

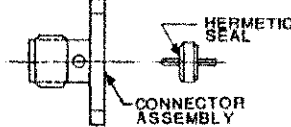
CONNECTOR TYPE

OSCS FLANGE MOUNT
HERMETIC JACK RECEPTACLE
TWO PIECE CONSTRUCTION

TOOLS REQUIRED:

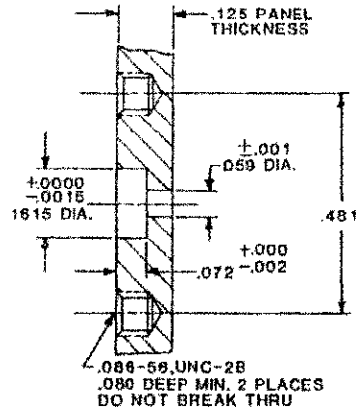
HERMETIC SEAL SOLDERING FIXTURE: 2098-5615-64
HARDWARE NOT SUPPLIED BY MANUFACTURER:
TWO (2) MACHINE SCREWS: .086-56,UNC-2A X .125 LONG
SOLDER PREFORM (TYPE OPTIONAL)

CONNECTOR

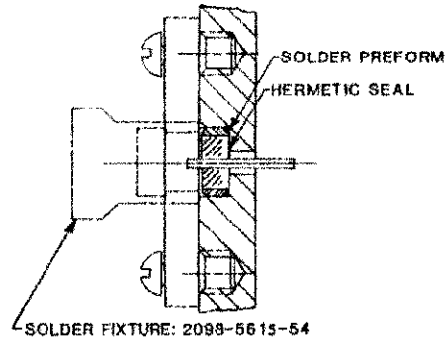


ASSEMBLY OPERATIONS

- 1.0 MOUNTING HOLE PREPARATION**
- 1.1 DRILL .059 ± .001 DIAMETER PILOT HOLE THROUGH PANEL.
 - 1.2 INSERT STEP REAMER INTO PILOT HOLE AND REAM TO DEPTH SHOWN.
 - 1.3 DRILL AND TAP .086-56, UNC-2B THREAD 2 PLACES LOCATED AS SHOWN.



- 2.0 INSTALLATION OF HERMETIC SEAL ASSEMBLY**
- 2.1 ASSEMBLE FLANGE ASSEMBLY, OF HERMETIC SEAL SOLDERING FIXTURE, ONTO PANEL AS SHOWN.
 - 2.2 ASSEMBLE APPROPRIATE SOLDER PREFORM INTO MOUNTING HOLE.
 - 2.3 ASSEMBLE HERMETIC SEAL ASSEMBLY INTO MOUNTING HOLE AS SHOWN.
 - 2.4 THREAD HERMETIC SEAL SOLDERING FIXTURE INTO FLANGE ASSEMBLY AND BOTTOM.
 - 2.5 APPLY SUFFICIENT HEAT TO FLOW SOLDER.
 - 2.6 DISASSEMBLE FLANGE ASSEMBLY AND HERMETIC SEAL SOLDERING FIXTURE.



- 3.0 INSTALLATION OF CONNECTOR ONTO PANEL**
- 3.1 INSTALL CONNECTOR ONTO PANEL AS SHOWN, BEING SURE THAT HERMETIC SEAL PIN ENTERS CENTER CONTACT OF CONNECTOR.
 - 3.2 ASSEMBLY IS NOW COMPLETE.

