

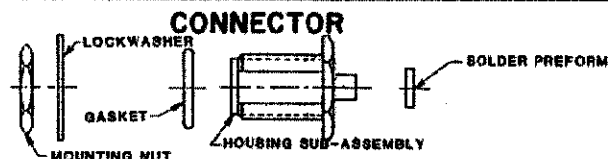
**CONNECTOR
TYPE
TYPE 'N'
BULKHEAD JACK
DIRECT SOLDER
ATTACHMENT**

CABLE TYPE

CT 141-50
COAXIAL CABLE

TOOLS REQUIRED:

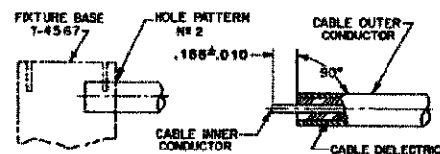
FIXTURE BASE: 2098-5208-54(T-4567)
CLAMP INSERT: 2098-5207-54(T-4700-1)
LOCATOR TOOL: 2098-5276-02(T-4572)



ASSEMBLY OPERATIONS

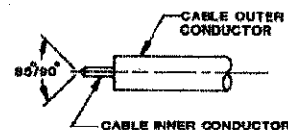
1.0 PREPARATION OF CABLE

- 1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #2.
- 1.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
- 1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.
- 1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.
- 1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR TO DIMENSION SHOWN.



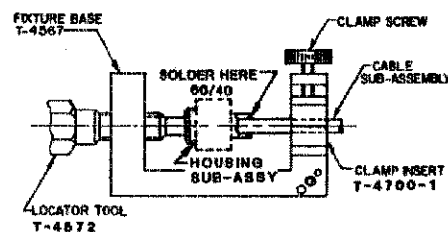
2.0 SHAPE INNER CONDUCTOR OF CABLE

- 2.1 FILE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° CONE.



3.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY

- 3.1 FIXTURE BASE SHOULD BE CLAMPED IN VISE VERTICALLY TO KEEP LOCATOR TOOL SEATED AGAINST FIXTURE BASE WALL.
- 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN LOCATOR TOOL.
- 3.3 CAREFULLY INSERT INNER CONDUCTOR OF CABLE INTO PRE-ASSEMBLED CENTER CONTACT OF HOUSING SUB-ASSEMBLY.
- 3.4 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
- 3.4.1 MAINTAIN SEATED POSITION OF CABLE FIRMLY AND TIGHTEN CLAMP SCREW TO SECURE CABLE.
- 3.5 SOLDER WHERE SHOWN.



4.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY

- 4.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

