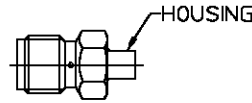


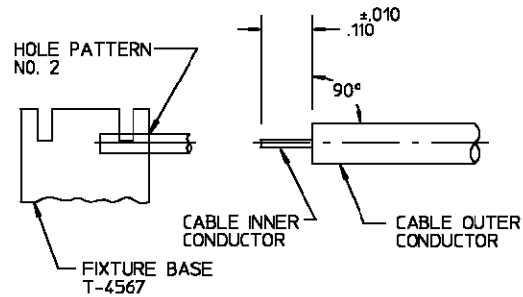
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT	.085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5206-54(T-4567) LOCATOR TOOL: 2098-5625-02(T-948) CLAMP INSERTS: 2098-5208-54(T-4700-2)

CONNECTOR

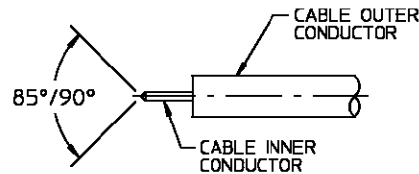


ASSEMBLY OPERATIONS

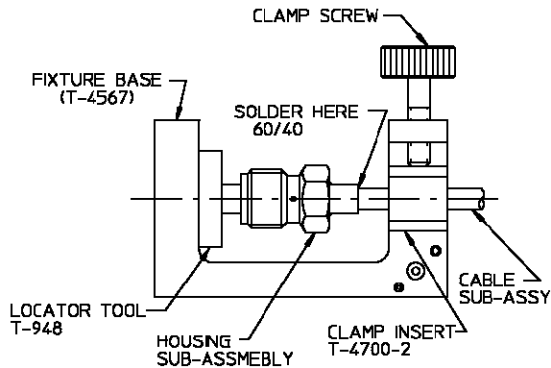
- 1.0 PREPERATION OF CABLE.
 - 1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #2.
 - 1.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
 - 1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.
 - 1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE
 - 1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR TO DIMENSION SHOWN.



- 2.0 SHAPE INNER CONDUCTOR OF CABLE
 - 2.1 TRIM INNER CONDUCTOR TO LENGTH AS SHOW.
 - 2.2 FILE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° CONE.



- 3.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY.
 - 3.1 FIXTURE BASE SHOULD BE CLAMPED IN VISE VERTICALLY TO KEEP LOCATOR TOOL SEATED AGAINST FIXTURE BASE WALL.
 - 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN LOCATOR TOOL.
 - 3.3 CAREFULLY INSERT INNER CONDUCTOR OF CABLE INTO PRE-ASSEMBLED CENTER CONTACT OF HOUSING SUB-ASSEMBLY.
 - 3.4 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOW.
 - 3.4.1 MAINTAIN SEATED POSITION OF CABLE FIRMLY AND TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 3.5 SOLDER WHERE SHOWN.



- 4.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY.
 - 4.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

