OSM Right Angle Cable Plug Crimp Attachment 1052080-1, 1327121-1, 1052081-1, and 1061840-1

Instruction Sheet 408–4684 08 FEB 00 Rev O EC 0990-0122-00

FERRULE

CONNECTOR **TYPE**

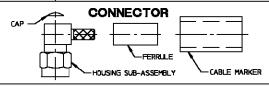
OSM RIGHT ANGLE CABLE PLUG CRIMP ATTACH

CABLE TYPE

TOOLS REQUIRED:

RG 180/U, 195

LOCATOR TOOL: 2098-5218-02 (T-2367) CRIMP TOOL: 2098-0105-54 DIE NO. D



ASSEMBLY OPERATIONS

±.010

.115

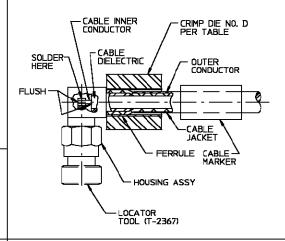
- 1.0 PREPARE COAXIAL CABLE END.
 - 1.1 PLACE CABLE MARKER AND FERRULE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH. 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.
- CABLE MARKER ± 010 .210 CABLE OUTER CONDUCTOR CABLE JACKET CABLE DIELECTRIC CABLE INNER CONDUCTOR

±.010

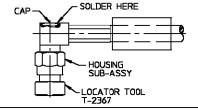
.355

- 2.0 SOLDERING OF CABLE INNER CONDUCTOR HOUSING SUB-ASSEMBLY.
 - SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
 - POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - TIN INNER CONDUCTOR OF CABLE.
 - INSERT CABLE INTO HOUSING SUB-ASSEMBLY
 - 2.4.1. NEST INNER CONDUCTOR IN CONTACT SLOT
 - 2.4.2. HOLD CABLE DIELECTRIC AND INNER CONDUCTOR FLUSH AS SHOWN.
 PLACE SOLDERING IRON ON TIP OF
 - CONTACT AND SOLDER
- 3.0 CRIMPING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY.

 3.1 SLIDE FERRULE OVER FLARED
 - PORTION OF OUTER CONDUCTOR.
 - CRIMP FERRULE IN PLACE.
 - TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 4.0 SEAL OPENING IN HOUSING 4.1 PRESS CAP INTO OPENING IN REAR HOUSING SUB-ASSEMBLY.
 CAP MAY BE EPOXIED INTO
 - PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.
 - REMOVE LOCATOR TOOL. 4.3



- 5.0 SHRINK CABLE MARKER TO CABLE
 - 5.1 POSITION CABLE MARKER OVER FERRULE AS SHOWN.
 - APPLY INDIRECT HEAT WITH THERMO GUN TO CABLE MARKER.

 - REMOVE LOCATOR TOOL.
 ASSEMBLY IS NOW COMPLETE

