

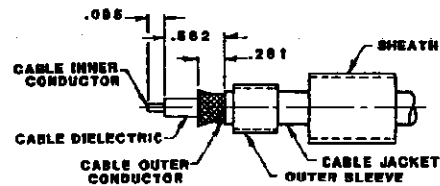
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSSM STRAIGHT CABLE PLUG CRIMP ATTACHMENT	RG 174/U, 179, 187, 188, 316	CENTER CONTACT HOLDER-2098-5237-10(T-457)@ CRIMP TOOL-2098-0105-84 DIE N/C

CONNECTOR

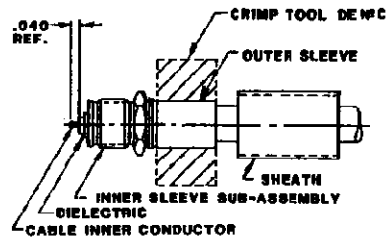


ASSEMBLY OPERATIONS

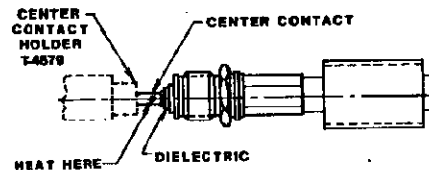
- 1.0 PREPARE COAXIAL CABLE END.**
- 1.1 PLACE SHEATH AND SLEEVE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



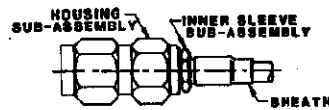
- 2.0 CRIMP CABLE TO INNER SLEEVE SUB-ASSEMBLY.**
- 2.1 TIN INNER CONDUCTOR.
 - 2.2 POSITION AND SECURE INNER SLEEVE SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 2.3 INSERT CABLE INTO INNER SLEEVE SUB-ASSEMBLY AND SEAT FIRMLY.
 - 2.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 2.5 HOLD CABLE FIRMLY SEATED AND CRIMP OUTER SLEEVE IN PLACE.
 - 2.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 3.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.**
- 3.1 PLACE CENTER CONTACT IN HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE WITH THE LARGE DIAMETER OF CONTACT RESTING FIRMLY AGAINST DIELECTRIC.
 - 3.2 REMOVE EXCESS SOLDER.



- 4.0 SECURE HOUSING SUB-ASSEMBLY TO INNER SLEEVE SUB-ASSEMBLY AND SHRINK SHEATH.**
- 4.1 ASSEMBLE DIELECTRIC OVER CENTER CONTACT.
 - 4.2 ENGAGE THREADS OF INNER SLEEVE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY AND TORQUE TO 25-30 IN. LBS.
 - 4.3 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
 - 4.4 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.



- 5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY**
- 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

