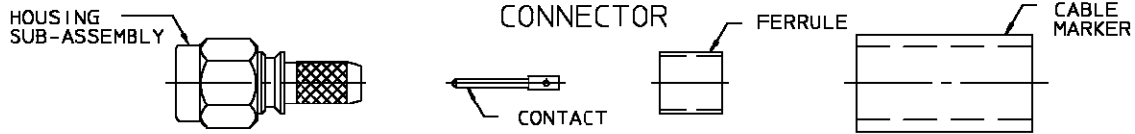
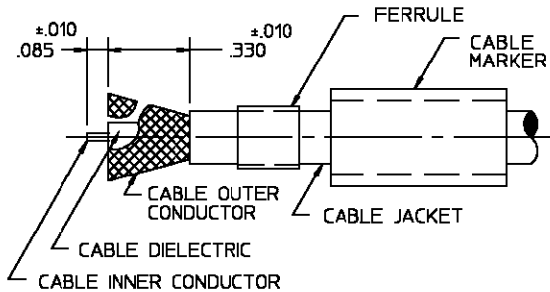


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSM STRAIGHT CABLE PLUG CRIMP ATTACHMENT	RG-55/U RG-142/U RG-223/U RG-400/U	CENTER CONTACT HOLDER: 2098-5221-10 CRIMP TOOL: 2098-0105-54 (DIE No. B) LOCATOR TOOL: 2098-5218-02

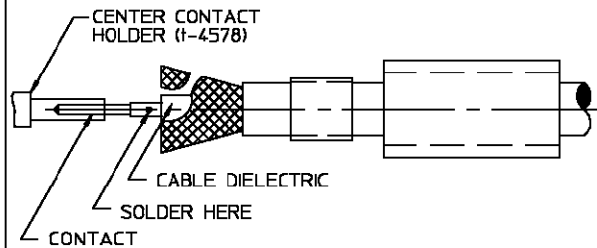


ASSEMBLY OPERATIONS

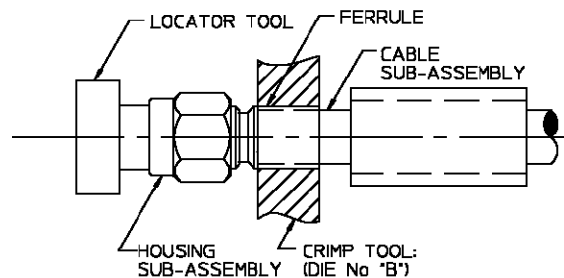
- 1.0 PREPARE COAXIAL CABLE END.
 - 1.1 PLACE CABLE MARKER AND FERRULE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



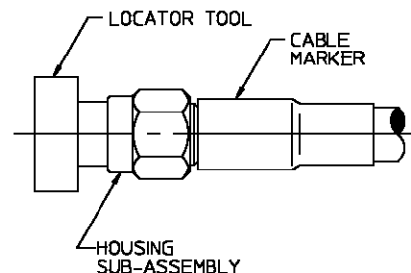
- 2.0 SOLDER CENTER CONTACT TO CABLE INNER CONDUCTOR.
 - 2.1 TIN INNER CONDUCTOR.
 - 2.2 PLACE CENTER CONTACT IN HOLDER.
 - 2.3 HEAT CENTER CONTACT WITH SOLDERING IRON AND CAREFULLY PUSH IT OVER THE INNER CONDUCTOR TO REST FIRMLY AGAINST THE CABLE DIELECTRIC.
 - 2.4 REMOVE EXCESS SOLDER OR SPLATTER.



- 3.0 CRIMP FERRULE TO CABLE.
 - 3.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
 - 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 3.3 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
 - 3.4 SLIDE FERRULE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 3.5 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 4.0 SHRINK CABLE MARKER TO CABLE.
 - 4.1 POSITION CABLE MARKER OVER OUTER SLEEVE AS SHOWN.
 - 4.2 APPLY INDIRECT HEAT WITH A THERMO GUN TO SHRINK CABLE MARKER.
 - 4.3 REMOVE LOCATOR TOOL.



5.0 INSPECT COMPLETED ASSEMBLY.
5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN
SHOULD YIELD TOLERANCES SHOWN.

