

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OST STRAIGHT CABLE PLUG DIRECT SOLDER ATTACHMENT	.085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE 2098-5208-54(T-4567) CLAMP INSERTS:2098-5208-54(T-4700-2) CENTER CONTACT HOLDER:2098-5278-10(T-4560) SOLDER GAGE:2098-5281-02 (T-4562-6) LOCATOR TOOL: 2098-5810-02

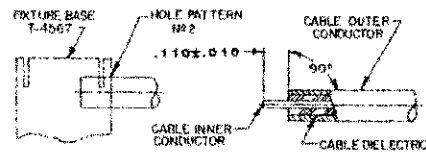
CONNECTOR



ASSEMBLY OPERATIONS

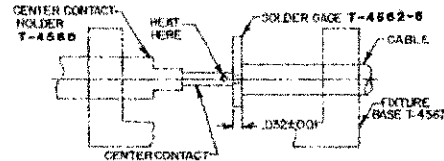
1.0 PREPARATION OF CABLE

- 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 OUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.



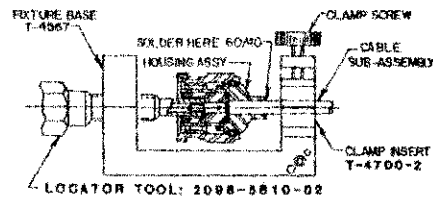
2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

- 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.



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 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 3.2.2 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
- 3.3 SOLDER CABLE TO HOUSING SUB-ASSEMBLY AS SHOWN.



NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE.

4.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY

- 4.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

