

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the OSP Right-Angle Floating Flange Mount Cable Jack Connector 1058573-1, which is applied onto 178/U double braid cable.

The table in Figure 2 represents tool numbers applicable to this instruction sheet. The table references the previous part number to the Tyco Electronics part number.

TOOL DESCRIPTION	TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER
Crimp Tool	1060713-1	5698-5014-54 (T-4718)
Crimp Die	1060714-1	5698-5015-54 (T-4702-1) Die No. C (.128 Hex)

Figure 2

NOTE

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

2. DESCRIPTION (Figure 1)

The right-angle floating flange mount cable jack connector consists of a disc, housing subassembly, outer sleeve, and sheath.

3. ASSEMBLY PROCEDURES

3.1. Preparing the Coaxial Cable End (Figure 3)

1. Place sheath and sleeve on cable.

2. Remove the end portion of the cable jacket to expose the cable outer conductor.
3. Trim the outer conductor to length.
4. Trim the cable dielectric to length.
5. Trim the inner conductor to length.
6. Flare outer conductor.

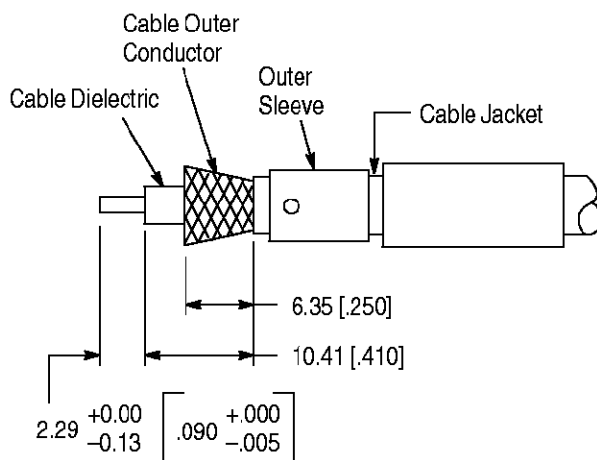


Figure 3

3.2. Soldering of Cable Inner Conductor to Center Contact (Figure 4)

1. Position and secure the housing subassembly in a small bench vise.
2. Tin inner conductor of the cable.

3. Insert cable into the housing subassembly.
 - a. Insert cable inner conductor in the center contact slot.
 - b. Hold cable dielectric and inner conductor flush as shown in Figure 4.
4. Place soldering iron on the tip of the center contact and solder.

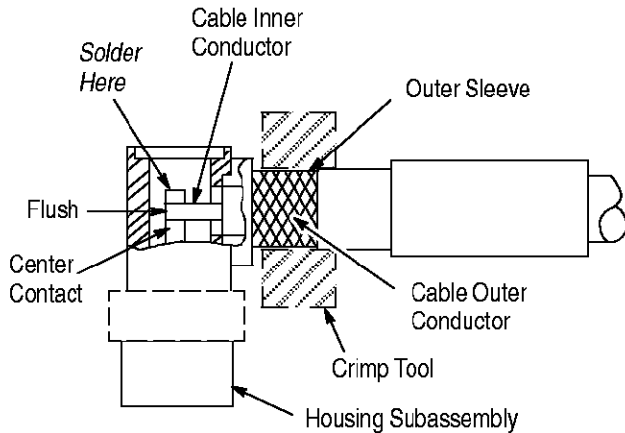


Figure 4

3.3. Crimping of Cable Subassembly to Housing Subassembly (Figure 4)

1. Slide the outer sleeve over flared portion of the outer conductor.
2. Crimp outer sleeve in place.
3. Trim and remove excess outer conductor strands.

CAUTION Damaged components must not be used. They must be replaced with new components.

3.4. Shrinking Sheath to Cable (Figure 5)

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

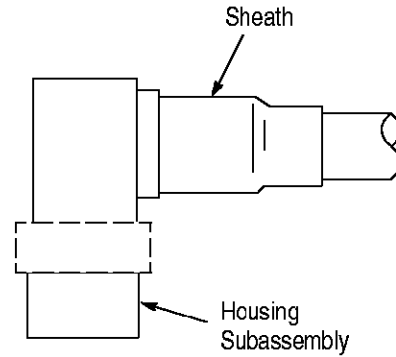


Figure 5

3.5. Sealing Opening in Housing (Figure 6)

Press the disc into opening in rear of housing subassembly after which one of the below methods may be used:

Option 1: Tin perimeter of opening and press disc into position. Apply heat to cap, do not allow solder to penetrate housing.

Option 2: Disc may be epoxied into place. Do not allow epoxy to penetrate inside housing.

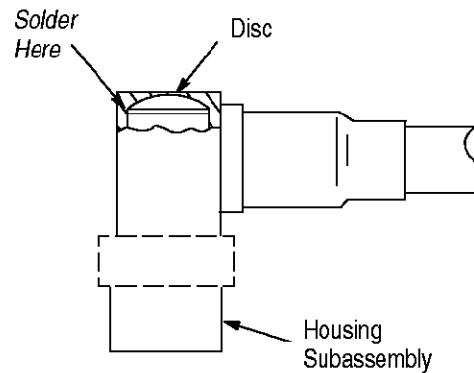


Figure 6

4. REVISION SUMMARY

Initial release of document per EC 0990-0052-03