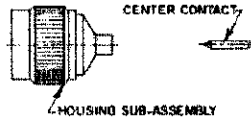


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSN STRAIGHT CABLE PLUG DIRECT SOLDER ATTACHMENT	RG405/U .086 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5208-54(T-4567) CLAMP INSERT: 2098-5208-54(T-4700-2) CENTER CONTACT HOLDER: 2098-5277-10(T-4581) LOCATOR TOOL: 2098-5275-02(T-4571)

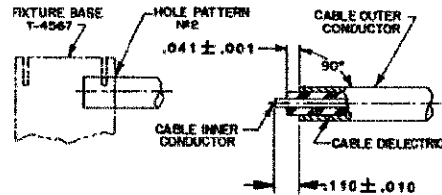
## CONNECTOR



## ASSEMBLY OPERATIONS

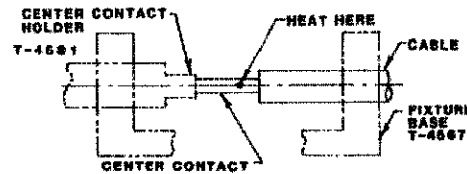
### 1.0 PREPARATION OF CABLE

- 1.1 INSERT SQUARED CABLE END INTO CABLE CUTTER AND CUT THROUGH CABLE OUTER CONDUCTOR.
- 1.2 REMOVE CUT OUTER CONDUCTOR FROM CABLE.
- 1.3 FINISH CUTTING CABLE DIELECTRIC WITH CUTTING BLADE.
- 1.4 TRIM CABLE INNER CONDUCTOR TO DIMENSION SHOWN.  
CAUTION: REMOVE ALL BURRS BETWEEN CABLE OUTER CONDUCTOR AND CABLE DIELECTRIC.



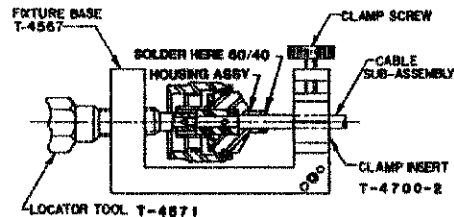
### 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.

- 2.1 TIN INNER CONDUCTOR OF CABLE
- 2.2 PLACE CENTER CONTACT IN HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.
- 2.3 REMOVE EXCESS SOLDER.



### 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO HOUSING

- 3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.
- 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
  - 3.2.1 NEST CENTER CONTACT IN LOCATOR TOOL.
  - 3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
  - 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
- 3.3 SOLDER CABLE TO HOUSING SUB-ASSEMBLY AS SHOWN.



### 4.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY

- 4.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

