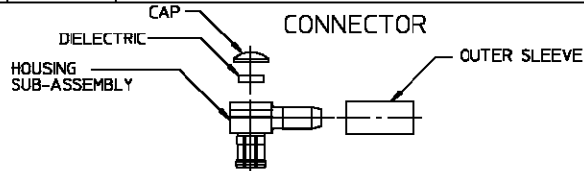
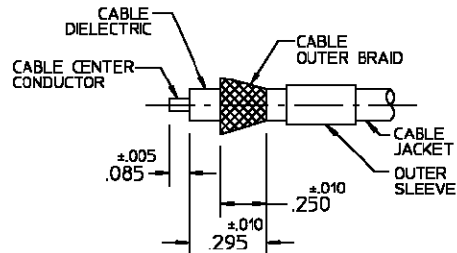


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSX RIGHT ANGLE CABLE PLUG CRIMP ATTACHMENT	RG 188/U, 316 DOUBLE BRAIDED	CRIMP TOOL: 5698-5014-54 CRIMP DIE 2098-0323-54 OPTIONAL: 2598-5231-10

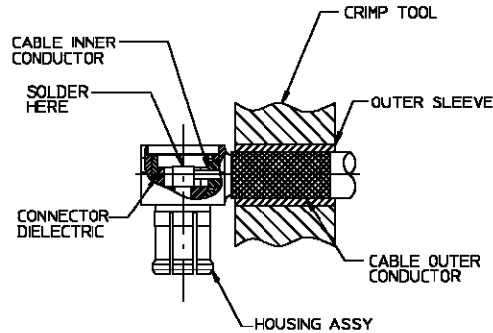


ASSEMBLY OPERATIONS

- 1.0 PREPARATION OF COAXIAL CABLE END
- 1.1 PLACE SHEATH AND OUTER 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 CENTER CONTACT
- 2.1 POSITION AND SECURE HOUSING SUB-ASSY IN A SMALL BENCH VISE
 - 2.2 TIN INNER CONDUCTOR OF CABLE
 - 2.3 INSERT CABLE INTO HOUSING SUB-ASSY
 - 2.3.1 NEST CABLE INNER CONDUCTOR IN CENTER CONTACT SLOT
 - 2.3.2 BOTTOM CABLE DIELECTRIC ON CONNECTOR DIELECTRIC
 - 2.4 PLACE SOLDERING IRON ON TIP OF CENTER CONTACT AND SOLDER



- 3.0 CRIMPING OF CABLE SUB-ASSY TO HOUSING SUB-ASSY
- 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 DIELECTRIC INTO OPENING IN REAR OF HOUSING SUB-ASSY
 - 4.2 PLACE DISC INTO OPENING IN REAR OF HOUSING SUB-ASSY AND EITHER PRESS, SOLDER, OR EPOXY INTO PLACE AS SHOWN.
 - 4.3 CAP MAY BE INSERTED USING OPTIONAL INSTALLATION TOOL 2598-5231-10.

