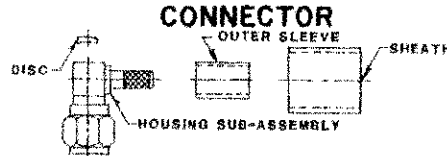
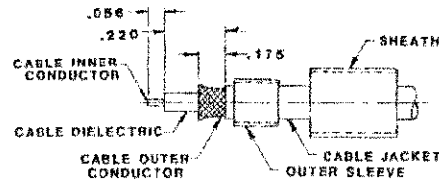


| CONNECTOR TYPE | CABLE TYPE | TOOLS REQUIRED: |
|---|-------------|--|
| OSMM RIGHT ANGLE CABLE PLUG CRIMP ATTACHMENT | RG178/U,196 | LOCATOR TOOL:4098-5015-02 CRIMP TOOL:2098-0105-54 DENMA |

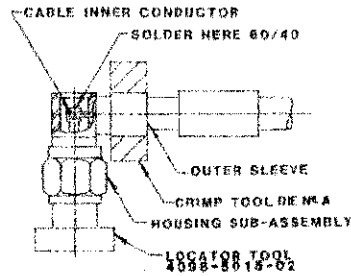


ASSEMBLY OPERATIONS

- 1.0 PREPARE COAXIAL CABLE END.
- 1.1 PLACE SHEATH AND SLEEVE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.

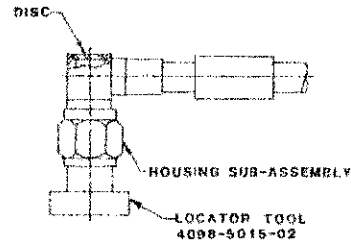


- 2.0 SOLDERING OF CABLE INNER CONDUCTOR TO HOUSING SUB-ASSEMBLY.
- 2.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
 - 2.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 2.3 TIN INNER CONDUCTOR OF CABLE.
 - 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY.
 - 2.4.1 NEST INNER CONDUCTOR IN CONTACT SLOT
 - 2.4.2 HOLD DIELECTRIC FLUSH AS SHOWN.
 - 2.5 PLACE SOLDERING IRON ON TIP OF CONTACT AND SOLDER.



- 3.0 CRIMPING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY.
- 3.1 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 3.2 CRIMP OUTER SLEEVE IN PLACE.
 - 3.3 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.

- 4.0 SEAL OPENING IN HOUSING
- 4.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY.
- OPTION 1: TIN PERIMETER OF OPENING AND PRESS DISC INTO POSITION; APPLY HEAT TO CAP; DO NOT ALLOW SOLDER TO PENETRATE HOUSING.
- OPTION 2: DISC MAY BE EPOXIED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.



- 5.0 SHRINK SHEATH TO CABLE
- 5.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
 - 5.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.
 - 5.3 REMOVE LOCATOR.
 - 5.4 ASSEMBLY IS NOW COMPLETE.

