

Figure 1

## 1. INTRODUCTION

This instruction sheet contains the assembly procedures for AMP OSSP Bulkhead Feedthrough Cable Plug 1059857-1. See Figure 1. This connector is a rear mount, direct solder attachment type plug that attaches to a bulkhead and RG405/U .085 semi-rigid coaxial cable.

The table in Figure 2 references the special tools required to apply these connectors. The table includes tool descriptions, Tyco Electronics part numbers, and corresponding M/A-COM part numbers.

APPLICATION TOOLING		
Tool Description	Tyco Electronics Part Number	M/A-COM Part Number
Fixture Base	1055439-1	2098-5206-54 (T-4567)
Clamp Insert	1055441-1	2098-5208-54 (T-4700-2)
Locator Tool	1362989-1	4798-5005-02

Figure 2

### NOTE

Dimensions on this sheet are in millimeters [with inches in brackets], unless otherwise specified. Figures are not drawn to scale.

Reasons for reissue are provided in Section 3, REVISION SUMMARY.

## 2. ASSEMBLY PROCEDURES

### 2.1. Preparing Cable (Figure 3)

1. Insert the squared cable end into the fixture base hole, as shown in Figure 3,A.
2. Place saw in saw locator slot and cut through the outer conductor and into the dielectric while rotating the cable.

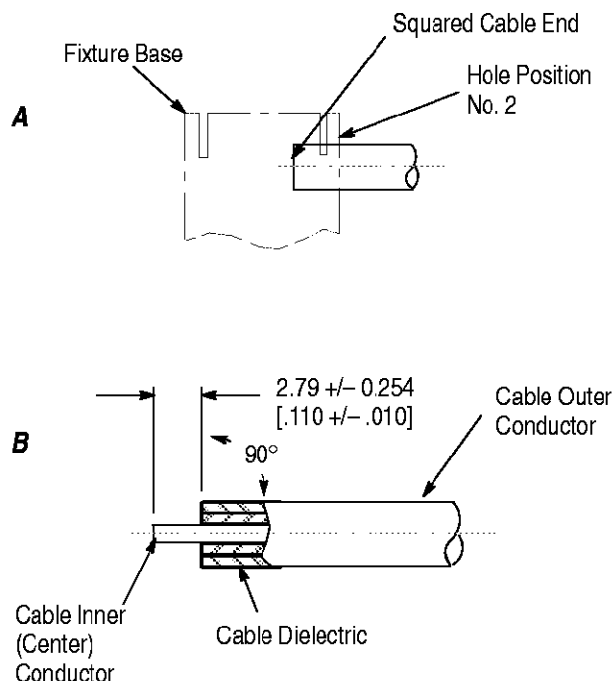


Figure 3

3. Remove cable from fixture and finish cutting the dielectric with a cutting blade.

**DANGER**

*To prevent personal injury, be sure to follow all local safety practices when cutting the cable.*

4. Bare the inner (center) conductor by prying the cut outer conductor and dielectric from the cable.

5. Trim the cable inner (center) conductor to the dimensions shown in Figure 3,B.

6. Shape the inner (center) conductor of the cable.

a. Trim the center conductor to the length shown in Figure 4.

b. File the blunt end of the center conductor to produce an 85° to 90° cone. See Figure 4.

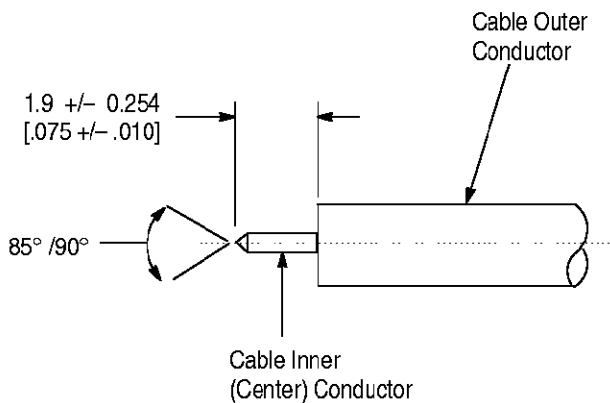


Figure 4

## 2.2. Soldering the Cable to the Housing Sub-Assembly

1. Carefully insert the center conductor into the pre-assembled center contact of the housing sub-assembly.

2. Loosely place the the assembly in the fixture base as shown in Figure 5.

3. Tighten the clamp screw on the fixture base to secure the cable.

4. Tighten the locator tool to seat the housing sub-assembly firmly.

**DANGER**

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

5. Maintain the position of the housing sub-assembly firmly against the locator tool and solder the connector with 60/40 solder.

**NOTE**

*The fixture base should be clamped in a vise in the vertical position to keep the housing sub-assembly seated against the locator tool.*

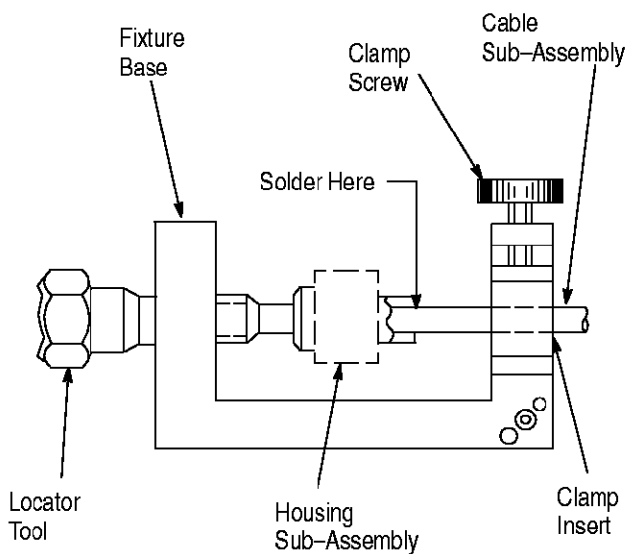


Figure 5

## 3. REVISION SUMMARY

Per EC 0990-0116-01:

- Update and clarify illustrations, text, and callouts.