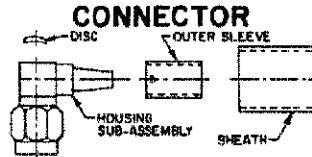
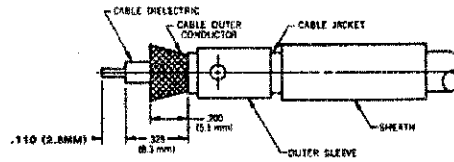


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM RIGHT ANGLE CABLE PLUG SOLDER ATTACHMENT	RG174/U,179 187,188,316 RD 188/U,RD 318/U DOUBLE BRAIDED	LOCATOR TOOL:2098-5218-02(T-2367)

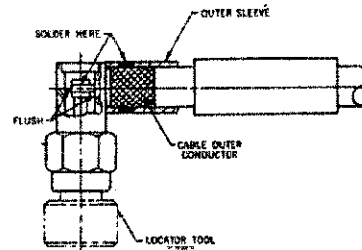


ASSEMBLY OPERATIONS

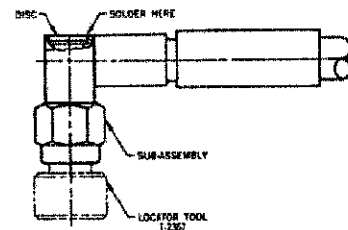
- 1.0 PREPARE COAXIAL CABLE END
 - 1.1 PLACE SHEATH AND OUTER SLEEVE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



- 2.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY
 - 2.1 TIN INNER CONDUCTOR OF CABLE.
 - 2.2 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
 - 2.3 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AS SHOWN.
 - 2.5 PLACE SOLDERING IRON ON CONTACT & SOLDER.
 - 2.6 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR AND SOLDER AS SHOWN.



- 3.0 SEAL OPENING IN HOUSING
 - 3.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY
 - OPTION 1: TIN PERIMETER OF OPENING AND PRESS DISC INTO POSITION; APPLY HEAT TO CAP. DO NOT ALLOW SOLDER TO PENETRATE HOUSING.
 - OPTION 2: DISC MAY BE EPOXIED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.



- 4.0 SHRINK SHEATH TO CABLE
 - 4.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
 - 4.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.
 - 4.3 REMOVE LOCATOR TOOL.

