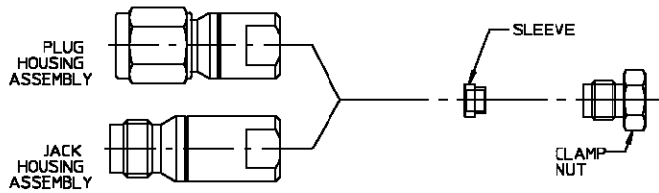


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OS-50 STRAIGHT CABLE CONNECTORS SOLDER CLAMP ATTACHMENT	.085 S/R COAXIAL CABLE	FIXTURE BASE: 2098-5206-54 CLAMP INSERT: 2098-5208-54 INTERFACE LOCATING TOOL: 2598-5110-02 METAL FILE, SOLDER (60/40), FLUX, CLEANING ALCOHOL, RAZOR BLADE

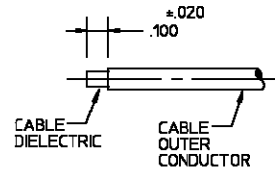
CONNECTOR



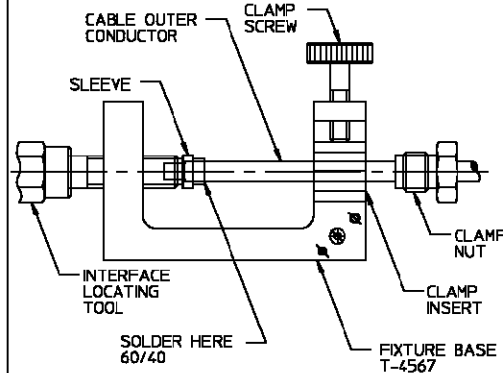
NOTE: THIS AP CAN BE USED FOR FLANGE MOUNT AND BULKHEAD FEEDTHRU CONNECTORS ALSO.

ASSEMBLY OPERATIONS

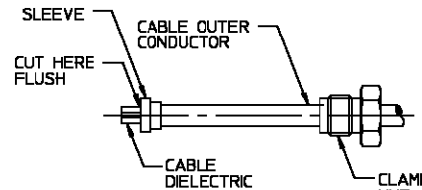
- 1.0 PREPARATION OF COAXIAL CABLE:
1.1 CUT CABLE TO DESIRED LENGTH.
1.2 TRIM END OF CABLE TO DIMENSION SHOWN TO EXPOSE CABLE DIELECTRIC.
1.3 REMOVE BURRS AND CLEAN WITH ALCOHOL.



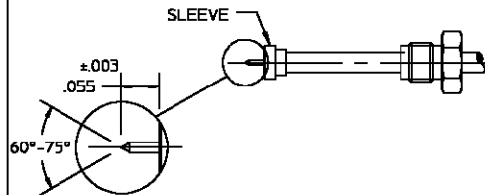
- 2.0 SOLDERING OF SLEEVE TO CABLE:
2.1 PLACE THE CLAMP NUT ON CABLE WITH EXTERIOR THREAD FACING TOWARD THE CUT END OF THE CABLE.
2.2 PLACE THE SLEEVE ON THE CABLE WITH THE LARGER DIAMETER OF THE SLEEVE CLOSEST TO THE CABLE END. PUSH SLEEVE UNTIL FIRMLY SEATED AGAINST THE CABLE.
2.3 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
2.3.1 NEST EXPOSED DIELECTRIC INTO INTERFACE LOCATING TOOL, BOTTOMING SLEEVE AGAINST LOCATOR TOOL AS SHOWN.
2.3.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
2.3.3 ENSURE LOCATOR TOOL IS FIRMLY SEATED AGAINST THE SLEEVE.
2.4 MAINTAIN POSITION OF SLEEVE AGAINST LOCATOR TOOL AND APPLY A SMALL AMOUNT OF FLUX AROUND THE CABLE/SLEEVE JUNCTION. APPLY ONLY ENOUGH SOLDER TO FIRMLY ATTACH THE SLEEVE TO THE CABLE.
2.5 VERIFY THAT NO VOIDS EXIST AT EITHER END OF SLEEVE.
2.6 REMOVE EXCESS SOLDER OR SPLATTER.



- 3.0 TRIMMING CABLE DIELECTRIC.
3.1 PLACE CUTTING BLADE FLUSH WITH SLEEVE FACE AND CUT THROUGH THE DIELECTRIC WHILE ROTATING THE CABLE. A CUTTING OR SLICING MOTION WILL WORK EASIER THAN A SAWING MOTION.
3.2 FINISH CUTTING DIELECTRIC WITH CUTTING BLADE TAKING CARE NOT TO SCORE THE CENTER CONDUCTOR OF CABLE. BARE INNER CONDUCTOR BY PRYING THE DIELECTRIC FROM THE CABLE.



- 5.0 TRIM END OF CLAMP ASSEMBLY.
5.1 CUT EXPOSED CENTER CONDUCTOR TO DIMENSION SHOWN.
5.2 FILE BLUNT END OF INNER CONDUCTOR TO A 60°-75° CONE AS SHOWN, MAINTAINING $.055 \pm .003$ DIMENSION.
5.3 CLEAN WITH ALCOHOL.



- 5.0 SECURE HOUSING ASSEMBLY TO CABLE ASSEMBLY.
5.1 INSERT THE CABLE SUB-ASSY INTO THE HOUSING SO THAT THE CABLE CENTER CONDUCTOR IS ACCEPTED BY THE CONTACT IN THE CONNECTOR.
5.2 HOLDING THE CABLE STEADY, SLIDE NUT FORWARD AS SHOWN.
5.3 ENGAGE THREADS OF NUT TO HOUSING ASSEMBLY AND TORQUE TO 25 in.-lbs.

