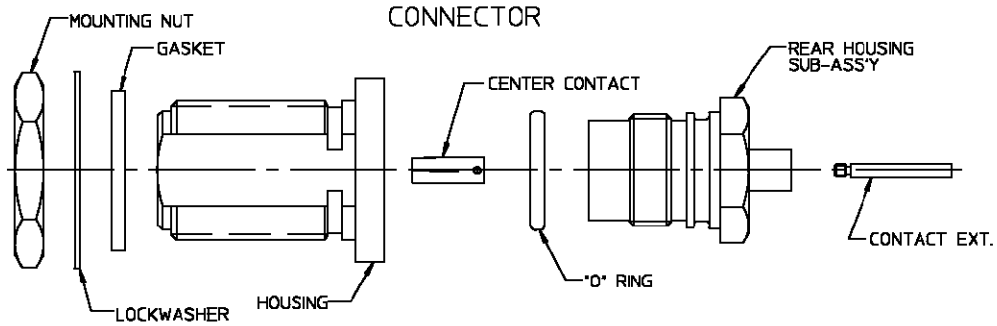
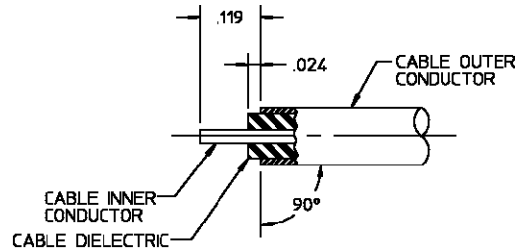


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSN STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT	.085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERTS: 2098-5208-54 (T-4700-2) LOCATOR TOOL: 2098-5209-02 (T-4575)

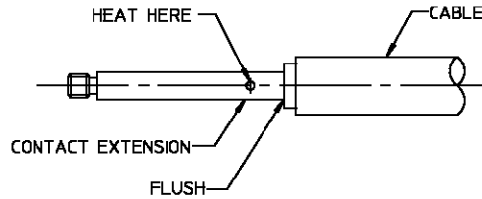


### ASSEMBLY OPERATIONS

- 1.0 PREPARATION OF CABLE  
1.1 TRIM CABLE TO DIMENSIONS SHOWN.

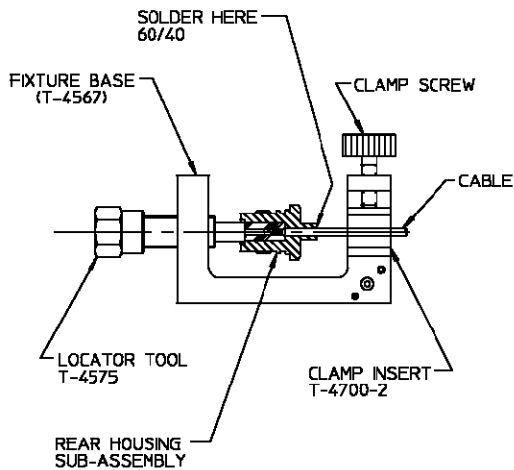


- 2.0 SOLDERING OF CONTACT EXTENSION TO CABLE INNER CONDUCTOR.  
2.1 TIN INNER CONDUCTOR OF CABLE.  
2.2 HEAT CONTACT EXTENSION AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.  
2.3 REMOVE EXCESS SOLDER.

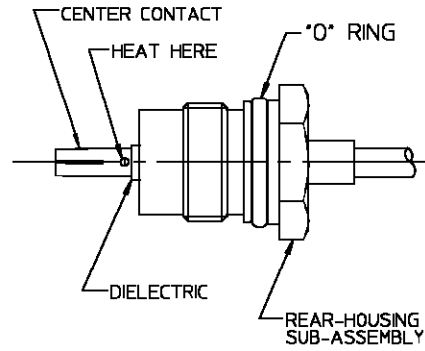


- 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO REAR HOUSING SUB-ASSEMBLY.  
3.1 PLACE REAR HOUSING SUB-ASSEMBLY ON END OF CABLE SUB-ASSEMBLY.  
3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.  
3.2.1 TIGHTEN CLAMP SCREW TO SECURE CABLE.  
3.2.2 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY AGAINST HOUSING.  
3.3 SOLDER CABLE TO REAR HOUSING SUB-ASSEMBLY AS SHOWN.

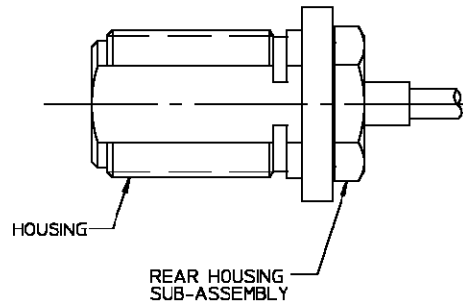
NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE.



- 4.0 ASSEMBLE CENTER CONTACT INTO CONTACT EXTENSION.
- 4.1 SCREW CENTER CONTACT ONTO CONTACT EXTENSION TO REST FIRMLY AGAINST DIELECTRIC.
- 4.2 APPLY SOFT SOLDER INTO CROSS HOLE OF CENTER CONTACT AND HEAT TO MAKE SOLDER CONNECTION.
- 4.3 REMOVE EXCESS SOLDER.
- 4.4 ASSEMBLE O-RING ONTO REAR HOUSING SUB-ASS'Y.



- 5.0 ASSEMBLE HOUSING ONTO REAR HOUSING SUB-ASSEMBLY.
- 5.1 SECURE HOUSING TO THREADS OF REAR HOUSING SUB-ASSEMBLY.
- 5.2 TIGHTEN WITH A TORQUE OF 25 IN. LBS.



- 6.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY.
- 6.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

