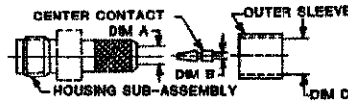


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE JACK CRIMP ATTACHMENT M39012/57-3502	RG 142/U RG 400/U	CENTER CONTACT CRIMP TOOL: M22520/1-01 CRIMP DIE: M22520/1-15 OUTER SLEEVE CRIMP TOOL: M22520/5-01 CRIMP DIE: M22520/5-57 CLOSURE A OPTIONAL: CENTER CONTACT HOLDER: 2068-5221-10 (T-4578) LOCATOR TOOL: 2068-5213-02 (T-946)

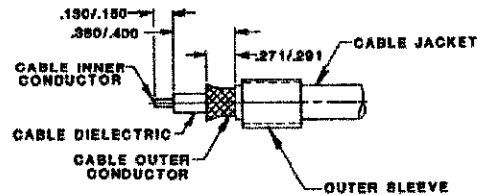
CONNECTOR



ASSEMBLY OPERATIONS

1.0 PREPARE COAXIAL CABLE END

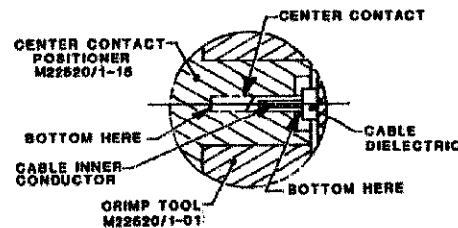
- 1.1 PLACE OUTER SLEEVE ON CABLE.
- 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
- 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
- 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
- 1.5 TRIM INNER CONDUCTOR TO LENGTH.
- 1.6 FLARE OUTER CONDUCTOR.



CRIMP CENTER CONTACT

2.0 CRIMPING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.

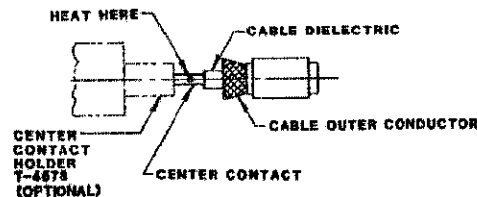
- 2.1 SET SELECTOR KNOB TO NUMBER "3".
- 2.2 PLACE CENTER CONTACT INTO CENTER CONTACT POSITIONER TOOL AND BOTTOM. PROPER POSITIONING OF CENTER CONTACT IN THE POSITIONER TOOL WILL RESULT IN A CONTROLLED COMPENSATION FOR OPTIMUM ELECTRICAL PERFORMANCE.
- 2.3 INSERT CABLE INNER CONDUCTOR INTO CENTER CONTACT AND BOTTOM CABLE IN POSITIONER.
- 2.4 HOLD CABLE FIRMLY SEATED AND CRIMP.



OPTION: SOLDER CENTER CONTACT

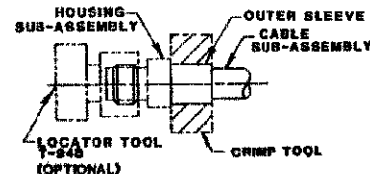
2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.

- 2.1 TIN INNER CONDUCTOR OF CABLE.
- 2.2 PLACE CENTER CONTACT IN HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.
- 2.3 REMOVE EXCESS SOLDER.



3.0 CRIMP CABLE TO INNER SLEEVE

- 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 CRIMP OUTER SLEEVE IN PLACE.
- 3.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



NOTE: ADHERENCE TO STEPS GIVEN WILL
YIELD TOLERANCES SHOWN ON
M39012/57

DIM. A: .122 DIM. B: .041 DIM. C: .220
CENTER CONTACT COLOR BANDS: RED/MAROON