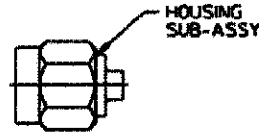


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSM STRAIGHT CABLE PLUG DIRECT SOLDER ATTACHMENT	.085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5208-54 (T-4567) CLAMP INSERT: 2098-5208-54 (T-4700-2) LOCATOR TOOL: 2098-5218-021T-2367

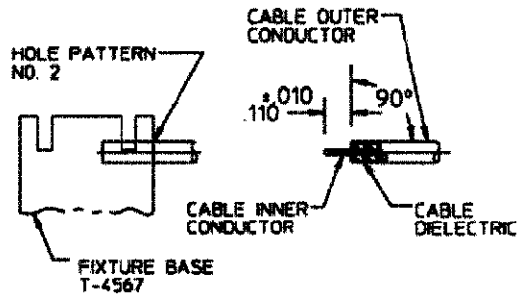
CONNECTOR



ASSEMBLY OPERATIONS

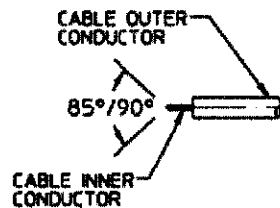
1.0 PREPARATION OF CABLE

- 1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #2.
- 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.



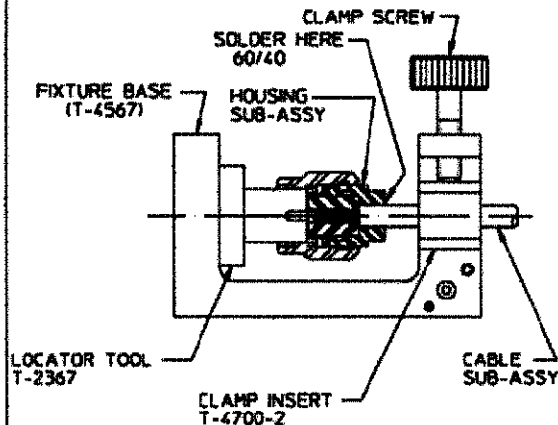
2.0 SHAPE INNER CONDUCTOR OF CABLE

- 2.1 TRIM INNER CONDUCTOR TO LENGTH AS SHOWN.
- 2.2 FILE BLUNT END OF INNER CONDUCTOR TO AN 85° - 90° CONE.



3.0 SOLDERING OF CABLE TO HOUSING

- 3.1 SCREW HOUSING ASSEMBLY ONTO LOCATOR TOOL.
- 3.2 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE-ASSEMBLED CENTER CONTACT OF HOUSING ASSEMBLY.
- 3.3 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 3.3.1 BOTTOM LOCATOR TOOL AGAINST FIXTURE BASE AS SHOWN.
 - 3.3.2 MAINTAINING PRESSURE ON CABLE TO KEEP LOCATOR TOOL BOTTOMED, TIGHTEN CLAMP SCREW TO SECURE CABLE.
- 3.4 SOLDER CABLE TO HOUSING



NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE (SO THAT CONNECTOR INTERFACE IS FACING DOWN).