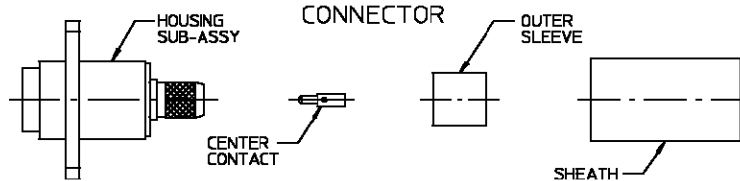
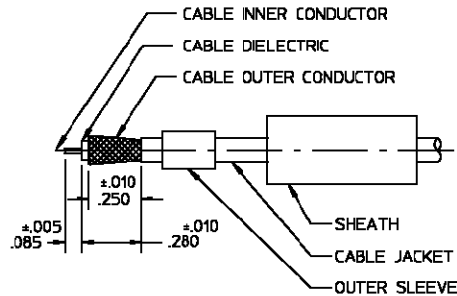


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSP FLOATING 2 HOLE FLANGE MOUNT CABLE JACK - CRIMP ATTACHMENT	ADAMS RUSSELL FE19ST	CRIMP TOOL: 5698-5014-54 (T-4718) CRIMP DIE: 5698-5015-54 (T-4702-1) DIE NO. B

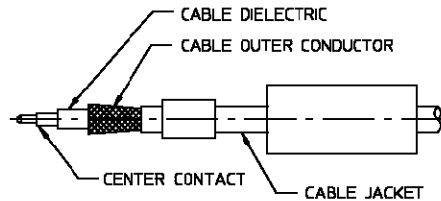


ASSEMBLY OPERATIONS

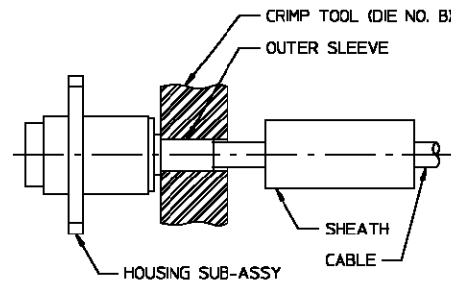
1. PREPARE COAXIAL CABLE END.
 - 1.1 PLACE OUTER SLEEVE AND SHEATH ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



2. SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.
 - 2.1 TIN INNER CONDUCTOR OF CABLE.
 - 2.2 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT WITH SOLDERING IRON AND PUSH IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST CABLE DIELECTRIC.
 - 2.3 REMOVE EXCESS SOLDER OR SPLATTER.



3. CRIMPING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY.
 - 3.1 BEING SURE THAT THE CENTER CONTACT ENTERS THE PRE-ASSEMBLED HOUSING CONTACT, INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT CABLE FIRMLY.
 - 3.2 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 3.3 CRIMP OUTER SLEEVE IN PLACE.
 - 3.4 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



4. SHRINK SHEATH TO CABLE
 - 4.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
 - 4.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.
 - 4.3 ASSEMBLY IS NOW COMPLETE.

