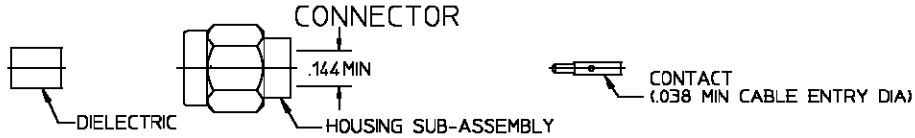


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSM STRAIGHT CABLE PLUG, DIRECT SOLDER ATTACHMENT	.141 DIA SEMI-RIGID CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5207-54 (T-4700-1) CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) SOLDER GAGE: 2098-5216-02 (T-4562-5) LOCATOR TOOL: 2098-5210-02 (T-4569) DIELECTRIC INSERT TOOL: 2098-5214-02 (T-4554)

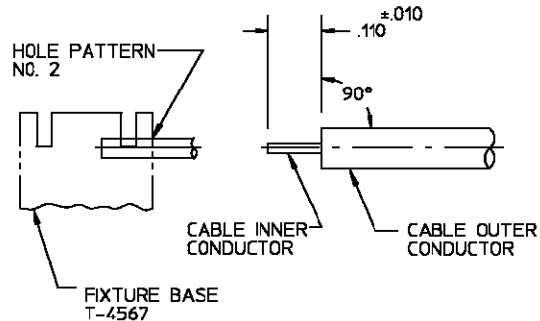
DESC NO.
84149SSG-1
M/A-COM NO.
2001-5557-02



ASSEMBLY OPERATIONS

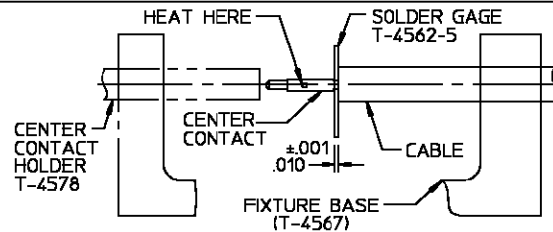
1.0 PREPERATION OF CABLE.

- 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 TRIM CABLE INNER CONDUCTOR TO LENGTH.



2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

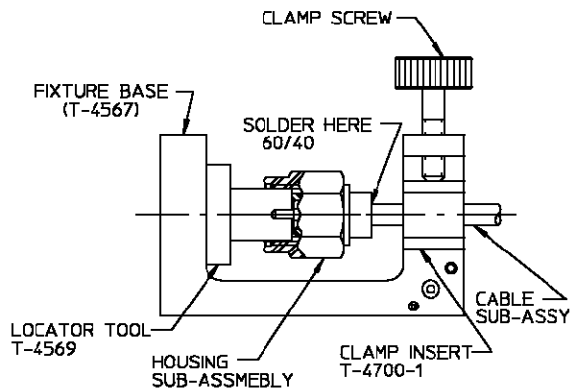
- 2.1 TIN INNER CONDUCTOR OF CABLE.
- 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.
- 2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.
- 2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER.



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

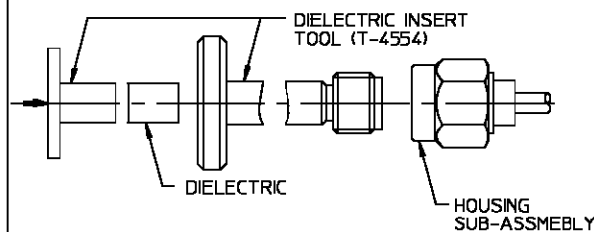
- 3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.
- 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 3.2.1 NEST CENTER CONTACT IN LOCATOR TOOL.
 - 3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
- 3.3 SLIDE HOUSING OVER LOCATOR TOOL.
- 3.4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

NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE (SO THAT CONNECTOR INTERFACE IS FACING DOWN) TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.



4.0 PRESSING OF DIELECTRIC INTO HOUSING SUB-ASSEMBLY

- 4.1 THREAD INSERT TOOL INTO HOUSING SUB-ASSEMBLY
- 4.2 INSERT DIELECTRIC INTO INSERT TOOL HOUSING.
- 4.3 PLACE INSERT TOOL PLUNGER INTO POSITION AND PRESS UNTIL FLANGE BOTTOMS ON TOOL HOUSING
- 4.4 ASSEMBLY IS NOW COMPLETE.



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

