

CONNECTOR TYPE

OSN STRAIGHT
CABLE JACK
DIRECT SOLDER
ATTACHMENT

CABLE TYPE

TOOLS REQUIRED:

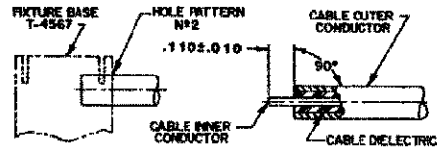
FIXTURE BASE: 2098-5208-54 (T-4567)
CLAMP INSERT: 2098-5207-54 (T-4700-1)
CENTER CONTACT HOLDER: 2098-5277-40 (T-4581)
SOLDER GAGE: 2098-5212-02 (T-4562-1)
LOCATOR TOOL: 2098-5276-02 (T-4572)

CONNECTOR

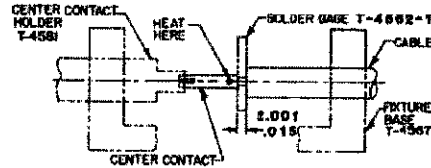


ASSEMBLY OPERATIONS

- 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.



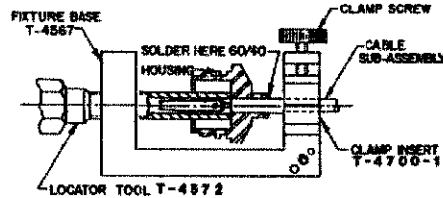
- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.**
- 2.1 TIN INNER CONDUCTOR OF CABLE.
 - 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR. FLUSH WITH END OF OUTER CONDUCTOR.
 - 2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.
 - 2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER.



*FOR MICROPOROUS CABLE DO NOT USE FLUX OR SOLVENT IN CABLE DIELECTRIC AREA.

- 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO REAR HOUSING.**

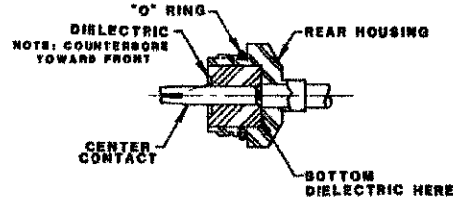
- 3.1 PLACE REAR HOUSING ON END OF CABLE SUB-ASSEMBLY.
- 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 3.2.1 REST CENTER CONTACT IN LOCATOR TOOL.
 - 3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
- 3.3 SLIDE REAR HOUSING OVER LOCATOR TOOL.
- 3.4 MAINTAIN POSITION OF REAR HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.



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

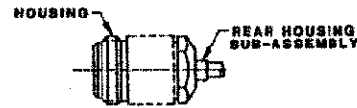
- 4.0 INSERT DIELECTRIC AND ASSEMBLE "O" RING.**

- 4.1 INSERT THE DIELECTRIC BUSHING (COUNTERBORE TOWARD FRONT) OVER THE CENTER CONTACT INTO THE HOUSING.
- 4.2 ASSEMBLE "O" RING ONTO REAR HOUSING AS SHOWN.



- 5.0 ASSEMBLE HOUSING ONTO REAR HOUSING SUB-ASSEMBLY.**

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



- 6.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY.**

- 6.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

