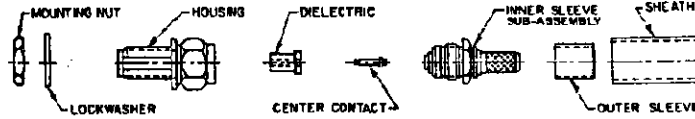


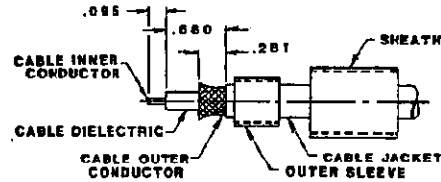
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSSM BULKHEAD FEEDTHROUGH CABLE JACK, CRIMP ATTACHMENT	RD178/U,196 DOUBLE BRAID	CENTER CONTACT HOLDER: 2096-5237-10(T-4578) CRIMP TOOL: 6098-5014-54 (T-4718) CRIMP DIE: 2088-0370-54 (.118 HEX)

CONNECTOR

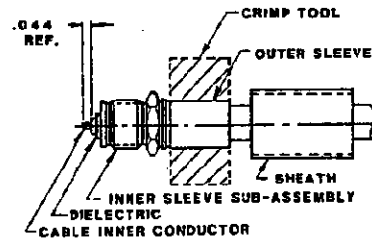


ASSEMBLY OPERATIONS

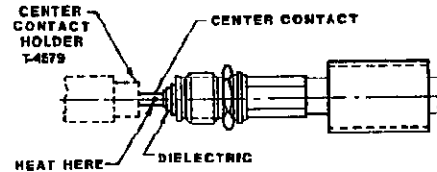
- 1.0 PREPARE COAXIAL CABLE END.
 - 1.1 PLACE CLAMP NUT ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



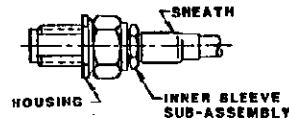
- 2.0 CRIMP CABLE TO INNER SLEEVE SUB-ASSEMBLY.
 - 2.1 TIN INNER CONDUCTOR.
 - 2.2 POSITION AND SECURE INNER SLEEVE SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 2.3 INSERT CABLE INTO INNER SLEEVE SUB-ASSEMBLY AND BEAT FIRMLY.
 - 2.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 2.5 HOLD CABLE FIRMLY SEATED AND CRIMP OUTER SLEEVE IN PLACE.
 - 2.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 3.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.
 - 3.1 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE WITH THE LARGE DIAMETER OF CONTACT RESTING FIRMLY AGAINST DIELECTRIC.
 - 3.2 REMOVE EXCESS SOLDER.



- 4.0 SECURE HOUSING TO INNER SLEEVE SUB-ASSEMBLY AND SHRINK SHEATH.
 - 4.1 ASSEMBLE DIELECTRIC OVER CENTER CONTACT.
 - 4.2 ENGAGE THREADS OF INNER SLEEVE SUB-ASSEMBLY TO HOUSING AND TORQUE TO 25-30 IN. LBS.
 - 4.3 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
 - 4.4 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.



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

