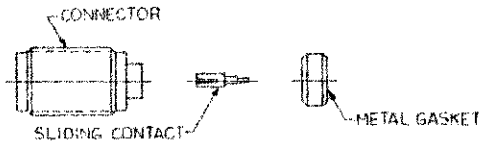


CONNECTOR TYPE

OSM
PANEL FEEDTHROUGH HERMETIC JACK
RECEPTACLE WITH METAL GASKET AND
SLIDING CONTACT.

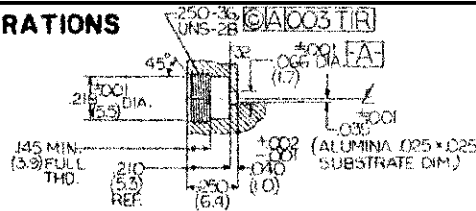
TOOLS REQUIRED:

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

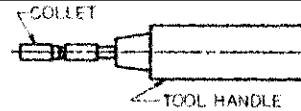


ASSEMBLY OPERATIONS

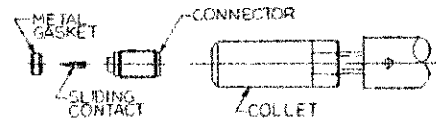
- 1.0 MOUNTING HOLE PREPARATION
- 1.1 DRILL .066 ±.001 DIA THRU PANEL.
- 1.2 INSERT STEP REAMER INTO PILOT HOLE AND REAM TO DEPTH SHOWN.
- 1.3 TAP .250 - 36 THREAD TO DEPTH SHOWN.
- 1.4 COUNTERSINK THREADS.



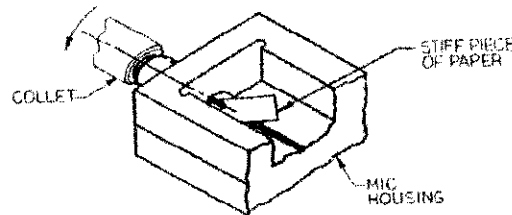
- 2.0 ADJUST TORQUE WRENCH
- 2.1 WITH ONE HAND HOLDING THE COLLET AND THE OTHER HAND ON THE HANDLE, TURN THE HANDLE CLOCKWISE IN REFERENCE TO THE COLLET UNTIL IT STOPS.



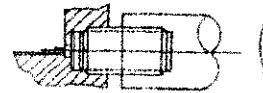
- 3.0 ASSEMBLE CONNECTOR INTO TORQUE TOOL
- 3.1 WITH ONE HAND HOLDING THE COLLET, THREAD THE CONNECTOR ALL THE WAY INTO THE TOOL UNTIL IT BOTTOMS INSIDE. HAND TIGHTEN THE CONNECTOR.
- 3.2 ASSEMBLE CONTACT INTO CONNECTOR, UNTIL THE CONTACT BOTTOMS AGAINST THE GLASS.
- 3.3 ASSEMBLE METAL GASKET ONTO CONNECTOR.



- 4.0 INSTALLATION OF CONNECTOR
- 4.1 THREAD THE CONNECTOR INTO THE MIC HOUSING USING THE HANDLE OF THE TOOL. USE STIFF PIECE OF PAPER TO PREVENT CONTACT FROM DAMAGE WHEN SCREWING CONNECTOR AND CONTACT IN PLACE. TURN TOOL HANDLE CLOCKWISE UNTIL THE TORQUE ON THE HANDLE OF THE TOOL RELEASES (TORQUE ADJUSTED TO 25 ± 2 INCH POUNDS).



- 5.0 RELEASE TOOL FROM CONNECTOR
- 5.1 RELEASE THE TOOL FROM THE CONNECTOR BY USING A 3/8" OPEN WRENCH TO HOLD THE FRONT COLLET THEN TURN THE HANDLE OF THE TOOL COUNTER-CLOCKWISE.



- 6.0 ADJUST CONTACT
- 6.1 USE TWEEZERS TO PULL CONTACT (.028 DIA) FLUSH AGAINST SUBSTRATE (ALUMINA .025 x .025)
- 6.2 CONTACT SHOULD BE CENTERED ON SUBSTRATE.
- 6.3 REMOVE PAPER.
- 6.4 CONNECTOR IS NOW PROPERLY INSTALLED.

