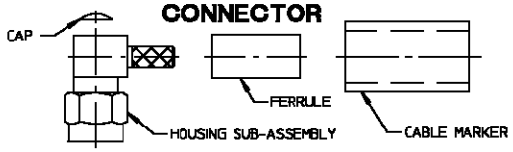
OSM Right Angle Cable Plug Crimp Attachment 1052080–1, 1327121–1, 1052081–1, and 1061840–1

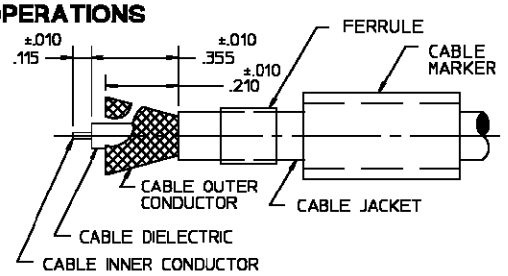
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM RIGHT ANGLE CABLE PLUG CRIMP ATTACH	RG 180/U, 195	LOCATOR TOOL: 2098-5218-02 (T-2367) CRIMP TOOL: 2098-0105-54 DIE NO. D

CONNECTOR



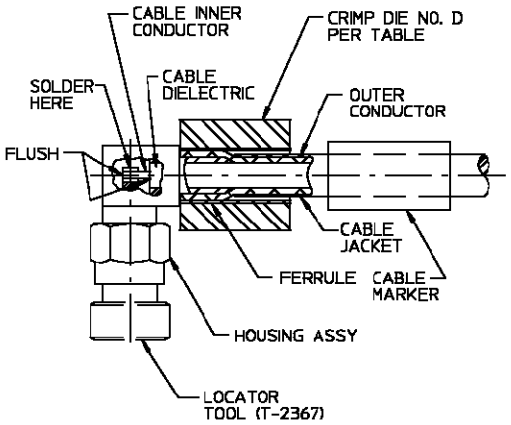
ASSEMBLY OPERATIONS

1.0 PREPARE COAXIAL CABLE END.
- 1.1 PLACE CABLE MARKER 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.

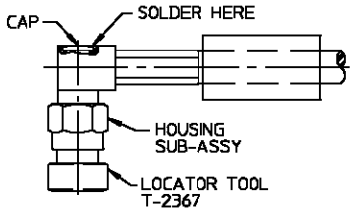


2.0 SOLDERING OF CABLE INNER CONDUCTOR HOUSING SUB-ASSEMBLY.
- 2.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
- 2.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 2.3 TIN INNER CONDUCTOR OF CABLE.
- 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY
  - 2.4.1. NEST INNER CONDUCTOR IN CONTACT SLOT
  - 2.4.2. HOLD CABLE DIELECTRIC AND INNER CONDUCTOR FLUSH AS SHOWN.
- 2.5 PLACE SOLDERING IRON ON TIP OF CONTACT AND SOLDER.

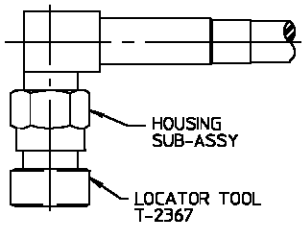
3.0 CRIMPING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY.
- 3.1 SLIDE FERRULE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 3.2 CRIMP FERRULE IN PLACE.
- 3.3 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



4.0 SEAL OPENING IN HOUSING
- 4.1 PRESS CAP INTO OPENING IN REAR HOUSING SUB-ASSEMBLY.
- 4.2 CAP MAY BE EPOXIED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.
- 4.3 REMOVE LOCATOR TOOL.



5.0 SHRINK CABLE MARKER TO CABLE
- 5.1 POSITION CABLE MARKER OVER FERRULE AS SHOWN.
- 5.2 APPLY INDIRECT HEAT WITH THERMO GUN TO CABLE MARKER.
- 5.3 REMOVE LOCATOR TOOL.
- 5.4 ASSEMBLY IS NOW COMPLETE



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