

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE PLUG, RETRACTABLE COUPLING NUT DIRECT SOLDER ATTACHMENT	.141 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5207-54 (T-4700-1) LOCATOR TOOL: 2098-5209-02 (T-4575) DIELECTRIC RECESS TOOL: 2098-5217-54 (T-4582) TRIM TOOL (OPTIONAL): 2098-5222-02 (T-5699)

## CONNECTOR



## ASSEMBLY OPERATIONS

<p>1.0 <u>TRIM CABLE END SQUARE AND DEBURR</u></p>	
<p>2.0 <u>SOLDERING OF CABLE TO HOUSING</u></p> <p>2.1 PLACE CONNECTOR HOUSING ON END OF CABLE</p> <p>2.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.</p> <p>2.2.1 NEST CABLE END IN LOCATOR TOOL.</p> <p>2.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.</p> <p>2.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.</p> <p>2.3 SLIDE HOUSING AGAINST LOCATOR TOOL.</p> <p>2.4 MAINTAIN POSITION OF HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.</p> <p>NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.</p>	
<p>3.0 <u>COMPRESS EXPANDED DIELECTRIC</u></p> <p>3.1 TRIM EXTENDED OR EXPOSED DIELECTRIC FLUSH WITH END OF THE CABLE OUTER CONDUCTOR.</p> <p>3.2 PLACE DIELECTRIC RECESS TOOL ON DIELECTRIC AND PUSH TO RECESS DIELECTRIC WITHIN CABLE OUTER CONDUCTOR.</p>	
<p>4.0 <u>REMOVE OUTER CONDUCTOR AND DIELECTRIC</u></p> <p>4.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #1.</p> <p>4.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.</p> <p>4.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.</p> <p>4.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.</p>	
<p>5.0 <u>TRIM END OF HOUSING SUB-ASSEMBLY (OPTIONAL)</u></p> <p>5.1 PLACE TRIM TOOL OVER INNER CONDUCTOR PROJECTION AND ROTATE TO FACE OFF FRONT FACE.</p> <p>5.2 INSPECT FOR DIMENSIONAL TOLERANCE .0942-.004.</p>	
<p>6.0 <u>SHAPE INNER CONDUCTOR</u></p> <p>6.1 TRIM TO LENGTH AS SHOWN.</p> <p>6.2 FILE BLUNT END OF INNER CONDUCTOR TO AN 75° - 90° CONE.</p>	
<p>7.0 <u>SECURE COUPLING NUT TO HOUSING</u></p> <p>7.1 PLACE GASKET ON HOUSING.</p> <p>7.2 SLIDE COUPLING NUT ONTO HOUSING.</p> <p>7.3 SNAP RETAINING RING IN HOUSING GROOVE JUST BEHIND COUPLING NUT.</p> <p>7.4 COUPLING NUT SHOULD ROTATE FREELY.</p>	