CONNECTOR TYPE

27.0 GH OSM BULKHEAD FEEDTHROUGH CABLE JACK, DIRECT SOLDER ATTACHMENT

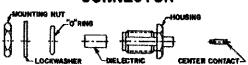
CABLE TYPE

.141 SEMI-RIGID COAXIAL CABLE

TOOLS REQUIRED:

FIXTURE BASE:2098-5206-54(T-4567) CLAMP INSERT: 2098-5207-54(T-4700-I) CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) SOLDER GAGE: 2098-5516-02(T-4562-5) LOCATOR TOOL:2798-5003-02 DELECTRIC INSERT TOOL:2798-5002-02

CONNECTOR



ASSEMBLY OPERATIONS

- 1.0 PREPARATION OF CABLE

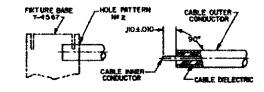
 1.1 INSERT SQUARED CABLE END INTO FIXTURE
 BASE HOLE PATTERN \$2.

 1.2 FLACE SAN 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.

 1.4 DAME INNER CONDUCTOR BY PRYING CUT OUTER
 CONDUCTOR AND DIELECTRIC FROM CABLE.



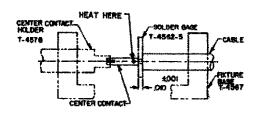
- 2 2.0
- SCIDERING OF CENTER CONTACT TO CABLE INNER COMDUCTOR.

 I'N INNER CONDUCTOR OF CABLE.

 PLACE SOLDER GAGE ON INNER CONDUCTOR.

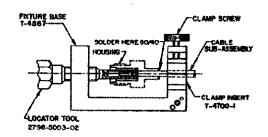
 FLUSH WITH EMD OF DUTER CONDUCTOR.

 PLACE CENTER CONTACT IN HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE. FOLDER GAGE, REMOVE SOLDER GAGE AND EXCESS SOLDER.



- 3.0 SOLDERING OF CASLE TO HOUSING
 3.1 PLACE CONNECTOR HOUSING DN END OF CABLE
 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 3.2.1 NEST CABLE END IN LOCATOR TOOL.
 3.2.2 TIGHTEN CLAMP SCREN TO SECURE CABLE.
 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FEBRLY. FIRMLY.
 - FIRMLY.

 SLIDE HOUSING AGAINST LOCATOR TOOL.
 MAINTAIN POSITION OF HOUSING FIRMLY
 AGAINST LOCATOR TOOL AND SOLDER.
 OTE: FIXTURE SHOULD BE CLAMPED VERTICALLY
 IN VISE TO KEEP HOUSING SEATED
 AGAINST LOCATOR TOOL.

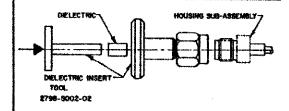


- PRESSING OF BIELECTRIC BUSHING INTO HOUSING SUB-ASSEMBLY THREAD INSERT TOOL ONTO HOUSING SUB-
- ASSEMBLY.
- ASSEMBLY.

 INSERT DIELECTRIC INTO INSERT TOOL HOUSING.

 PLACE INSERT TOOL PLUNGER INTO POSITION

 AND PRESS UNTIL FLANGE BOTTOMS ON TOOL
- HOUSING. ASSEMBLY IS NOW COMPLETE.



IMSPECTION OF COMPLETED CONNECTOR ASSEMBLY
I ADMERENCE TO STEPS GIVEN WILL YIELD
TOLERANCES SHOWN.

