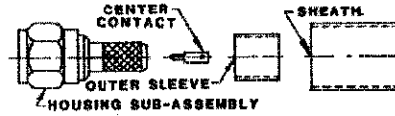


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSMM STRAIGHT CABLE PLUG CRIMP ATTACHMENT	RG178/U,196	CENTER CONTACT HOLDER:4098-5012-10 SOLDER GAGE:4098-5013-02(T-4582-10) LOCATOR TOOL:4098-5015-02 CRIMP TOOL:2098-0108-54 TWP A

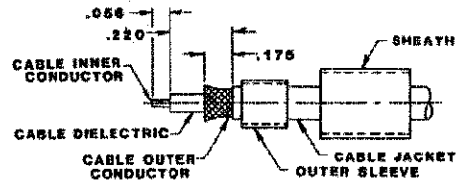
### CONNECTOR



### ASSEMBLY OPERATIONS

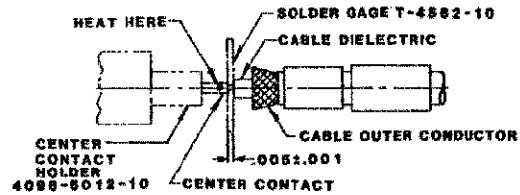
#### 1.0 PREPARATION OF CABLE

- 1.1 PLACE SHEATH AND OUTER SLEEVE ON CABLE
- 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
- 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
- 1.4 TRIM CABLE DIELECTRIC TO LENGTH SHOWN TO EXPOSE CABLE INNER CONDUCTOR.
- 1.5 FLARE OUTER CONDUCTOR.



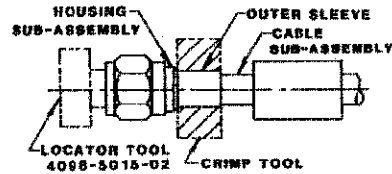
#### 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.

- 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.



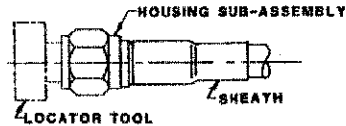
#### 3.0 CRIMP CABLE TO INNER SLEEVE

- 3.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
- 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 3.3 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
- 3.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 3.5 HOLD CABLE FIRMLY SEATED AND CRIMP OUTER SLEEVE IN PLACE.
- 3.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



#### 4.0 SHRINK SHEATH TO CABLE

- 4.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
- 4.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.
- 4.3 REMOVE LOCATOR.



#### 5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY

- 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

