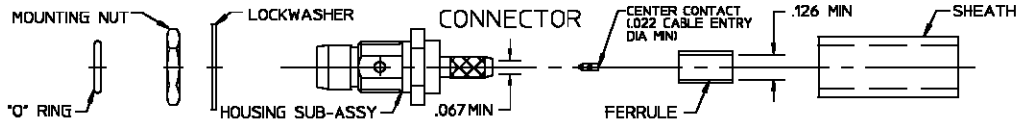
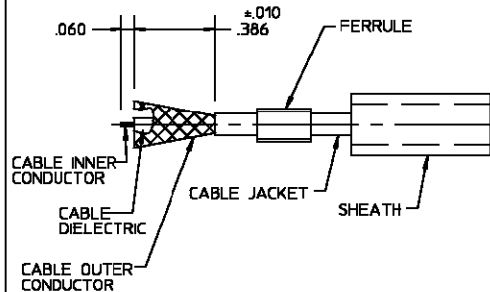


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSP BULKHEAD FEEDTHRU CABLE PLUG CRIMP ATTACHMENT	RG174/U. RG179/U. RG187/U. RG188/U RG316/U	CRIMP TOOL: M22520/5-01 CRIMP DIE: M22520/5-03 CLOSURE A OPTIONAL TOOLING: CRIMP TOOL: 5698-5014-54 (T-4718) CRIMP DIE: 5698-5015-54 (T-4702-1) DIE No. C

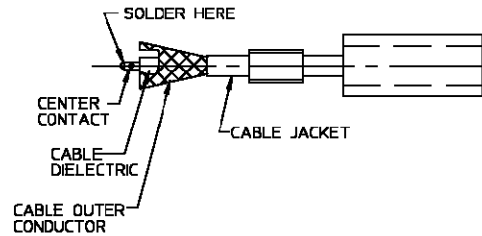


ASSEMBLY OPERATIONS

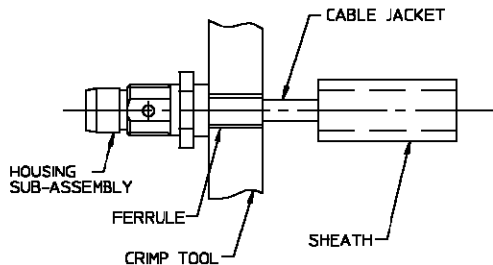
- 1.0 PREPARE COAXIAL CABLE END:
- 1.1 PLACE SHEATH AND FERRULE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



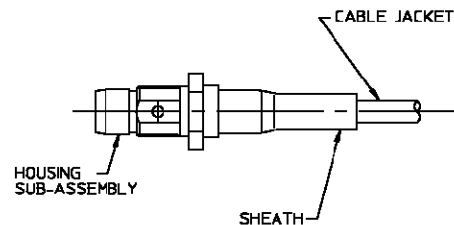
- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR
- 2.1 TIN INNER CONDUCTOR OF CABLE.
 - 2.2 HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.
 - 2.3 REMOVE EXCESS SOLDER.



- 3.0 CRIMP CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY
- 3.1 BEING SURE THAT THE CENTER CONTACT ENTERS THE PRE-ASSEMBLED HOUSING CONTACT. INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT CABLE FIRMLY.
 - 3.2 SLIDE FERRULE OVER FLARED PORTION OF CABLE OUTER CONDUCTOR.
 - 3.3 HOLD CABLE FIRMLY SEATED AND CRIMP FERRULE IN PLACE.
 - 3.4 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 ASSEMBLY IS NOW COMPLETE.



DESC NO.
85074Z5GA
M/A-COM NO.
4533-5007-02