

CONNECTOR TYPE 27.0GH OSM BULKHEAD FEEDTHROUGH CABLE JACK, DIRECT SOLDER ATTACHMENT	CABLE TYPE .141 SEMI-RIGID COAXIAL CABLE	TOOLS REQUIRED: FIXTURE BASE:2098-5208-54(T-4567) CLAMP INSERT:2098-5207-54(T-4700-1) CENTER CONTACT HOLDER:2098-5221-10 (T-4578) SOLDER GAGE:2098-5516-02(T-4562-5) LOCATOR TOOL:2798-5003-02 DIELECTRIC INSERT TOOL:2798-5002-02
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CONNECTOR



ASSEMBLY OPERATIONS

<p>1.0 PREPARATION OF CABLE</p> <ol style="list-style-type: none"> 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. 1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE. 1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE. 	
<p>2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR</p> <ol style="list-style-type: none"> 2.1 TIN INNER CONDUCTOR OF CABLE. 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR. 2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE. 2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER. 	
<p>3.0 SOLDERING OF CABLE TO HOUSING</p> <ol style="list-style-type: none"> 3.1 PLACE CONNECTOR HOUSING ON 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 SCREW TO SECURE CABLE. 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY. 3.3 SLIDE HOUSING AGAINST LOCATOR TOOL. 3.4 MAINTAIN POSITION OF HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER. <p>NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.</p>	
<p>4.0 PRESSING OF DIELECTRIC BUSHING INTO HOUSING SUB-ASSEMBLY</p> <ol style="list-style-type: none"> 4.1 THREAD INSERT TOOL ONTO HOUSING SUB-ASSEMBLY. 4.2 INSERT DIELECTRIC INTO INSERT TOOL HOUSING. 4.3 PLACE INSERT TOOL PLUNGER INTO POSITION AND PRESS UNTIL FLANGE BOTTOMS ON TOOL HOUSING. 4.4 ASSEMBLY IS NOW COMPLETE. 	
<p>5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY</p> <ol style="list-style-type: none"> 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN. 	