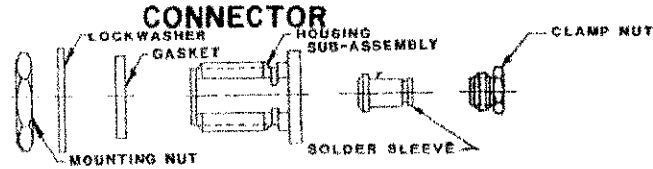
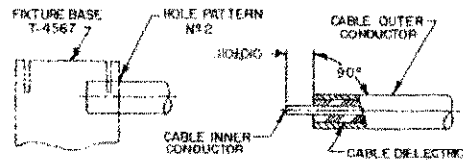


CONNECTOR TYPE 18.0 GHz OSN BULKHEAD FEEDTHROUGH CABLE JACK SOLDER CLAMP ATTACHMENT	CABLE TYPE .141 SEMI-RIGID COAXIAL CABLE	TOOLS REQUIRED: FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5207-34 (T-4700-1) LOCATOR TOOL: 2098-5606-02
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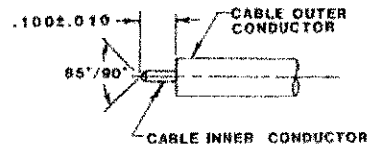


### ASSEMBLY OPERATIONS

- 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.

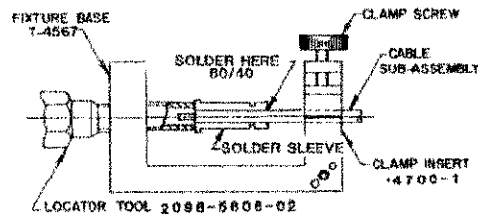


- 2.0 SHAPE INNER CONDUCTOR OF CABLE**
- 2.1 TRIM INNER CONDUCTOR TO LENGTH AS SHOWN.
  - 2.2 FILE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° CONE.

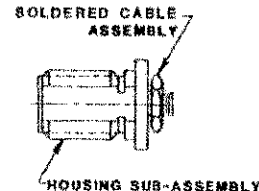


- 3.0 SOLDERING OF INNER SLEEVE TO CABLE**
- 3.1 PLACE CLAMP NUT AND INNER SLEEVE ON END OF CABLE.
  - 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN. (SLIDE CLAMP NUT BACK OUT OF WAY)
    - 3.2.1 NEST CABLE IN LOCATOR TOOL.
    - 3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
    - 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
  - 3.3 SLIDE INNER SLEEVE AGAINST LOCATOR TOOL.
  - 3.4 MAINTAIN POSITION OF INNER SLEEVE FIRMLY AGAINST LOCATOR TOOL AND SOLDER.
 

NOTE: FIXTURE BASE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP INNER SLEEVE SEATED AGAINST LOCATOR TOOL



- 4.0 ASSEMBLE SOLDERED CABLE ASSEMBLY INTO HOUSING SUB-ASSEMBLY**
- 4.1 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE-ASSEMBLED CENTER CONTACT OF HOUSING SUB-ASSEMBLY.
  - 4.2 ENGAGE THREADS OF CLAMP NUT TO HOUSING SUB-ASSEMBLY AND TORQUE TO 25-30 IN. LBS.
  - 4.3 ASSEMBLY IS NOW COMPLETE.



- 5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY**
- 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.