

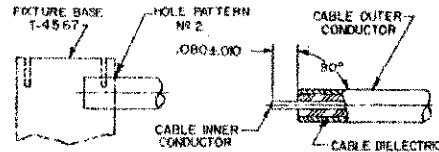
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT	085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE T-2098-5208-54 (T-4567) CLAMP INSERT T-2098-5208-54 (T-4700-2) CENTER CONTACT HOLDER T-2098-5221-10 (T-4578) SOLDER GAGE T-2098-5212-02 (T-4562-1) LOCATOR TOOL T-2098-5210-02 (T-4569) DIELECTRIC INSERT TOOL T-2098-5215-02 (T-4561)

CONNECTOR

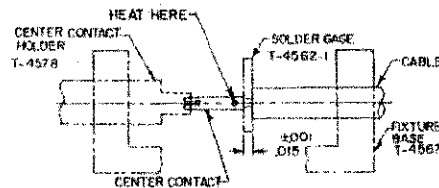


ASSEMBLY OPERATIONS

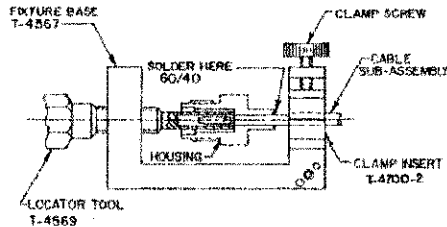
- 1.0 PREPARATION OF CABLE
- 1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN 12.
 - 1.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
 - 1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.
 - 1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.
 - 1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR TO DIMENSION SHOWN.



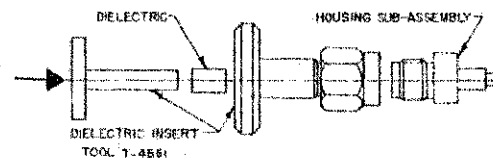
- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR
- 2.1 TIN INNER CONDUCTOR OF CABLE.
 - 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR. FLUSH WITH END OF OUTER CONDUCTOR.
 - 2.3 PLACE CENTER CONTACT IN HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.
 - 2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER.



- 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO HOUSING
- 3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.
 - 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 3.2.1 REST CENTER CONTACT IN LOCATOR TOOL.
 - 3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
 - 3.3 SLIDE HOUSING OVER LOCATOR TOOL.
 - 3.4 MAINTAIN POSITION OF HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.
- NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.



- 4.0 PRESSING OF DIELECTRIC BUSHING INTO HOUSING SUB-ASSEMBLY
- 4.1 THREAD INSERT TOOL ONTO HOUSING SUB-ASSEMBLY.
 - 4.2 INSERT DIELECTRIC INTO INSERT TOOL HOUSING.
 - 4.3 PLACE INSERT TOOL PLUNGER INTO POSITION AND PRESS UNTIL FLANGE BOTTOMS ON TOOL HOUSING.
 - 4.4 ASSEMBLY IS NOW COMPLETE.



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

