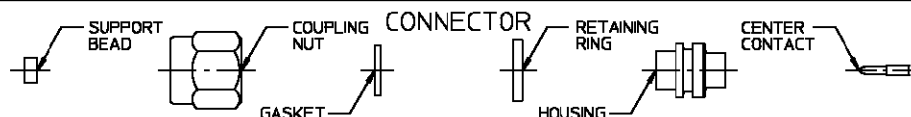
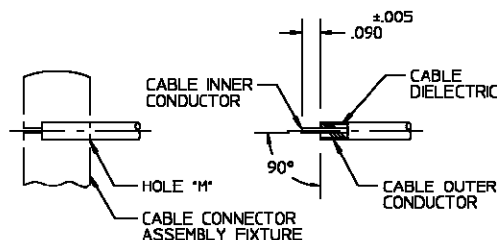


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OS-2.9 STRAIGHT CABLE PLUG, DIRECT SOLDER ATTACHMENT	.085 DIA SEMI-RIGID CABLE	RESISTANCE SOLDERING MACHINE: 2096-5200-54 LOCATOR TOOL: 2096-5207-54 FIXTURE BASE: 2096-5206-54 (T-4567) CLAMP INSERT: 2096-5208-54 (T-4700-2) CABLE CONNECTOR ASSEMBLY FIXTURE: 2096-5203-54 RETAINING RING PLIERS: 2096-5206-54 (T-5702) SOLDERING GAUGE: 2096-5205-54 (T4562-S) SOLVENT: ISOPROPYL ALCOHOL

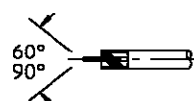


### ASSEMBLY OPERATIONS

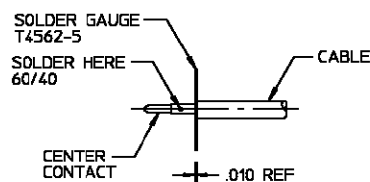
- 1.0 PREPARATION OF CABLE
  - 1.1 INSERT SQUARED CABLE END INTO CABLE CONNECTOR ASSEMBLY FIXTURE, HOLE "M" AS SHOWN.
  - 1.2 PLACE BLADE FLUSH AGAINST FIXTURE AND CUT THROUGH OUTER CABLE CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
  - 1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE. CARE SHOULD BE TAKEN NOT TO NICK INNER CONDUCTOR DURING THIS OPERATION.
  - 1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.
  - 1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR USING HOLE "M" TO ACHIEVE DIMENSION SHOWN.



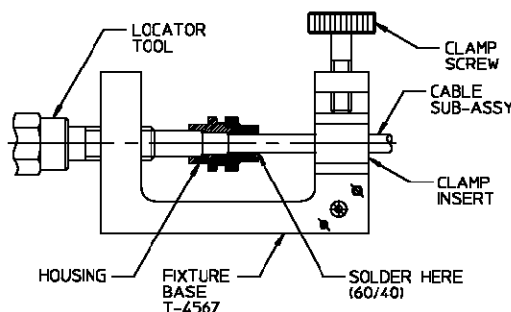
- 2.0 SHAPE CABLE INNER CONDUCTOR.
  - 2.1 FILE BLUNT END OF CABLE INNER CONDUCTOR TO A 60°-90° CONE.
  - 2.2 CLEAN END WITH SOLVENT.



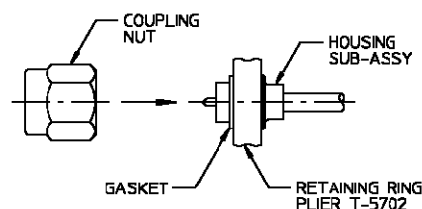
- 3.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.
  - 3.1 TIN INNER CONDUCTOR OF CABLE.
  - 3.2 PLACE SOLDER GAGE ON CENTER CONDUCTOR RESTING FIRMLY AGAINST CABLE DIELECTRIC.
  - 3.2 HEAT CENTER CONTACT AND PUSH IT OVER INNER CABLE CONDUCTOR TO REST FIRMLY AGAINST SOLDER GAGE.
  - 3.3 REMOVE EXCESS SOLDER AND CLEAN WITH SOLVENT.



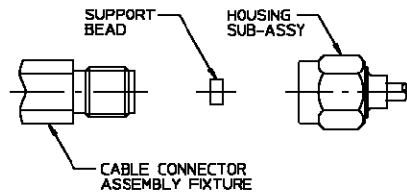
- 4.0 SOLDERING OF CABLE SUB-ASSY TO HOUSING
  - 4.1 INSERT LOCATOR TOOL INTO THE FRONT END OF HOUSING UNTIL LOCATOR BOTTOMS ON HOUSING.
  - 4.2 INSERT CABLE SUB-ASSY INTO REAR OF HOUSING UNTIL CABLE SUB-ASSY BOTTOMS ON LOCATOR TOOL.
  - 4.3 MAINTAIN POSITION OF THE CABLE FIRMLY AGAINST HOUSING AND SOLDER. AVOID APPLICATION OF EXCESS SOLDER AND VERIFY THAT THE SOLDER JOINT IS FREE OF VOIDS.
  - 4.4 CLEAN THE CABLE SUB-ASSY WITH SOLVENT.
  - 4.5 INSPECT CENTER CONTACT LENGTH FROM REFERENCE PLANE IN ACCORDANCE WITH FIGURE SHOWN IN STEP 6 OF THIS ASSEMBLY PROCEDURE.



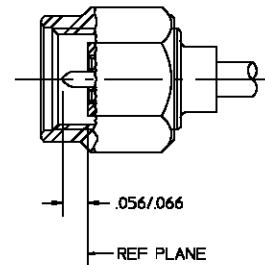
- 5.0 SECURE COUPLING NUT TO HOUSING SUB-ASSY
  - 5.1 PLACE RETAINING RING AND GASKET ON HOUSING SUB-ASSY.
  - 5.2 COMPRESS RETAINING RING WITH RETAINING RING PLIERS.
  - 5.3 PUSH COUPLING NUT ON HOUSING SUB-ASSY AND RETAINING RING.
  - 5.4 COUPLING NUT SHOULD ROTATE FREELY.



- 6.0 PRESSING OF SUPPORT BEAD INTO HOUSING SUB-ASSY
- 6.1 SLIDE SUPPORT BEAD OVER CENTER CONTACT AND POSITION AT HOUSING SUB-ASSY INTERFACE.
- 6.2 THREAD CABLE CONNECTOR ASSEMBLY FIXTURE INTO THE HOUSING SUB-ASSY TO FULLY INSERT SUPPORT BEAD.
- 6.3 ASSEMBLY IS NOW COMPLETE.



- 7.0 INSPECTION OF COMPLETED CONNECTOR ASSY
- 7.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCE AS SHOWN.



\*\*\* CAUTION \*\*\*

AVOID CLEANING FLUIDS CONTAINING HALOGENATED AND AROMATIC HYDROCARBONS (FREON □). THESE COMPOUNDS MAY SOFTEN OR DISSOLVE THE PPO ■ BEAD MATERIAL IN THE SUPPORT BEAD INSIDE THE BUSHING SUB-ASSEMBLY

- - TRADEMARK OF DUPONT CORP  
■ - TRADEMARK OF GENERAL ELECTRIC