

OSP Flange Mount Cable Jack Floating Rear Mount Direct Solder Attachment 1059456-1, 1059442-1, and 1046485-1

Instruction Sheet 408-8263 (was A.P. 45-008) 02 MAR 00 Rev O EC 0990-0250-00

CONNECTOR

TYPE

OSP FLANGE MOUNT
CABLE JACKFLOATING REAR
MOUNT
DIRECT SOLDER
ATTACHMENT

CABLE TYPE

RG405/U .085 SEMI-RIGID COAXIAL CABLE

TOOLS REQUIRED:

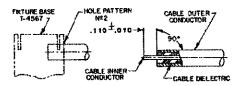
FIXTURE BASE: 2088-5208-54 (T-4567) CLAMP INSERT: 2098-5208-54 (T-4700-2) LOCATOR TOOL: 4598-5004-02

CONNECTOR

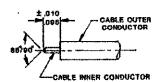


ASSEMBLY OPERATIONS

- 1.0 PREPARATION OF CABLE
 1.1 INSERT SQUARED CABLE END INTO FIXTURE
 BASE HOLE PATTERN #2.
 1.2 PLACE SAM IN SAM SLOT AND CUT THROUGH
 OUTER COMDUCTOR AND INTO DIELECTRIC
 WHILE ROTATING CABLE.
 1.3 REMOVE CABLE FROM FIXTURE AND FINISH
 CUTTING DIELECTRIC WITH CUTTING BLADE.
 1.4 BARE INNER COMDUCTOR BY PRYING CUT OUTER
 CONDUCTOR AND DIELECTRIC FROM CABLE.
 1.5 COMPLETE TRIMMING OF CABLE INNER
 COMPLETE TRIMMING OF CABLE INNER



- 2.0 SHAPE INNER CONDUCTOR OF CABLE
 2.1 FILE INNER CONDUCTOR TO LENGTH
 AS SHOWN.
 2.2 FILE BLUNT END OF INNER CONDUCTOR
 TO AN 85°-90° CONE.



- 3.0 SOLDERING OF CABLE IO CONNECTOR
 SUB-ASSEMBLY
 3.1 ASSEMBLE CABLE INTO CONNECTOR
 SUB-ASSEMBLY.
 3.1.1 CAREFULLY INSERT CABLE INNER
 CONDUCTOR INTO PRE-ASSEMBLED.
 CENTER CONTACT OF CONNECTOR
 BASE AS SHOWN.
 3.2 PLACE LOUSE ASSEMBLY IN FIXTURE
 BASE AS SHOWN.
 3.2.1 TIGHTEN CLAMP SCREW TO SECURE
 CABLE.
 3.2.2 TIGHTEN LOCATOR TOOL TO SEAT
 CONNECTOR SUB-ASSEMBLY FIRMLY.
 3.3 MAINTAIN POSITION OF CONNECTOR
 SUB-ASSEMBLY FIRMLY AGAINST
 LOCATOR TOOL AND SOLDER.

NOTE: FIXTURE BASE SHOULD BE CLAMPED VERTICAL IN A VISE TO KEEP COMMECTOR SUB-ASSEMBLY SEATED AGAINST LOCATOR TOOL.

