

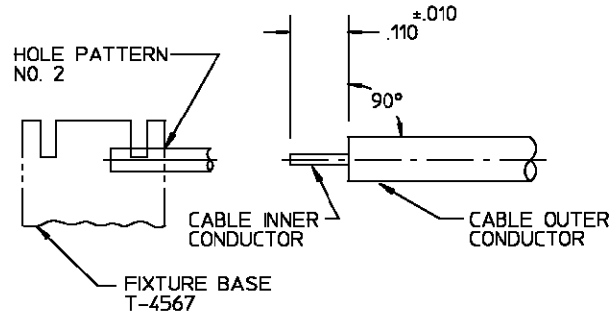
CONNECTOR



CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE PLUG DIRECT SOLDER ATTACHMENT	.141 SR COAXIAL CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5207-54 (T-4700-1) CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) SOLDER GAGE: 2098-5516-02 (T-4562-5) DIE INSERT TOOL: 2098-5214-02 (T-4554) LOCATOR TOOL: 2098-5210-02 (T-4569)

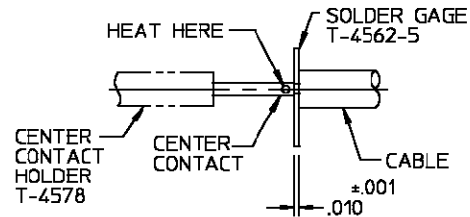
1.0 PREPARATION OF CABLE.

- 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 TRIM CABLE INNER CONDUCTOR TO LENGTH.



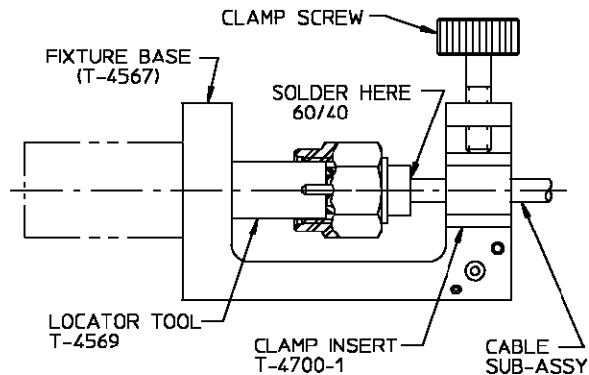
2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

- 2.1 TIN INNER CONDUCTOR OF CABLE.
- 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.
- 2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.
- 2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER.



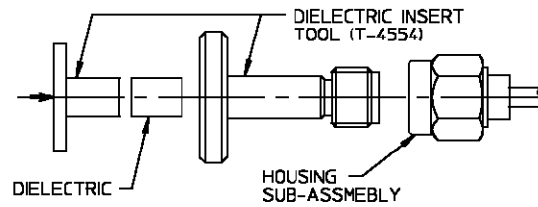
3.0 SOLDERING OF CABLE TO HOUSING

- 3.1 SCREW HOUSING ASSEMBLY ONTO LOCATOR TOOL.
- 3.2 CAREFULLY INSERT CABLE ASSEMBLY INTO PRE-ASSEMBLED DIELECTRIC OF HOUSING ASSEMBLY.
- 3.3 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 3.3.1 BOTTOM LOCATOR TOOL AGAINST FIXTURE BASE AS SHOWN.
 - 3.3.2 MAINTAINING PRESSURE ON CABLE TO KEEP LOCATOR TOOL BOTTOMED, TIGHTEN CLAMP SCREW TO SECURE CABLE.
- 3.4 SOLDER CABLE TO HOUSING.



NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE (SO THAT CONNECTOR INTERFACE IS FACING DOWN).

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- 4.0 PRESSING OF DIELECTRIC INTO HOUSING SUB-ASSEMBLY
 - 4.1 THREAD INSERT TOOL INTO HOUSING SUB-ASSEMBLY
 - 4.2 INSERT DIELECTRIC INTO INSERT TOOL HOUSING.
 - 4.3 PLACE INSERT TOOL PLUNGER INTO POSITION AND PRESS UNTIL FLANGE BOTTOMS ON TOOL HOUSING
 - 4.4 ASSEMBLY IS NOW COMPLETE.



NOTES:
INTERFACE DIMENSIONS PER MIL-STD-384A-310-1
