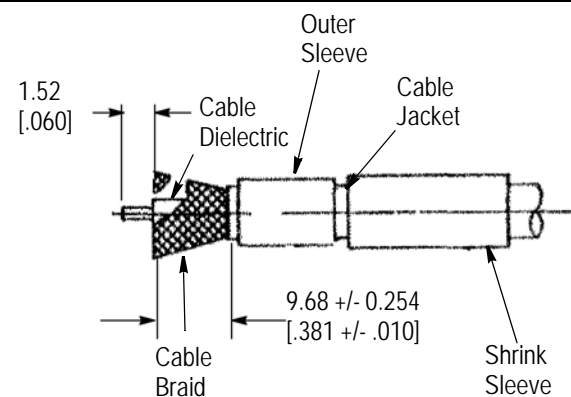


Figure 2

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



To avoid personal injury and avoid burns, exercise caution when using soldering equipment.

1. Tin the inner conductor.
2. Heat the center contact with a soldering iron and carefully push it over the inner conductor until it butts firmly against the dielectric.
3. Remove excess solder or splatter.

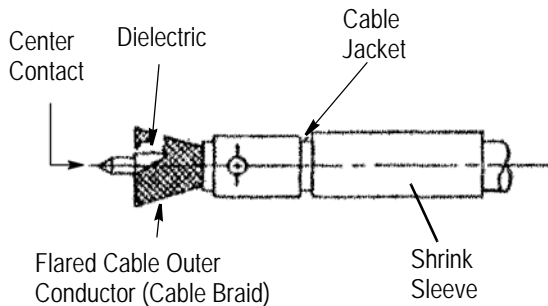


Figure 3

2.3. Crimping the Cable Subassembly to the Housing Subassembly (Figure 4)

1. Ensure that the center contact enters the pre-assembled housing contact. Insert the cable into the housing subassembly and seat it firmly.
2. Slide the outer sleeve over the flared portion of the cable outer conductor (cable braid).
3. Hold the cable (firmly seated in the connector subassembly) and crimp the outer sleeve in place using the tooling shown in the table in Section 2.
4. Trim and remove excess outer conductor (cable braid) strands.

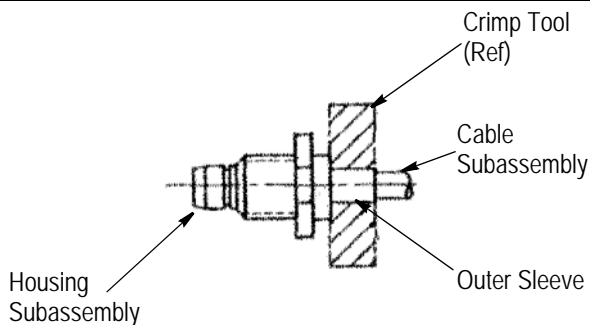


Figure 4

2.4. Applying the Shrink Sleeve

1. Position the shrink sleeve over the outer sleeve as shown in Figure 5.
2. Apply indirect heat evenly with a heat gun to shrink the sleeve.

3. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo

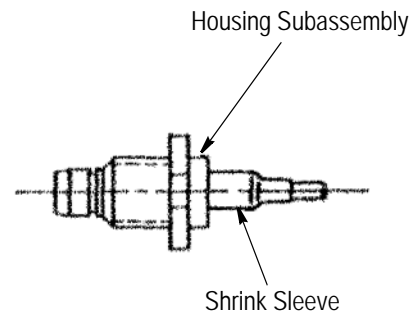


Figure 5