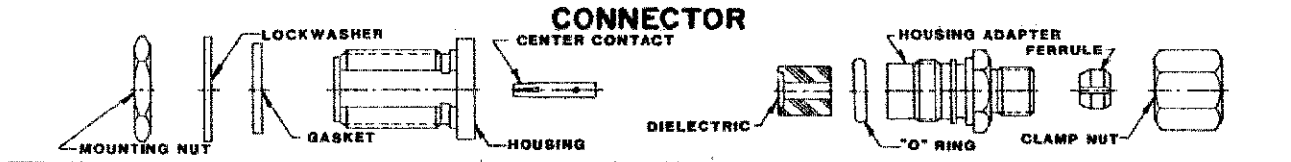


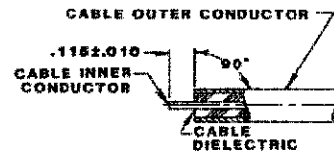
CONNECTOR TYPE OSN BULKHEAD FEEDTHROUGH CABLE JACK COMPRESSION CLAMP ATTACHMENT	CABLE TYPE .250 SEMI-RIGID COAXIAL CABLE SOLID TFE	TOOLS REQUIRED: CABLE CUTTER: 2098-5811-54(T-17346) CABLE ADAPTER: 2098-5812-02(T-17508) CENTER CONTACT HOLDER: 2098-5277-10(T-4681) SOLDER GAGE: 2098-5853-02(T-4676-3)
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ASSEMBLY OPERATIONS

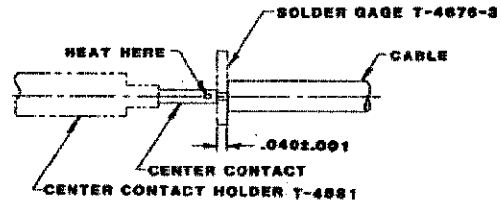
1.0 PREPARATION OF CABLE

- 1.1 INSERT SQUARED CABLE END INTO CABLE CUTTER AND CUT THROUGH CABLE OUTER CONDUCTOR.
- 1.2 REMOVE CUT OUTER CONDUCTOR FROM CABLE.
- 1.3 FINISH CUTTING CABLE DIELECTRIC WITH CUTTING BLADE.
- 1.4 TRIM CABLE INNER CONDUCTOR TO DIMENSION SHOWN.
CAUTION: REMOVE ALL BURRS BETWEEN CABLE OUTER CONDUCTOR AND CABLE DIELECTRIC.



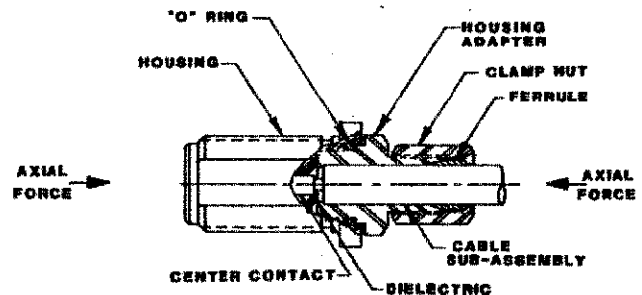
2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

- 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 ASSEMBLE CONNECTOR

- 3.1 ASSEMBLE "O" RING ONTO HOUSING ADAPTER.
- 3.2 ASSEMBLE DIELECTRIC INTO HOUSING ADAPTER.
- 3.3 ASSEMBLE HOUSING ADAPTER INTO HOUSING AND TIGHTEN TO 25-30 IN.LBS. OF TORQUE.
- 3.4 SLIDE CLAMP NUT AND FERRULE (15 DEGREE TAPER FORWARD) ONTO CABLE AS SHOWN.
- 3.5 INSERT CABLE AND CLAMPING PARTS INTO HOUSING ADAPTER. APPLY AN AXIAL FORCE TO THE CABLE AND THE HOUSING SUB-ASSEMBLY, TO ASSURE GOOD ELECTRICAL CONTACT OF THE CABLE OUTER CONDUCTOR TO THE HOUSING ADAPTER, WHILE TIGHTENING THE CLAMP NUT TO 25-30 IN.LBS. OF TORQUE.



4.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY

- 4.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

