

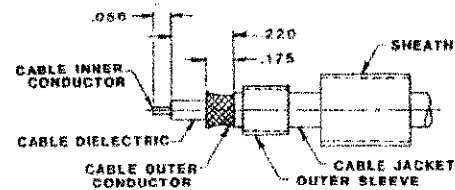
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSMM BULKHEAD FEEDTHROUGH CABLE JACK CRIMP ATTACHMENT	RG17B/U,196	CENTER CONTACT HOLDER:4098-5012-10 SOLDER GAGE:4098-5013-02(T-4582-10) LOCATOR TOOL:4098-5016-02 CRIMP TOOL:2099-0105-54

### CONNECTOR

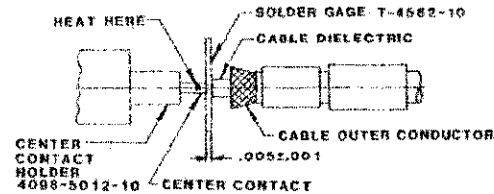


### ASSEMBLY OPERATIONS

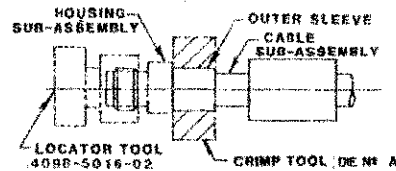
- 1.0 PREPARE COAXIAL CABLE END.
- 1.1 PLACE SHEATH AND SLEEVE ON CABLE.
  - 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
  - 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
  - 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
  - 1.5 TRIM INNER CONDUCTOR TO LENGTH.
  - 1.6 FLARE OUTER CONDUCTOR.



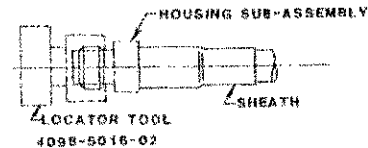
- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.
- 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.
  - 2.3 PLACE CENTER CONTACT IN HOLDER. HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.
  - 2.4 REMOVE SOLDER GAGE AND 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.



- 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.



- 5.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY
- 5.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

