

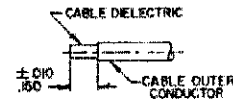
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSN BULKHEAD FEEDTHROUGH CABLE JACK, SOLDER CLAMP ATTACHMENT	.141 SEMI-RIGID COAXIAL CABLE .141 SEMI-RIGID MICROPOROUS CABLE	FIXTURE BASE:2098-5208-54(T-4567) CLAMP INSERT:2098-5207-64(T-4700-1) CENTER CONTACT HOLDER:2098-5277-10(T-4581) LOCATOR TOOL:2098-5276-02(T-4572)

CONNECTOR



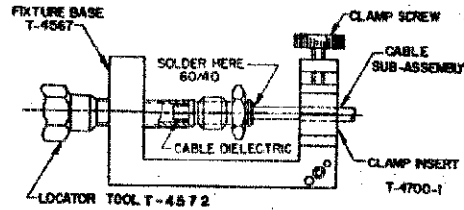
ASSEMBLY OPERATIONS

- 1.0 PREPARATION OF CABLE**
1.1 TRIM CABLE JACKET TO DIMENSION SHOWN.

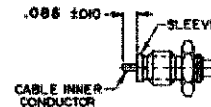


- 2.0 SOLDERING OF CABLE TO CLAMP ASSEMBLY**
2.1 PLACE CLAMP ASSEMBLY ON END OF TRIMMED CABLE.
2.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
2.2.1 NEST CABLE IN LOCATOR TOOL.
2.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
2.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
2.3 SLIDE CLAMP ASSEMBLY AGAINST LOCATOR TOOL.
2.4 MAINTAIN POSITION OF CLAMP ASSEMBLY AGAINST LOCATOR TOOL AND SOLDER.

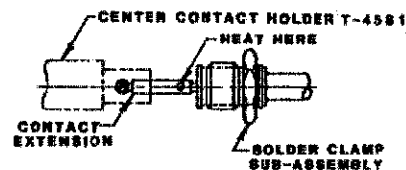
NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP CLAMP ASSEMBLY SEATED AGAINST LOCATOR TOOL.



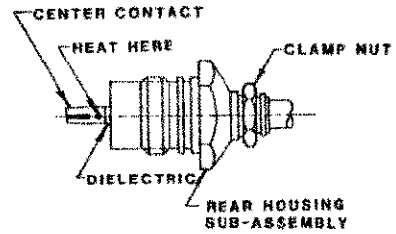
- 3.0 TRIMMING OF CABLE INNER CONDUCTOR**
3.1 TRIM CABLE DIELECTRIC FLUSH WITH SLEEVE.
3.2 TRIM INNER CONDUCTOR OF CABLE TO $.088 \pm .010$.
3.3 TIN INNER CONDUCTOR OF CABLE (DO NOT ALLOW EXCESSIVE BUILD-UP OF SOLDER).



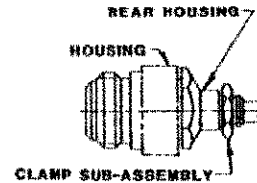
- 4.0 SOLDERING OF CONTACT EXTENSION TO CABLE INNER CONDUCTOR**
4.1 PLACE THREADED END OF CONTACT EXTENSION IN HOLDER, HEAT CONTACT EXTENSION AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.
4.2 REMOVE EXCESS SOLDER.



- 5.0 SECURE SOLDER CLAMP SUB-ASSEMBLY TO REAR HOUSING SUB-ASSEMBLY AND SOLDER CENTER CONTACT.
- 5.1 CAREFULLY INSERT THE CONTACT EXTENSION INTO THE DIELECTRIC BUSHING I.D. OF THE REAR HOUSING SUB-ASSEMBLY.
- 5.2 ENGAGE THREADS OF THE SOLDER CLAMP SUB-ASSEMBLY TO THE REAR HOUSING AND TORQUE TO 25-30 IN.LBS.
- 5.3 SCREW CENTER CONTACT ONTO CONTACT EXTENSION TO REST FIRMLY AGAINST DIELECTRIC.
- 5.4 APPLY SOFT SOLDER INTO CROSS HOLE OF CENTER CONTACT AND HEAT TO MAKE SOLDER CONNECTION.
- 5.5 REMOVE EXCESS SOLDER.



- 6.0 ASSEMBLE HOUSING ONTO REAR HOUSING SUB-ASSEMBLY.
- 6.1 SECURE HOUSING TO THREADS OF REAR HOUSING SUB-ASSEMBLY.
- 6.2 TIGHTEN WITH A TORQUE OF 25-30 IN.LBS.



- 7.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY.
- 7.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

