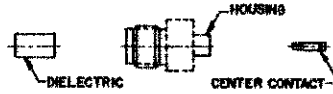


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
27.0 GHz OSM STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT	.141 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5207-54 (T-4700-1) CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) SOLDER GAGE: 2098-5516-02 (T-4862-5) LOCATOR TOOL: 2798-5003-02 DIELECTRIC INSERT TOOL: 2798-5002-02

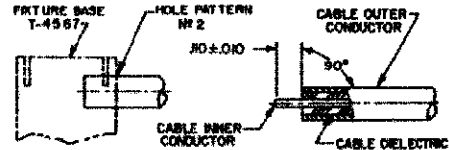
CONNECTOR



ASSEMBLY OPERATIONS

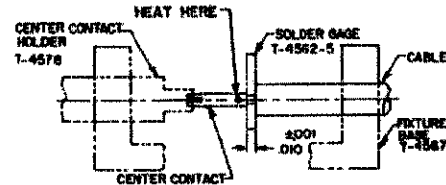
1.0 PREPARATION OF CABLE

- 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.



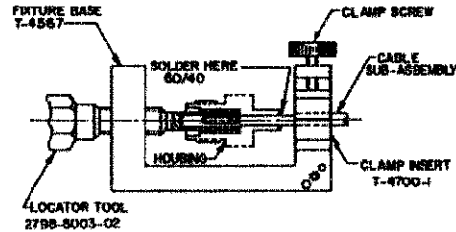
2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

- 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.



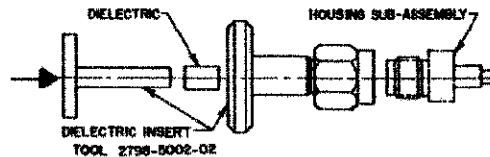
3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO HOUSING

- 3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.
 - 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 3.2.1 NEST CENTER CONTACT IN LOCATOR TOOL.
 - 3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
 - 3.3 SLIDE HOUSING OVER LOCATOR TOOL.
 - 3.4 MAINTAIN POSITION OF HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.
- NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.



4.0 PRESSING OF DIELECTRIC BUSHING INTO HOUSING SUB-ASSEMBLY

- 4.1 THREAD INSERT TOOL ONTO 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.



5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY

- 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

