

CONNECTOR		CABLE TYPE
TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	
1062258-1	1031 5002 95	RG174/U, 179 187, 188, 316
1081231-1	1031 5002 00	
1045481-1	1031 5002 00	
1045482-1	1031 5002 02	

Figure 1

**1. INTRODUCTION**

These instructions cover the assembly of the SSMA Straight Cable Plugs listed in Figure 1. Figure 1 also lists the cable types required for the various connectors.

All of these connectors are solder-type connectors.

Tooling required for the application is listed in Figure 2.

TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	DESCRIPTION
1055463-1	2098 5237 10 (T-4579)	Center Contact Holder
1055461-1	2098 5236 02 (T-1888)	Locator Tool

Figure 2

**NOTE** Dimensions in this document are in metric units [with U.S. customary units in brackets], unless otherwise specified.

**NOTE** Reasons for revision can be found in SECTION 3.

**2. ASSEMBLY**

**2.1. Preparing the Coaxial Cable End** (Figure 3)

1. Place the heat-shrink tubing and ferrule on the cable.

2. Remove the end portion of the cable jacket to expose the cable braid.
3. Trim the braid to the length shown in Figure 3.
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 Inner Conductor** (Figure 4)

1. Tin the inner conductor
2. Place center contact in center contact holder (see Figure 4)
3. Heat the center contact with a soldering iron and carefully push it over the inner conductor to rest firmly against the dielectric.

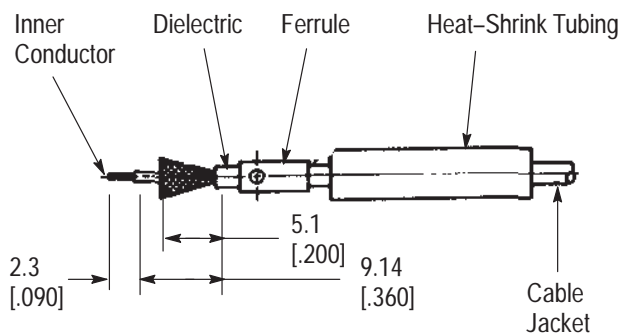


Figure 3

Center Contact  
Holder T-4579

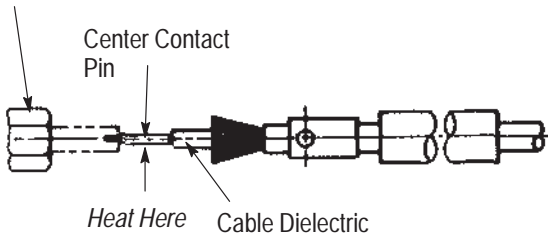


Figure 4

**DANGER**

To avoid personal injury, be sure to follow all local safety practices when using soldering equipment.

4. Remove the excess solder or splatter.

**2.3. Soldering Cable Braid to the Housing Subassembly** (Figure 5)

1. Secure the locator tool to the threads of the housing subassembly.
2. Position and secure the housing subassembly in a small bench vice.
3. Insert cable into the housing subassembly and seat it firmly.
4. Slide the ferrule over the flared cable braid.
5. Hold the cable firmly seated and solder through the holes in the ferrule.

**DANGER**

To avoid personal injury, be sure to follow all local safety practices when using soldering equipment.

6. Trim and remove excess cable braid strands.

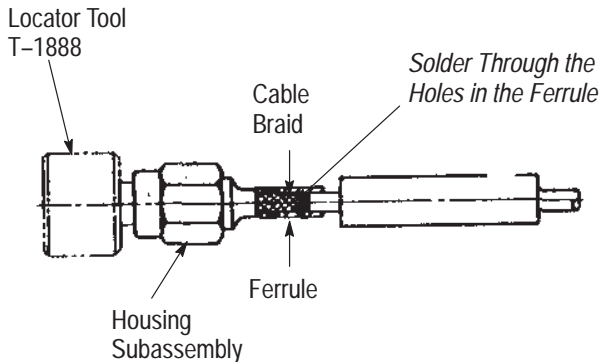


Figure 5

**2.4. Shrink Heat-Shrink Tubing to the Cable** (Figure 6)

1. Position the heat-shrink tubing over the ferrule as shown in Figure 6.

2. Apply indirect heat with a “thermo gun” to shrink the heat-shrink tubing.
3. Remove the locator tool.

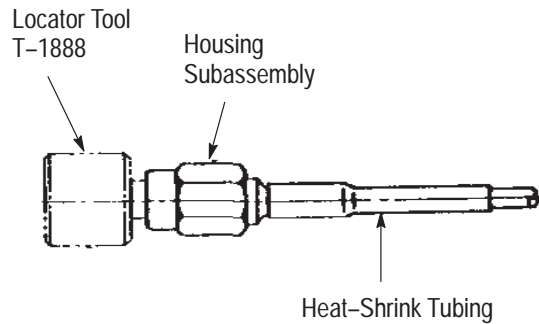


Figure 6

**2.5. Inspecting the Completed Assembly**

Adherence to the assembly steps should yield the dimensions shown in Figure 7.

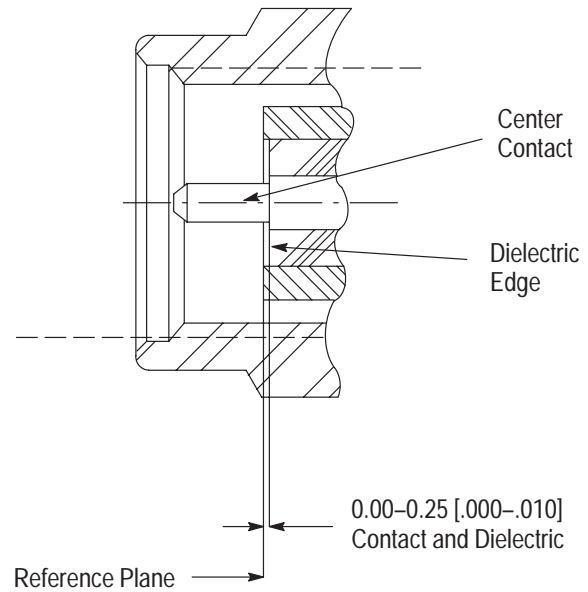


Figure 7

**3. REVISION SUMMARY**

Per EC 0990-0313-04:

- Removed obsolete number 1045485-1
- Changed title
- Clarified text and illustrations
- Updated format to current corporate requirements