

CONNECTOR TYPE

OSCS PANEL FEEDTHROUGH
 HERMETIC JACK RECEPTACLE
 COMPRESSION SEAL KNIFE EDGE

TOOLS REQUIRED:

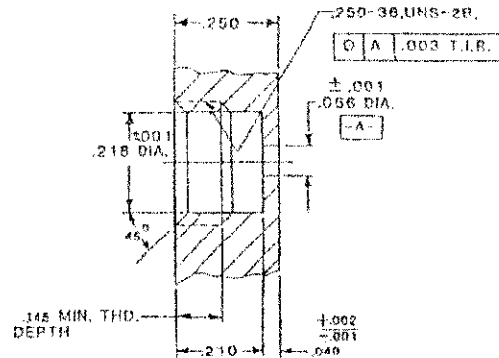
.250-36 UNS-2B BOTTOMING TAP: 2098-5618-54
 STEP REAMER: 2098-0442-54
 TORQUE TOOL: 2098-0248-54

CONNECTOR



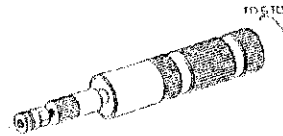
ASSEMBLY OPERATIONS

- 1.0 MOUNTING HOLE PREPARATION
- 1.1 DRILL $.056 \pm .001$ DIAMETER HOLE THROUGH PANEL.
 - 1.2 INSERT STEP REAMER INTO PILOT HOLE AND REAM TO DEPTH SHOWN.
 - 1.3 TAP $.250-36$ THREAD TO DEPTH SHOWN.



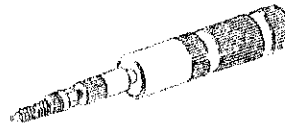
STEP: 1

WITH ONE HAND HOLDING THE COLLET AND THE OTHER HAND ON THE HANDLE, TURN THE HANDLE CLOCKWISE IN REFERENCE TO THE COLLET UNTIL IT STOPS, THEN TURN THE HANDLE COUNTERCLOCKWISE TO APPROXIMATELY $\frac{1}{4}$ TO $\frac{3}{4}$ OF A COMPLETE TURN.



STEP: 2

WITH ONE HAND HOLDING THE COLLET, THREAD THE CONNECTOR ALL THE WAY INTO THE TOOL UNTIL IT BOTTOMS INSIDE. HARD TIGHTEN THE CONNECTOR.



STEP: 3

THREAD THE CONNECTOR INTO THE MIC HOUSING USING THE HANDLE OF THE TOOL, TURNING CLOCKWISE UNTIL THE TORQUE ON THE HANDLE OF THE TOOL RELEASES (TORQUE ADJUSTED TO 25 ± 2 INCH POUNDS).



STEP: 4

RELEASE THE TOOL FROM THE CONNECTOR BY TURNING THE HANDLE COUNTERCLOCKWISE. THE CONNECTOR IS NOW PROPERLY INSTALLED.

NOTE: THE PROCEDURE GENERALLY WORKS IN MOST MIC HOUSINGS. IF FOR SOME REASON THE COLLET DOES NOT RELEASE THE CONNECTOR, USE A $\frac{3}{8}$ " OPEN WRENCH TO HOLD THE FRONT COLLET THEN TURN THE HANDLE OF THE TOOL COUNTERCLOCKWISE.

