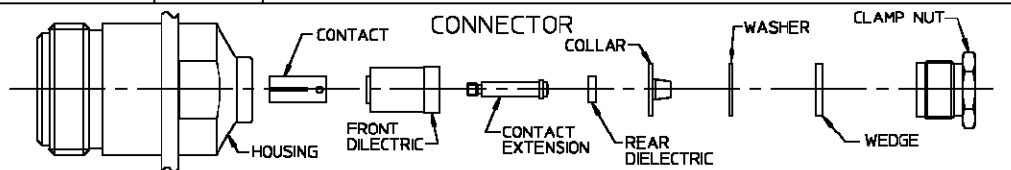


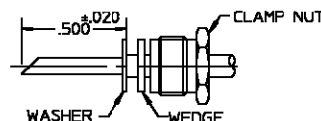
CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D:
OSN FLANGE MOUNT CABLE JACK CLAMP ATTACHMENT	RD-316/U	CENTER CONTACT HOLDER: 2098-5277-10 (T-4581)



ASSEMBLY OPERATIONS

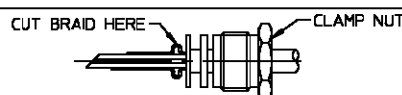
Step 1

- Cut cable outer jacket to dimension shown, 45° angle.
- Place nut (hex first) and wedge (small opening first over jacket) and washer.



Step 2

- Push back braid to expand and facilitate cutting. Cut braid with small pointed scissors at point of widest expansion.



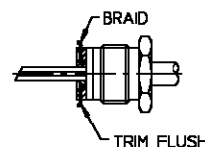
Step 3

- Cut slits in outer jacket, .062 long 3 places approx. 120 deg. apart, to facilitate installation of ferrule (optional).
- Flare out remaining braid, and install collar (tapered end first) and seat firmly.



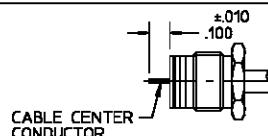
Step 4

- Slide washer, wedge and clamp nut toward collar, such as to clamp braid between the collar and washer.
- Trim braid as close as possible with a small pair of scissors or flush cut wire cutter.



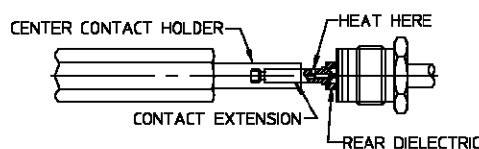
Step 5

- Cut cable dielectric flush with collar.
- Cut cable inner conductor to dimension shown.
- Tin inner conductor.



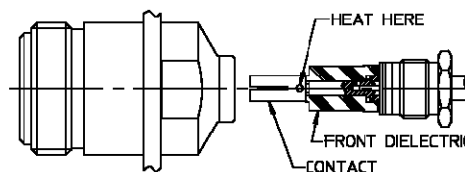
Step 6

- Slide rear dielectric over cable inner conductor.
- Place threaded end of contact extension in holder, heat contact extension and push it over cable inner conductor and into rear dielectric firmly.
- Remove excess solder.



Step 7

- Assemble front dielectric onto contact extension.
- Screw center contact onto contact extension to rest firmly against dielectric.
- Apply soft solder into cross hole of center contact and heat to make solder connection.
- Remove excess solder.
- Engage threads of clamp assembly to housing and torque to 25-30 in-lbs.



Step 8

- Adherence to steps given will yield tolerances shown.

