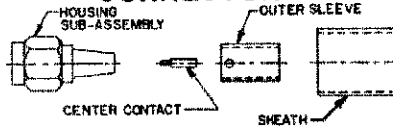


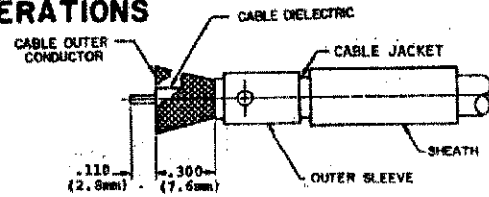
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM Straight Cable Plug Solder Attachment	RG55/U, 58 141, 142, 223, 303, 400	Center Contact Holder: 2098-5221-10 (T-4578) Solder Gage: 2098-5212-02 (T-4562-1) Locator Tool: 2098-5218-02 (T-2367)

CONNECTOR

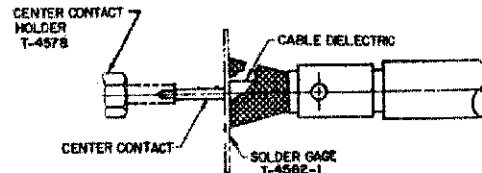


ASSEMBLY OPERATIONS

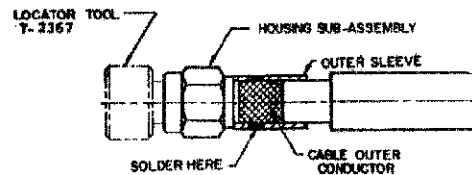
- 1.0 PREPARE COAXIAL CABLE END
 - 1.1 PLACE SHEATH AND OUTER SLEEVE ON CABLE.
 - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 - 1.6 FLARE OUTER CONDUCTOR.



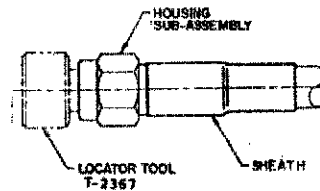
- 2.0 SOLDER CENTER CONTACT TO CABLE INNER CONDUCTOR
 - 2.1 TIN INNER CONDUCTOR.
 - 2.2 PLACE CENTER CONTACT IN HOLDER.
 - 2.3 HEAT CENTER CONTACT WITH SOLDERING IRON AND CAREFULLY PUSH IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST SOLDER GAGE.
 - 2.4 REMOVE EXCESS SOLDER OR SPLATTER.



- 3.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY
 - 3.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
 - 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 3.3 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
 - 3.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 3.5 HOLD CABLE FIRMLY SEATED AND SOLDER THROUGH HOLES IN OUTER SLEEVE.
 - 3.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 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.



- 5.0 INSPECT COMPLETED ASSEMBLY
 - 5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN.

