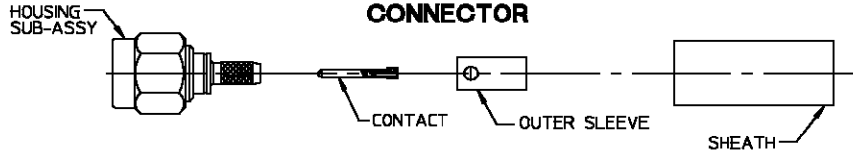
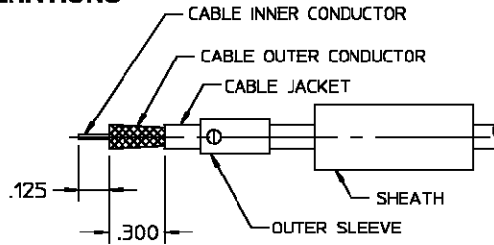


CONNECTOR TYPE "OSM" STRAIGHT CABLE PLUG SOLDER ATTACHMENT	CABLE TYPE RG-174/U, 179, 187, 188, 316, RD-316/U	TOOLS REQUIRED: CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) LOCATOR TOOL: 2098-5218-02 (T-2367)
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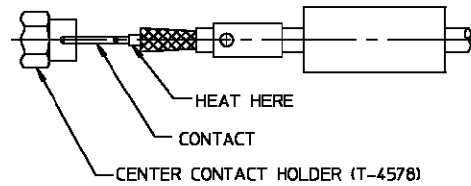


### ASSEMBLY OPERATIONS

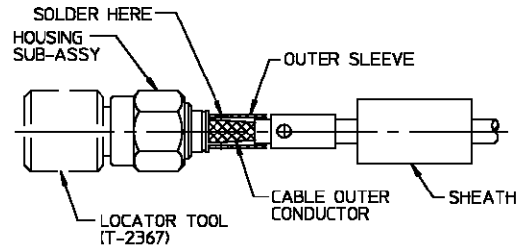
- 1.0 PREPARE COAXIAL CABLE END.**
- 1.1 PLACE SHEATH AND SLEEVE ON CABLE.
  - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
  - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
  - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
  - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
  - 1.6 FLARE OUTER CONDUCTOR.



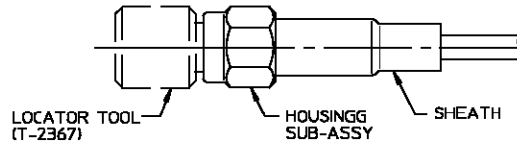
- 2.0 SOLDERING OF CONTACT TO CABLE INNER CONDUCTOR.**
- 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.
  - 2.3 REMOVE EXCESS SOLDER.



- 3.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY**
- 3.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
  - 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
  - 3.3 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
  - 3.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
  - 3.5 HOLD CABLE FIRMLY SEATED AND SOLDER THROUGH HOLES IN OUTER SLEEVE.
  - 3.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 4.0 SHRINK SHEATH TO CABLE**
- 4.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
  - 4.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.
  - 4.3 REMOVE LOCATOR TOOL.



- 5.0 INSPECT COMPLETED ASSEMBLY.**
- 5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN.

