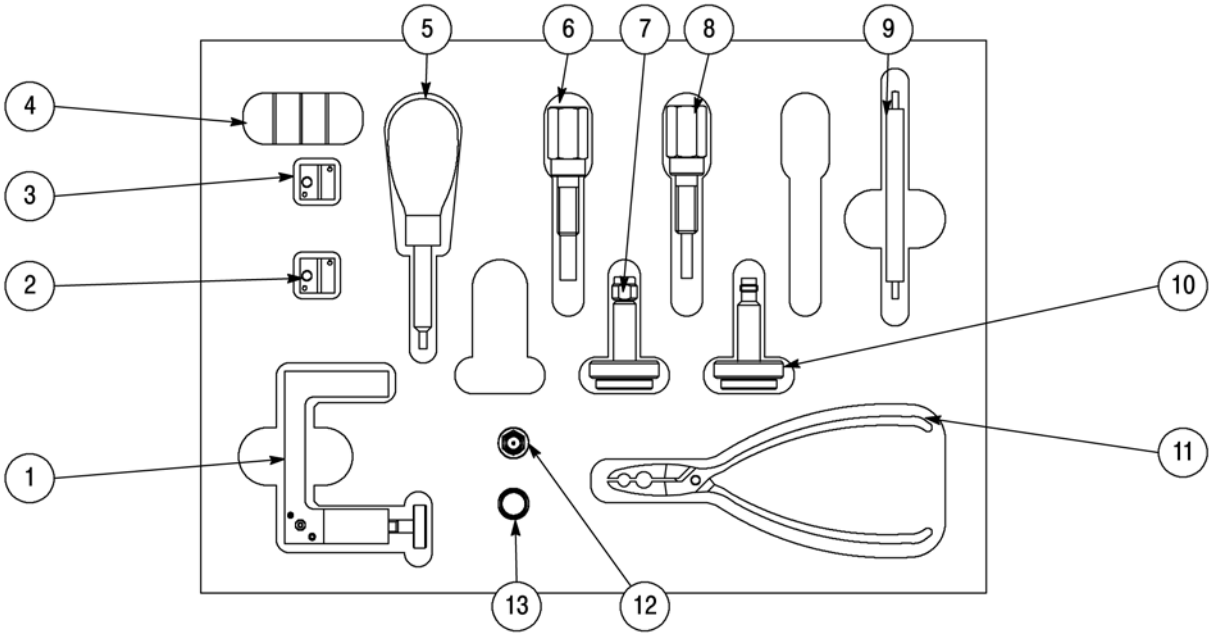
Solder Assembly Kit 1055466-1



ITEM NUMBER	TE PART NUMBER	DESCRIPTION	QTY PER KIT
1	1055439-1	Cable Fixture Sub-Assembly	1
2	1055441-1	Clamp Insert for 02.16 [.085] Cable	1 Set
3	1055547-1	Clamp Insert for 01.78 [.070] Cable	1 Set
4	91362-1	.38 [.015] Thick Solder Gage	1
5	1055460-1	Dielectric Recess Tool	1
6	1055456-1	Locator Tool, Type A	1
7	1055458-1	Dielectric Insert Tool	1
8	1055457-1	Locator Tool, Type A	1
9	1055463-1	Center Contact Holder	1
10	1055459-1	Dielectric Insert Tool	1
11	1055449-1	Locking Ring Pliers	1
12	1055464-1	Locator Tool, Type B	1
13	1055461-1	Locator Tool, Type B	1

Figure 1

1. INTRODUCTION

Solder Assembly Kit 1055466-1 for OSSM Connectors, shown in Figure 1, contains everything necessary to solder OSSM solder-style connectors to 2.16 [.085] and 1.78 [.070] diameter semi-rigid and flexible cable.

NOTE

Tool directions in this document are for reference only. Refer to the appropriate connector assembly instructions to insure proper assembly. Refer to Figure 2 and Figure 3 for connector assemblies and their associated instruction sheets.

©2011 Tyco Electronics Corporation, a TE Connectivity Ltd. Company
All Rights Reserved
*Trademark

TE Connectivity, TE connectivity (logo), and TE (logo) are trademarks. Other logos, product and/or Company names may be trademarks of their respective owners.

NOTE

Dimensions are in metric units [with U.S. customary units in brackets], unless otherwise indicated.

SEMI-RIGID CABLE CONNECTORS		
Connector Part Number		Instruction Sheet
1046477-1		408-4776
1046479-1		408-4777
1045423-1 1062251-1	1055670-1 1045422-1	408-4792
1045401-1		408-4793
1045381-1 1058589-1	1045410-1	408-4794
1058588-1 1045350-1	1045351-1 1062250-1	408-4795
1045370-1	1045369-1	408-4796

Figure 2

FLEXIBLE CABLE CONNECTORS		
Connector Part Number		Instruction Sheet
1045497-1		408-4788
1045496-1		408-4789
1062258-1 1081231-1	1045481-1 1045482-1	408-4790
1045477-1 1062256-1	1045476-1	408-4791
1062257-1 1045510-1	1085817-1 1045511-1	408-4798
1045507-1	1045508-1	408-4799

Figure 3

NOTE

Contact customer service or refer to Catalog 1308940 for additional information.

2. DESCRIPTION

Solder Assembly Kit 1055466-1 contains the tooling required to properly solder OSSM connectors to semi-rigid and flexible coax cable. The kit contains a cable fixture sub-assembly, two sets of clamp inserts for 2.16 [.085] and 1.78 [.070] cable, and four types of locators that are used to properly align the connector and cable. The kit also contains a solder gage for proper spacing of the center contact, a center contact holder, three dielectric insertion/recess tools, and locking ring pliers.

The cable fixture subassembly consists of a fixture frame, thumbscrew, positioning tool and spring. See Figure 4. When used with the proper clamp inserts the assembly holds and locates coaxial cable for soldering.

3. INSTALLING/REPLACING THE CLAMP INSERT

NOTE

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

1. Select the appropriate clamp inserts. Refer to Figure 1 for the appropriate clamp inserts.
2. Remove the cable fixture thumbscrew by rotating it in a counterclockwise direction.
3. Remove the positioning tool by rotating it in a counterclockwise direction.
4. Remove the clamp inserts from the frame after the positioning tool is removed.
5. Sandwich the spring in the pockets on the replacement clamp inserts.
6. Place clamp inserts in the fixture frame and reinstall the positioning tool.
7. Retighten positioning tool.
8. Reinstall 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 [.070], 2.16 [.085], and 3.58 [.141] cable. See Figure 4 and Figure 5. When cable is fully bottomed during trimming, a strip length of 2.79 [.110] will result. If different strip lengths are required the center conductor must be trimmed separately.

The side marked with a number 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 wih .38 [.015] maximum thickness.

5. USING SOLDER GAGE AND CENTER CONTACT HOLDER

The center contact holder is designed to hold both male and female center contacts for OSSM connectors.

The solder gage is used to properly space the OSSM center contact away from the cable dielectric.

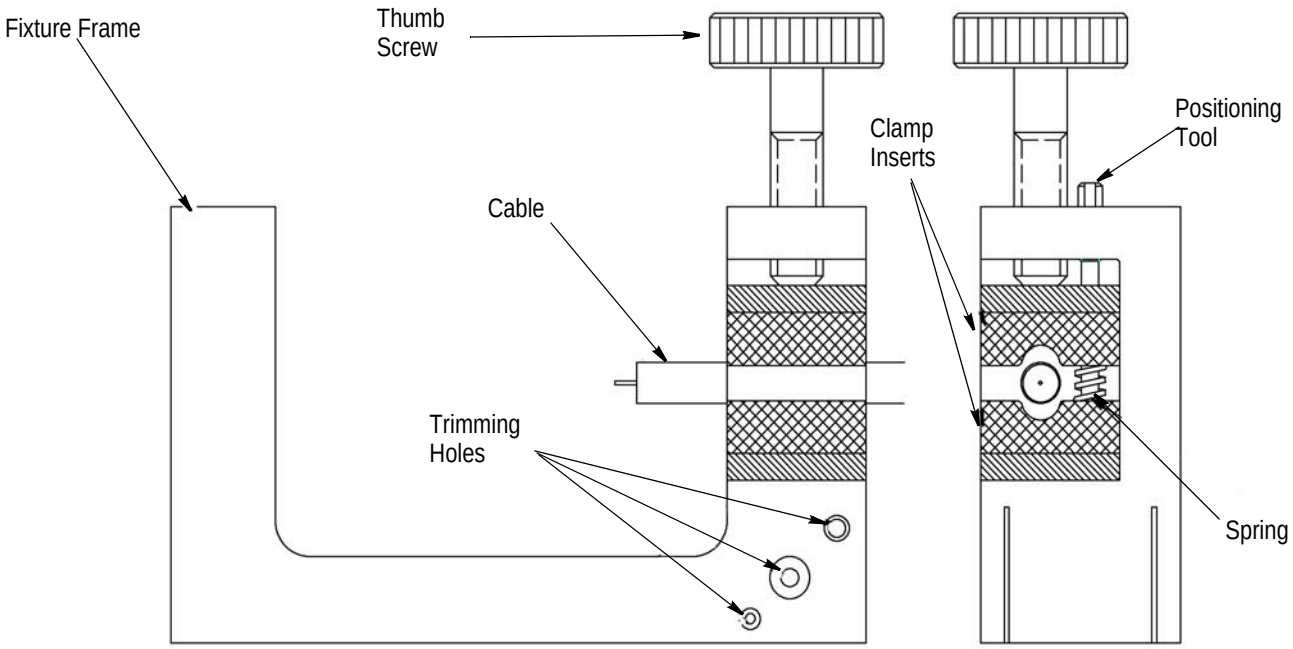


Figure 4

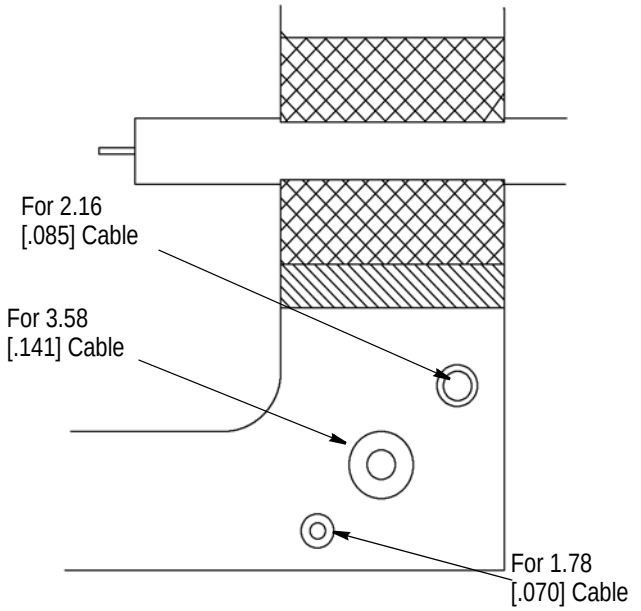


Figure 5

CAUTION

Center contact holders contains small amounts of lead. The lead is used for assembly.

NOTE

Maximum operating temperature for the center contact holder is 300°C [572°F].

DANGER

STOP

To avoid personal injury, be sure to observe all local safety practices (including the use of gloves). The solder gage, center contact holder, and the contact may be hot after soldering.

6. USING LOCATING TOOLS

Solder Assembly Kit 1055466-1 contains four locating tools. Refer to the connector specific instruction sheet for selection of proper locator tool and assembly instructions.

Type A, as well as Type B locating tools are available.

6.1. Using Type A Locating Tools

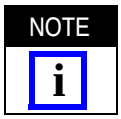
The solder assembly kit contains two Type A locator tools. These tools are designed to be used with the fixture subassembly. To insure proper connector assembly, follow the instructions listed below.

1. Place connector housing on end of cable sub-assembly. The subassembly refers to cable with center contact.
2. Place loose connector assembly in fixture base.
3. Nest the center contact in locator tool.
4. Tighten the thumbscrew to secure the cable.
5. Tighten the locator tool to seat the cable firmly.
6. Slide connector housing over locator tool.
7. Maintain position of housing firmly against locator tool.



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

8. Solder according to the connector specific instructions.



Fixture should be clamped vertically in vise to keep housing seated against locator tool.

6.2. Using Type B Locating Tools

The solder assembly kit contains two Type B locator tools. These tools are used to confine the connector dielectric, which aids in providing proper cable seating when soldering to flexible cable. To insure proper connector assembly, follow connector specific instructions.

7. USING DIELECTRIC TOOLS

Solder Assembly Kit 1055466-1 contains three dielectric tools. Two dielectric (insertion) tools are used to insert the dielectric bushing into the connector housing. The dielectric (recess) tool is used to compress expanded cable dielectric after soldering semi-rigid coaxial cable to the connector housing, if required.

Use the following instruction to press the dielectric bushing into the connector subassembly.

1. Thread the insertion tool into connector subassembly.
2. Insert the dielectric into insertion tool housing.
3. Place insertion tool plunger into position.
4. Press the plunger until the flange bottoms on the tool housing.

8. USING LOCKING RING PLIERS

The locking ring pliers are used to compress the retaining ring, allowing installation of the coupling nut on specific connectors. Use the pliers as follows:

1. Place retaining ring (and gasket) on connector housing.
2. Compress the retaining ring with the retaining ring pliers.
3. Push coupling nut on to housing and over the retaining ring.
4. Check to make sure the coupling nut rotates freely after the retaining ring is in place.

9. REVISION SUMMARY

Since the previous release of this document, the new company logo was applied.

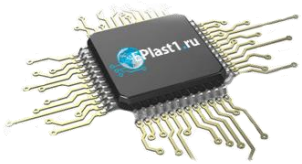
Компания «ЭлектроПласт» предлагает заключение долгосрочных отношений при поставках импортных электронных компонентов на взаимовыгодных условиях!

Наши преимущества:

- Оперативные поставки широкого спектра электронных компонентов отечественного и импортного производства напрямую от производителей и с крупнейших мировых складов;
- Поставка более 17-ти миллионов наименований электронных компонентов;
- Поставка сложных, дефицитных, либо снятых с производства позиций;
- Оперативные сроки поставки под заказ (от 5 рабочих дней);
- Экспресс доставка в любую точку России;
- Техническая поддержка проекта, помощь в подборе аналогов, поставка прототипов;
- Система менеджмента качества сертифицирована по Международному стандарту ISO 9001;
- Лицензия ФСБ на осуществление работ с использованием сведений, составляющих государственную тайну;
- Поставка специализированных компонентов (Xilinx, Altera, Analog Devices, Intersil, Interpoint, Microsemi, Aeroflex, Peregrine, Syfer, Eurofarad, Texas Instrument, Miteq, Cobham, E2V, MA-COM, Hittite, Mini-Circuits,General Dynamics и др.);

Помимо этого, одним из направлений компании «ЭлектроПласт» является направление «Источники питания». Мы предлагаем Вам помощь Конструкторского отдела:

- Подбор оптимального решения, техническое обоснование при выборе компонента;
- Подбор аналогов;
- Консультации по применению компонента;
- Поставка образцов и прототипов;
- Техническая поддержка проекта;
- Защита от снятия компонента с производства.



Как с нами связаться

Телефон: 8 (812) 309 58 32 (многоканальный)
Факс: 8 (812) 320-02-42
Электронная почта: org@eplast1.ru
Адрес: 198099, г. Санкт-Петербург, ул. Калинина, дом 2, корпус 4, литера А.