

Chipsmall Limited consists of a professional team with an average of over 10 year of expertise in the distribution of electronic components. Based in Hongkong, we have already established firm and mutual-benefit business relationships with customers from Europe, America and south Asia, supplying obsolete and hard-to-find components to meet their specific needs.

With the principle of "Quality Parts, Customers Priority, Honest Operation, and Considerate Service", our business mainly focus on the distribution of electronic components. Line cards we deal with include Microchip, ALPS, ROHM, Xilinx, Pulse, ON, Everlight and Freescale. Main products comprise IC, Modules, Potentiometer, IC Socket, Relay, Connector. Our parts cover such applications as commercial, industrial, and automotives areas.

We are looking forward to setting up business relationship with you and hope to provide you with the best service and solution. Let us make a better world for our industry!

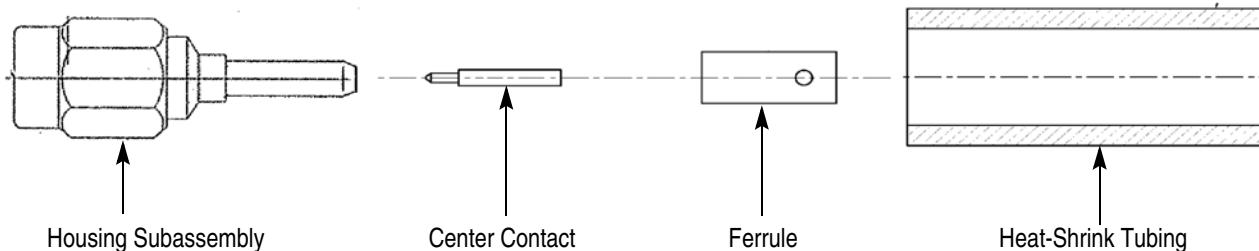


## Contact us

Tel: +86-755-8981 8866 Fax: +86-755-8427 6832

Email & Skype: [info@chipsmall.com](mailto:info@chipsmall.com) Web: [www.chipsmall.com](http://www.chipsmall.com)

Address: A1208, Overseas Decoration Building, #122 Zhenhua RD., Futian, Shenzhen, China



CONNECTOR		CABLE TYPE
TE CONNECTIVITY PART NO.	PREVIOUS PART NO.	
1062258-1	1031 5002 95	RG174/U, 179, 187, 188, 316
1081231-1	1031 5002 00	
1045481-1	1031 5002 00	
1045482-1	1031 5002 02	

Figure 1

## 1. INTRODUCTION

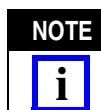
These instructions cover the assembly of the SSMA Straight Cable Plugs listed in Figure 1. Figure 1 also lists the cable types required for the various connectors.

All of these connectors are solder-type connectors.

Tooling required for the application is listed in Figure 2.

TE PART NO.	PREVIOUS PART NO.	DESCRIPTION
1055463-1	2098 5237 10 (T-4579)	Center Contact Holder
1055461-1	2098 5236 02 (T-1888)	Locator Tool

Figure 2



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

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

## 2. ASSEMBLY

### 2.1. Preparing the Coaxial Cable End (Figure 3)

1. Place the heat-shrink tubing and ferrule on the cable.
2. Remove the end portion of the cable jacket to expose the cable braid.

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

### 2.2. Soldering Center Contact to Inner Conductor (Figure 4)

1. Tin the inner conductor
2. Place center contact in center contact holder (see Figure 4)
3. Heat the center contact with a soldering iron and carefully push it over the inner conductor to rest firmly against the dielectric.

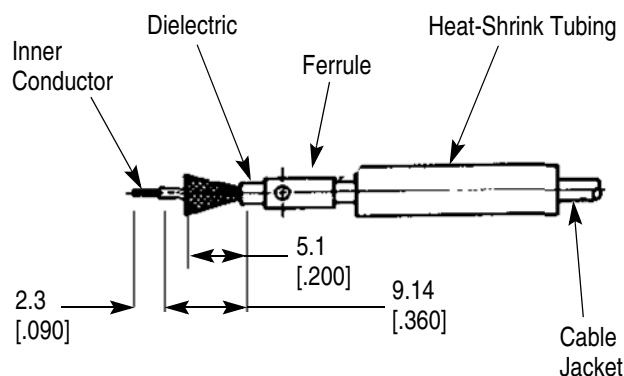


Figure 3

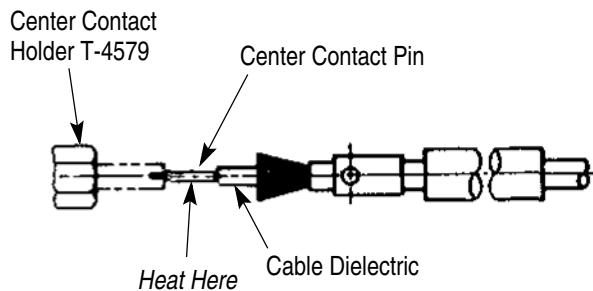


Figure 4

**DANGER**


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

4. Remove the excess solder or splatter.

### 2.3. Soldering Cable Braid to the Housing Subassembly (Figure 5)

1. Secure the locator tool to the threads of the housing subassembly.
2. Position and secure the housing subassembly in a small bench vice.
3. Insert cable into the housing subassembly and seat it firmly.
4. Slide the ferrule over the flared cable braid.
5. Hold the cable firmly seated and solder through the holes in the ferrule.

**DANGER**


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

6. Trim and remove excess cable braid strands.

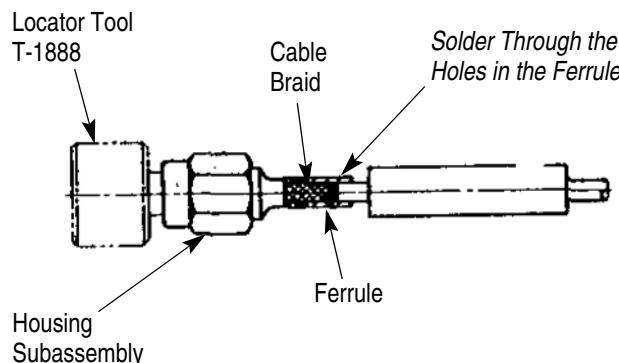


Figure 5

### 2.4. Shrink Heat-Shrink Tubing to the Cable (Figure 6)

1. Position the heat-shrink tubing over the ferrule as shown in Figure 6.

2. Apply indirect heat with a "thermo gun" to shrink the heat-shrink tubing.

3. Remove the locator tool.

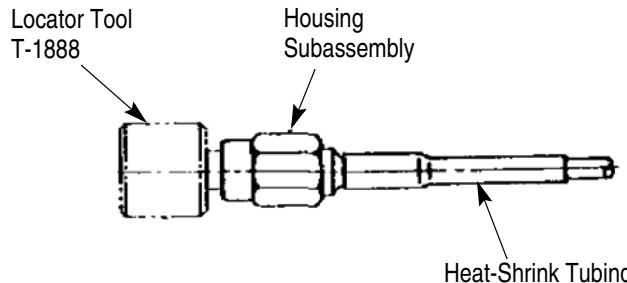


Figure 6

### 2.5. Inspecting the Completed Assembly

Adherence to the assembly steps should yield the dimensions shown in Figure 7.

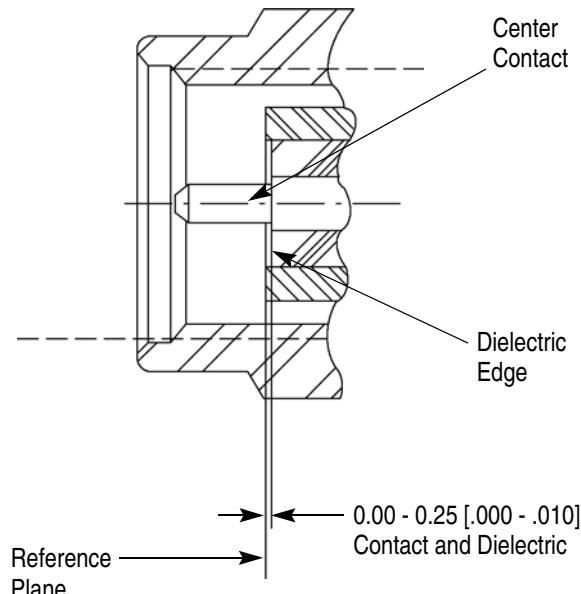


Figure 7

### 3. REVISION SUMMARY

Updated format to current corporate requirements