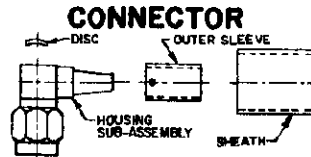
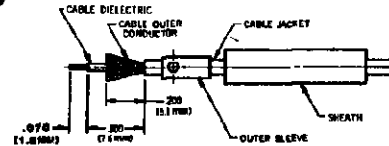


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSSM RIGHT ANGLE CABLE PLUG SOLDER ATTACHMENT	R6174/UJ79 1B7, 1B8, 3 16	LOCATOR TOOL: 2098-5236-02 (T-1888)

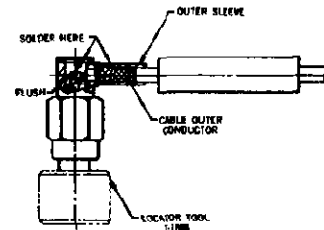


## ASSEMBLY OPERATIONS

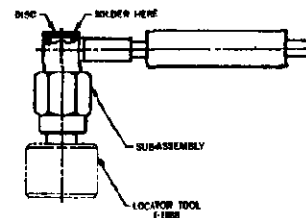
- 1.0 PREPARE COAXIAL CABLE END**
- 1.1 PLACE SHEATH AND OUTER SLEEVE ON CABLE.
  - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
  - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
  - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
  - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
  - 1.6 FLARE OUTER CONDUCTOR.



- 2.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY**
- 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
  - 2.3 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
  - 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AS SHOWN.
  - 2.5 PLACE SOLDERING IRON ON CONTACT & SOLDER.
  - 2.6 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR AND SOLDER AS SHOWN.



- 3.0 SEAL OPENING IN HOUSING**
- 3.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY
- OPTION 1:** TIN PERIMETER OF OPENING AND PRESS DISC INTO POSITION; APPLY HEAT TO CAP, DO NOT ALLOW SOLDER TO PENETRATE HOUSING.
- OPTION 2:** DISC MAY BE EPOXIED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.



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

