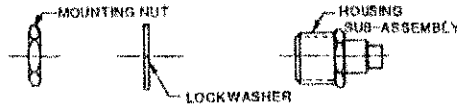


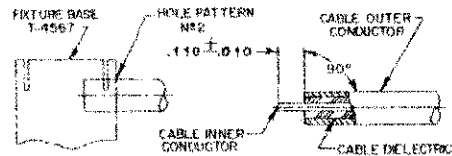
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSP BULKHEAD FEEDTHROUGH CABLE JACK-REAR MOUNT DIRECT SOLDER ATTACHMENT	RG402/U .141 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5206-84 (T-4567) CLAMP INSERT: 2098-5207-84 (T-4700-1) LOCATOR TOOL: 4588-5004-02

## CONNECTOR

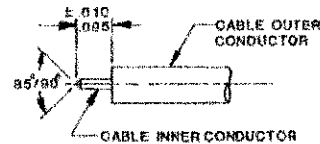


## ASSEMBLY OPERATIONS

- 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 TRIM INNER CONDUCTOR TO LENGTH AS SHOWN.
  - 2.2 FILE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° COME.



- 3.0 SOLDERING OF CABLE TO HOUSING SUB-ASSEMBLY
- 3.1 ASSEMBLE CABLE INTO HOUSING SUB-ASSEMBLY.
    - 3.1.1 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE-ASSEMBLED CENTER CONTACT OF HOUSING SUB-ASSEMBLY.
  - 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
    - 3.2.1 TIGHTEN CLAMP SCREW TO SECURE CABLE.
    - 3.2.2 TIGHTEN LOCATOR TOOL TO SEAT HOUSING SUB-ASSEMBLY FIRMLY.
  - 3.3 MAINTAIN POSITION OF HOUSING SUB-ASSEMBLY FIRMLY AGAINST LOCATOR TOOL AND SOLDER.
- NOTE: FIXTURE BASE SHOULD BE CLAMPED VERTICAL IN A VISE TO KEEP HOUSING SUB-ASSEMBLY SEATED AGAINST LOCATOR TOOL.

