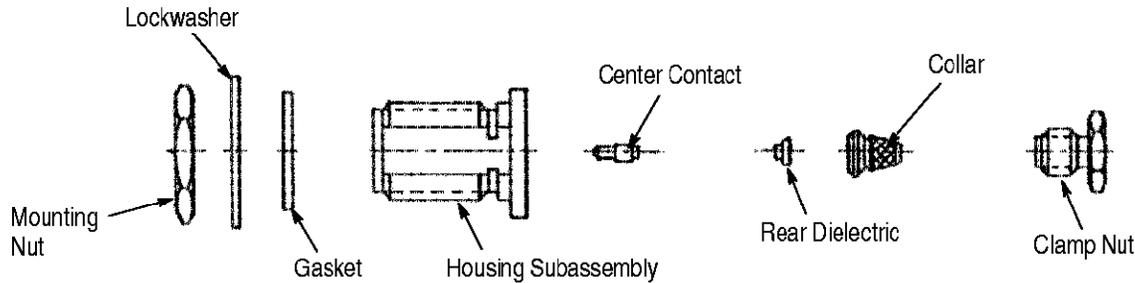


Type N Bulkhead Feedthrough Cable Jack Connectors



TYCO ELECTRONICS PART NUMBER	PREVIOUS PART NUMBER	CABLE TYPE
1057140-1	3004-7388-10	Flexible Cable
1057138-1	3004-7341-10	

Figure 1

1. INTRODUCTION

This instruction sheet contains the assembly procedures for the Type N Bulkhead Feedthrough Cable Jacks listed in Figure 1. These connectors are compression clamp attachment type connectors that attach to flexible cable. Figure 1 also contains the previous Type N Bulkhead Feedthrough Cable Jack part numbers.

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

The table in Figure 2 references the tools required to apply these connectors. The table includes tool descriptions, current Tyco Electronics part numbers, and the corresponding (previous) part numbers.

Tool Description	Tyco Electronics Part Number	Previous Part Number
Center Contact Holder	1055474-1	2098-5279-10 (T-4580)

Figure 2

Reasons for reissue can be found in Section 3, REVISION SUMMARY.

Read and understand these instructions thoroughly before proceeding.

2. ASSEMBLY PROCEDURES

2.1. Preparing the Coaxial Cable End (Figure 3)

1. Place the clamp nut on the cable.

2. Remove the end portion of the cable jacket to expose the cable outer conductor.

WARNING To avoid personal injury, be sure to follow all local safety practices when handling a knife or cutting tool.

3. Trim the outer conductor to length.
4. Trim the cable dielectric to length.
5. Trim the inner conductor to length.
6. Flare the outer conductor, as shown in Figure 3.

2.2. Assembling the Collar

WARNING To avoid personal injury and avoid burns, exercise caution when using soldering equipment.

1. Tin the inner conductor of the cable.
2. Slide the collar over the cable dielectric and under the cable outer conductor and cable jacket until the cable dielectric is flush with the face of the collar. See Figure 4.

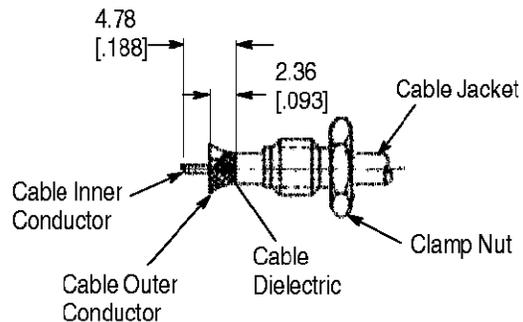


Figure 3

3. Trim the cable outer conductor flush with the diameter of the shoulder on the collar.

2.3. Soldering the Center Contact to the Cable Inner Conductor (Figure 5)

1. Assemble the rear dielectric onto the inner conductor of the cable with large diameter of rear dielectric seated against the collar.
2. Place the center contact in the center contact holder (Figure 2).

DANGER To avoid personal injury and avoid burns, exercise caution when using soldering equipment.

3. Heat the center contact and push it over the inner conductor of the cable with the large diameter of the contact resting firmly against the dielectric.
4. Remove excess solder.

2.4. Assembling the Clamp Nut into the Housing Subassembly (Figure 6)

1. Carefully insert the center contact into the pre-assembled center contact of the housing subassembly.
2. Engage the threads of the clamp nut to the housing and tighten the nut (approximately 25 to 30 Inch/Pounds torque).

2.5. Inspecting the Completed Connector Assembly

Carefully following the instructions should yield the tolerances shown in Figure 7.

3. REVISION SUMMARY

The following changes were made per EC 0990-1065-01:

- Added tooling part number cross-reference
- Changed title
- Changed OSN to Type N in the title
- Clarified text and illustrations
- Updated format to current corporate requirements

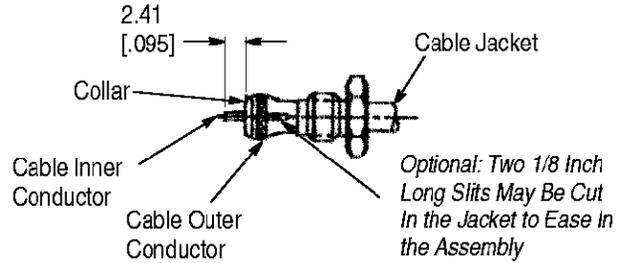


Figure 4

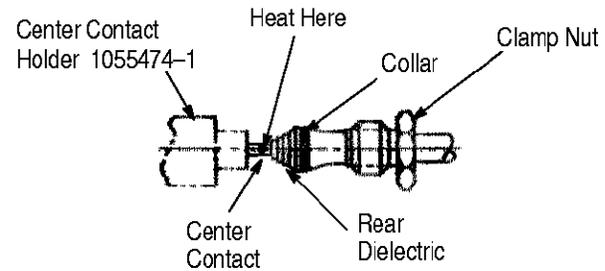


Figure 5

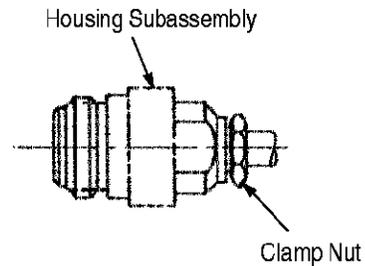


Figure 6

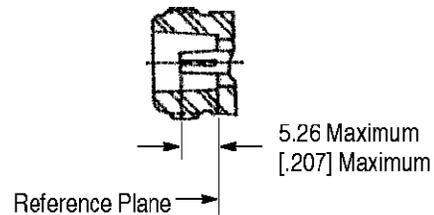


Figure 7