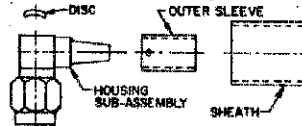


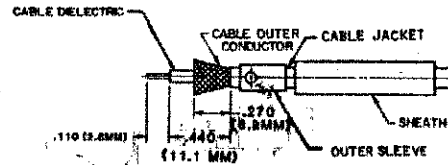
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM RIGHT ANGLE CABLE PLUG SOLDER ATTACHMENT	RG55/U,58, 141,142, 223,303,400	LOCATOR TOOL: 2098-926-02(T-2367)

### CONNECTOR

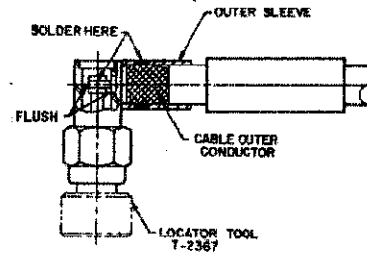


### ASSEMBLY OPERATIONS

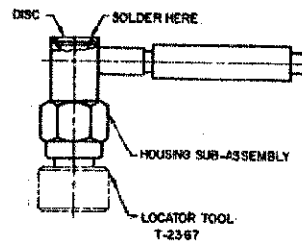
- 1.0 PREPARE COAXIAL CABLE END
  - 1.1 PLACE SHEATH AND OUTER SLEEVE ON CABLE.
  - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
  - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
  - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
  - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
  - 1.6 FLARE OUTER CONDUCTOR.



- 2.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY
  - 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
  - 2.3 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
  - 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AS SHOWN.
  - 2.5 PLACE SOLDERING IRON ON CONTACT & SOLDER.
  - 2.6 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR AND SOLDER AS SHOWN.



- 3.0 SEAL OPENING IN HOUSING
  - 3.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY
    - OPTION 1: TIN PERIMETER OF OPENING AND PRESS DISC INTO POSITION; APPLY HEAT TO CAP. DO NOT ALLOW SOLDER TO PENETRATE HOUSING.
    - OPTION 2: DISC MAY BE EPOXIED INTO PLACE, DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.



- 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

