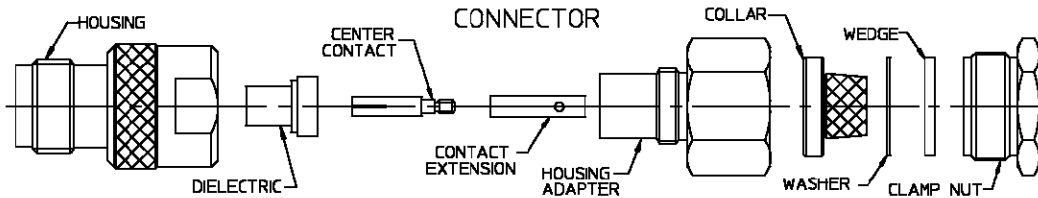
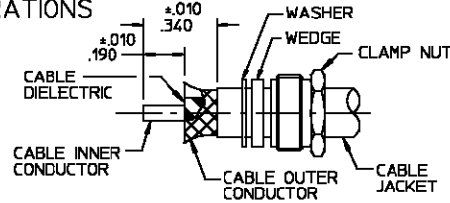


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OST STRAIGHT CABLE JACK CLAMP ATTACHMENT	RG214/U, 225	TORQUE WRENCH: 2098-0324-54

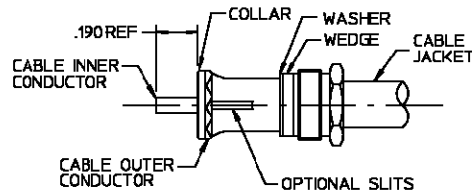


### ASSEMBLY OPERATIONS

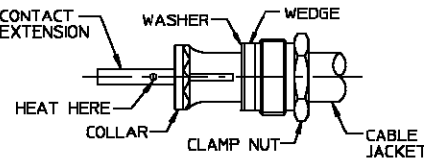
- 1.0 PREPARE CABLE END
- 1.1 PLACE CLAMP NUT, WEDGE (SMALL OPENING FIRST) AND WASHER ON CABLE.
  - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
  - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
  - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
  - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
  - 1.6 FLARE OUTER CONDUCTOR.



- 2.0 ASSEMBLY OF COLLAR
- 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 SLIDE COLLAR OVER CABLE DIELECTRIC AND UNDER CABLE OUTER CONDUCTOR UNTIL CABLE DIELECTRIC IS FLUSH WITH FACE OF COLLAR.
  - 2.3 TRIM CABLE OUTER CONDUCTOR FLUSH WITH THE FACE OF THE COLLAR.

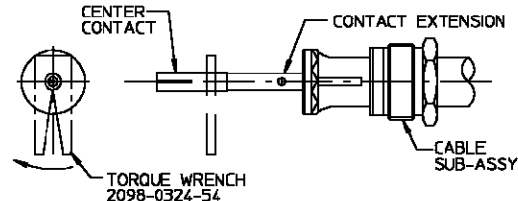


OPTIONAL: TWO (2) SLITS .250 LONG X 180° APART MAY BE CUT IN JACKET TO EASE ASSEMBLY

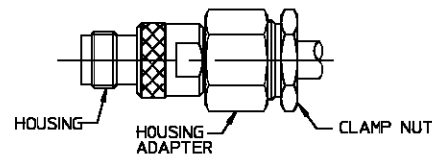


- 3.0 SOLDERING OF CONTACT EXTENSION TO CABLE INNER CONDUCTOR
- 3.1 HEAT CONTACT EXTENSION AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.
  - 3.2 REMOVE EXCESS SOLDER

- 4.0 ASSEMBLE CENTER CONTACT INTO CONTACT EXTENSION
- 4.1 APPLY A FEW DROPS OF SILVER CONDUCTIVE EPOXY TO BACK OF THREADS OF CENTER CONTACT  
NOTE: DO NOT USE LOCTITE
  - 4.2 SCREW CENTER CONTACT INTO CONTACT EXTENSION
  - 4.3 PLACE TORQUE WRENCH OVER CENTER CONTACT AND TIGHTEN UNTIL TORQUE WRENCH LOSES GRIP AND SLIPS FREELY AROUND CENTER CONTACT SURFACE
  - 4.4 WIPE ANY EXCESS EPOXY FROM CONTACT SURFACES



- 5.0 ASSEMBLE DIELECTRIC & SECURE HOUSING TO CLAMP NUT
- 5.1 ASSEMBLE DIELECTRIC, SMALL DIA END FIRST, INTO HOUSING.
  - 5.2 SCREW HOUSING ADAPTER INTO HOUSING.
  - 5.3 CAREFULLY INSERT CENTER CONTACT INTO THE DIELECTRIC BUSHING I.D.
  - 5.4 ENGAGE THREADS OF CLAMP NUT TO HOUSING AND TORQUE TO 25-30 IN-LBS.



- 6.0 INSPECTION OF COMPLETED ASSY
- 6.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

