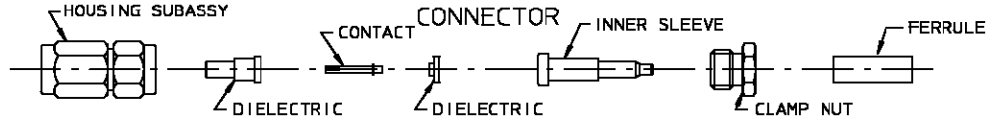


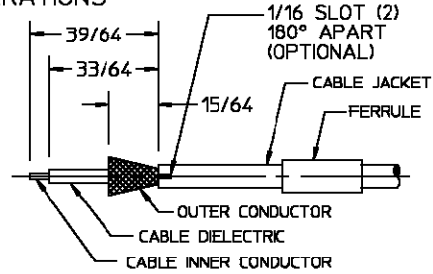
CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
SMC STRAIGHT CABLE PLUG - CRIMP ATTACHMENT	RG196 FLEX. OSMT CABLE	CENTER CONTACT HOLDER: 2098-5237-10 (T-4579) CRIMP TOOL: 2598-5005-54 (DIE NO. A) TORQUE WRENCH 2598-5243-54



ASSEMBLY OPERATIONS

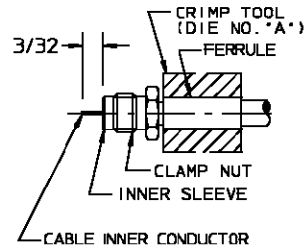
1.0 PREPARE COAXIAL CABLE END

- 1.1 PLACE FERRULE ON CABLE
- 1.2 REMOVE END PORTION OF CABLE JACKET AND TRIM CABLE TO DIMENSIONS SHOWN
- 1.3 FLARE OUTER CONDUCTOR
- 1.4 CUT TWO SLITS IN CABLE JACKET AS SHOWN (OPTIONAL).



2.0 CRIMP CABLE TO INNER SLEEVE

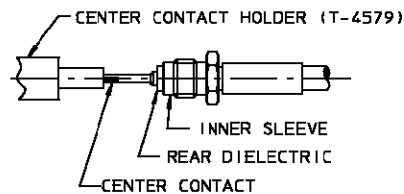
- 2.1 ASSEMBLE CLAMP NUT ONTO INNER SLEEVE
- 2.2 INSERT CABLE INTO INNER SLEEVE AND SEAT FIRMLY. DIELECTRIC TO BE FLUSH WITH INNER SLEEVE, TRIM IF REQUIRED
- 2.3 SLIDE FERRULE OVER FLARED PORTION OF OUTER CONDUCTOR
- 2.4 HOLD CABLE FIRMLY AND CRIMP FERRULE IN PLACE
- 2.5 TIN INNER CONDUCTOR
- 2.6 TRIM INNER CONDUCTOR AS SHOWN.



3.0 ■ SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

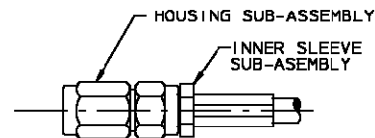
- 3.1 ASSEMBLE REAR DIELECTRIC ONTO CENTER CONTACT.
- 3.2 PLACE CENTER CONTACT INTO HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE WITH LARGE DIAMETER OF REAR DIELECTRIC RESTING FIRMLY AGAINST INNER SLEEVE
- 3.3 REMOVE EXCESS SOLDER AND FLUX

■ NOTE:
TO AVOID DAMAGE TO THE CABLE WHEN USING OSMT CABLE MINIMIZE TIME AT TEMPERATURE WHEN SOLDERING AND/OR HEAT SHRINKING CONNECTOR TO CABLE. AVOID DIRECT HEAT ON EXPOSED CABLE JACKET.



4.0 SECURE HOUSING SUB-ASSEMBLY TO INNER SLEEVE ASSEMBLY

- 4.1 INSERT DIELECTRIC INTO HOUSING SUB-ASSY
- 4.2 CAREFULLY INSERT CENTER CONTACT INTO DIELECTRIC OF THE HOUSING SUB-ASSEMBLY
- 4.3 ENGAGE THREADS OF INNER SLEEVE TO SUB-ASSEMBLY AND TORQUE TO 7-10 IN. LBS.



5.0 INSPECT COMPLETED ASSEMBLY

- 5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN

