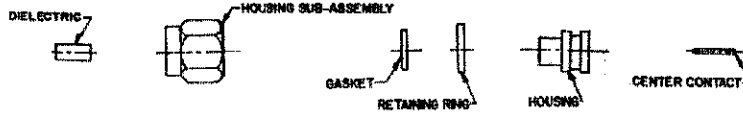


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE PLUG DIRECT SOLDER ATTACHMENT	.085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5206-54(T-4567) CLAMP INSERT: 2098-5208-54(T-4700-2) CENTER CONTACT HOLDER: 2098-5221-10(T-4578) SOLDER GAUGE: 2098-5516-02(T-4662-5) LOCATOR TOOL: 2098-0307-02 DIELECTRIC INSERT TOOL: 2098-0295-02 RETAINING RING PLIERS: 2098-5216-54(T-5702)

CONNECTOR



ASSEMBLY OPERATIONS

<p>1.0 PREPARATION OF CABLE</p> <p>1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #2.</p> <p>1.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.</p> <p>1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.</p> <p>1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.</p> <p>1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR TO DIMENSION SHOWN.</p>	
<p>2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR</p> <p>2.1 TIN INNER CONDUCTOR OF CABLE.</p> <p>2.2 PLACE SOLDER GAUGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.</p> <p>2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAUGE.</p> <p>2.4 REMOVE SOLDER GAUGE AND EXCESS SOLDER.</p>	
<p>3.0 SOLDERING OF CABLE TO HOUSING</p> <p>3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.</p> <p>3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.</p> <p>3.2.1 NEST CENTER CONTACT IN LOCATOR TOOL.</p> <p>3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.</p> <p>3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.</p> <p>3.3 SLIDE HOUSING OVER LOCATOR TOOL.</p> <p>3.4 MAINTAIN POSITION OF HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.</p> <p>NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.</p>	
<p>4.0 SECURE COUPLING NUT TO HOUSING</p> <p>4.1 PLACE RETAINING RING AND GASKET ON HOUSING COMPRESS RETAINING RING WITH RETAINING RING PLIERS.</p> <p>4.3 PUSH COUPLING NUT ONTO HOUSING AND RETAINING RING.</p> <p>4.4 COUPLING NUT SHOULD ROTATE FREELY.</p>	
<p>5.0 PRESSING OF DIELECTRIC BUSHING INTO HOUSING SUB-ASSEMBLY</p> <p>5.1 THREAD INSERT TOOL INTO HOUSING SUB-ASSEMBLY.</p> <p>5.2 INSERT DIELECTRIC INTO INSERT TOOL HOUSING.</p> <p>5.3 PLACE INSERT TOOL PLUNGER INTO POSITION AND PRESS UNTIL FLANGE BOTTOMS ON TOOL HOUSING.</p> <p>5.4 ASSEMBLY IS NOW COMPLETE.</p>	
<p>6.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY.</p> <p>6.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.</p>	