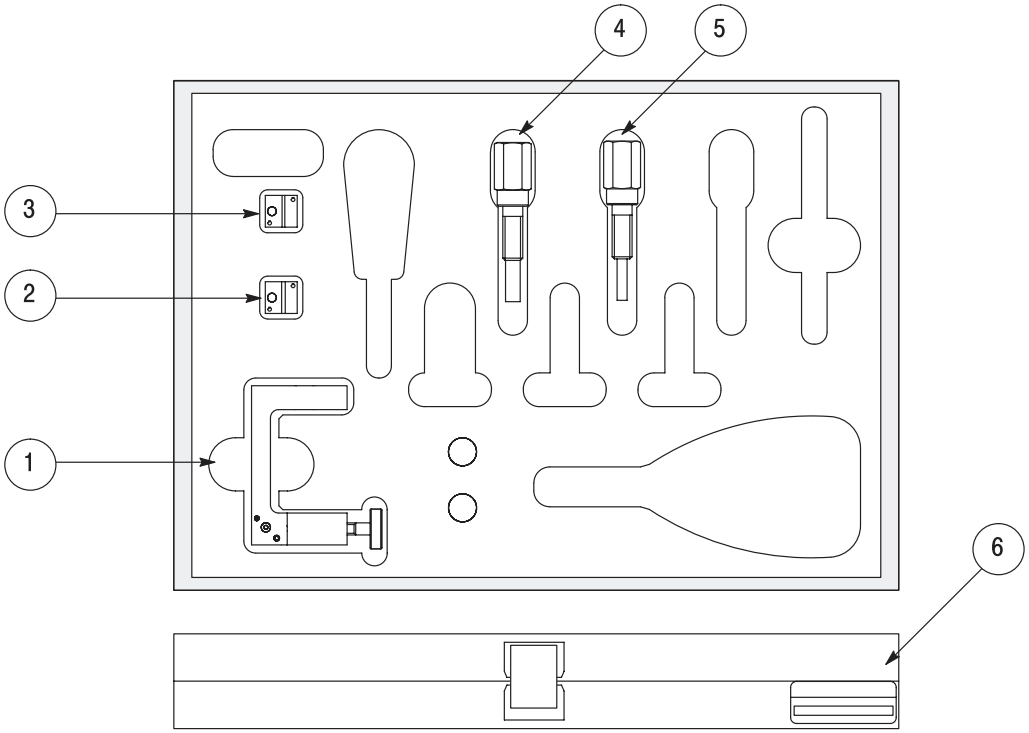
Solder Assembly Kit 1059772–1



ITEM NUMBER	COMPONENT		QTY PER KIT
	PART NUMBER	DESCRIPTION	
1	1055439–1	Cable Fixture Subassembly	1
2	1055441–1	Clamp Insert for 2.16–mm [.085–in.] Cable	1 Set
3	1055440–1	Clamp Insert for 3.58–mm [.141–in.] Cable	1 Set
4	1059769–1	Locator Tool	1
5	1059770–1	Locator Tool	1
6	10403722–1	Tool Box Assembly (with Identification Plate)	1

Figure 1

1. INTRODUCTION

Solder Assembly Kit 1059772–1 shown in Figure 1 contains everything necessary to solder OSP Blindmate solder style connectors to 2.16–mm [.085–in.] and 3.58–mm [.141–in.] diameter semi–rigid cable.

CAUTION

These instructions are for reference only. *Refer to the appropriate connector–specific instructions to insure proper assembly.*

Reasons for reissue of this instruction sheet are provided in Section 6, REVISION SUMMARY.

NOTE

Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

2. DESCRIPTION

The kit contains the components listed in Figure 1. The two types of locators are used to properly align the connector and cable.

The cable fixture subassembly consists of a fixture frame, thumb screw, positioning tool, and spring. See Figure 2. When used with the proper set of clamp inserts, the assembly holds and locates the coaxial cable for soldering.

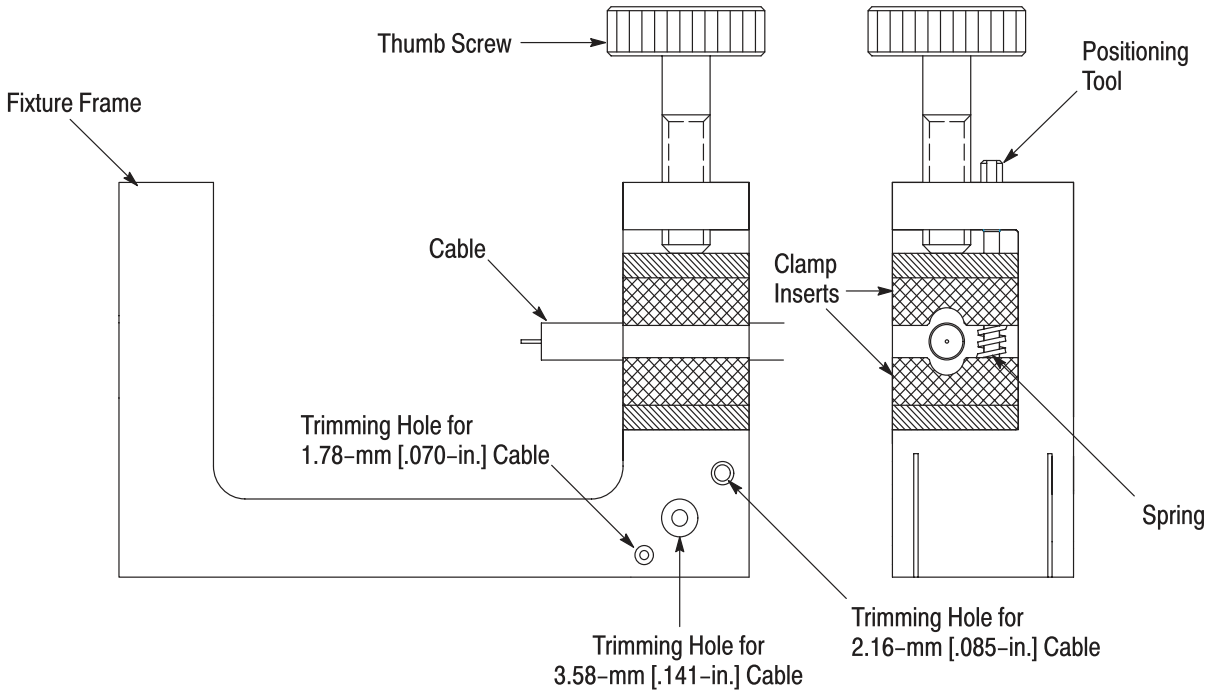


Figure 2

3. INSTALLING AND REPLACING CLAMP INSERT

NOTE

Clamp inserts are supplied in sets of two. Upper and lower inserts are interchangeable.

1. Select the appropriate set of clamp inserts (refer to Figure 1).
2. Remove the cable fixture thumbscrew by rotating it counterclockwise.
3. Remove the positioning tool by rotating it counterclockwise.
4. Remove the clamp inserts from the fixture frame after the positioning tool is removed.
5. Sandwich the spring in the pockets of the replacement clamp inserts. Refer to Figure 2.
6. Place the clamp inserts in the fixture frame and re–install the positioning tool.
7. Re–tighten the positioning tool.
8. Re–install the thumbscrew.

4. TRIMMING CABLE WITH FIXTURE FRAME

The fixture frame is equipped with six trimming holes designed to remove the outer jacket and cable dielectric.

The side marked with the number “2” is for trimming 1.78–mm [.070–in.], 2.16–mm [.085–in.], and 3.58–mm [.141–in.] cable. See Figure 2. When the cable is fully bottomed during trimming, a strip length of 2.79 mm [.110 in.] will result. If different strip lengths are required, the center conductor must be trimmed separately.

The side marked with the number “1” is for trimming cable already mounted in a connector housing. See the connector–specific instruction sheet for more information.

NOTE

Trim blades are NOT included with the kit. Use a razor blade with 0.38–mm [.015–in.] maximum thickness.

5. USING LOCATING TOOLS

The kit contains two locating tools. Refer to the connector–specific instruction sheet for selection of proper locator tool and assembly instructions.

These tools are designed to be used with the fixture subassembly. To insure proper connector assembly, use the following:

1. Place the connector housing on the end of the cable subassembly (cable with the center contact).
2. Place the loose connector assembly in the fixture base.
3. Nest the center contact in the locator tool.

4. Tighten the thumbscrew to secure the cable.

5. Tighten the locator tool to seat the cable firmly.

6. Slide the connector housing over the locator tool.

7. Maintain the position of the housing firmly against the locator tool.

The fixture should be clamped vertically in a vise to keep the housing seated against the locator tool.

8. Solder according to the connector–specific instructions.

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

6. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements