

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSN STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT	.085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE:2098-5206-54(T-4567) CENTER CONTACT HOLDER:2098-5277-10(T-4581)

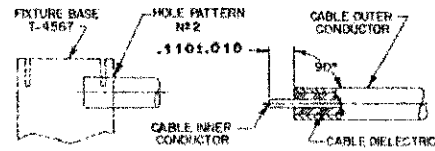
## CONNECTOR



## ASSEMBLY OPERATIONS

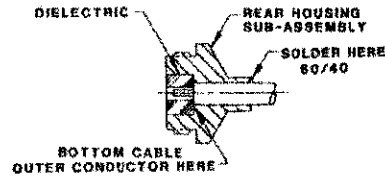
### 1.0 PREPARATION OF CABLE

- 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.



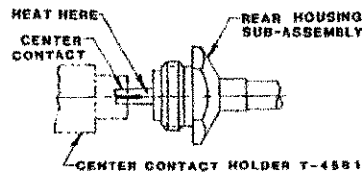
### 2.0 SOLDERING CABLE TO REAR HOUSING SUB-ASSEMBLY

- 2.1 INSERT DIELECTRIC INTO REAR HOUSING.
- 2.2 POSITION AND SECURE REAR HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 2.3 TIN INNER CONDUCTOR OF CABLE.
- 2.4 INSERT CABLE INTO REAR HOUSING SUB-ASSEMBLY.
- 2.5 SEAT CABLE FIRMLY AGAINST DIELECTRIC IN REAR HOUSING AND SOLDER.



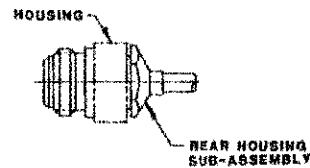
### 3.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

- 3.1 PLACE CENTER CONTACT IN HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE WITH THE LARGE DIAMETER OF CONTACT RESTING FIRMLY AGAINST DIELECTRIC.
- 3.2 REMOVE EXCESS SOLDER.



### 4.0 ASSEMBLE HOUSING ONTO REAR HOUSING SUB-ASSEMBLY

- 4.1 SECURE HOUSING TO THREADS OF REAR HOUSING SUB-ASSEMBLY.
- 4.2 TIGHTEN WITH A TORQUE OF 25-30 IN.LBS.



### 5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY

- 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

