

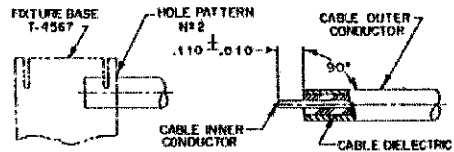
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSSP FLANGE MOUNT CABLE JACK- FLOATING REAR MOUNT DIRECT SOLDER ATTACHMENT	RG405/U .086 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5200-54 (T-4567) CLAMP INSERT: 2098-5200-54 (T-4700-2) LOCATOR TOOL: 4788-8004-02

CONNECTOR

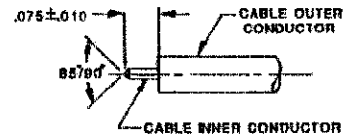


ASSEMBLY OPERATIONS

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



- 3.0 SOLDERING OF CABLE TO CONNECTOR SUB-ASSEMBLY**
- 3.1 ASSEMBLE CABLE INTO CONNECTOR SUB-ASSEMBLY.
 - 3.1.1 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE-ASSEMBLED CENTER CONTACT OF CONNECTOR 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 CONNECTOR SUB-ASSEMBLY FIRMLY.
 - 3.3 MAINTAIN POSITION OF CONNECTOR SUB-ASSEMBLY FIRMLY AGAINST LOCATOR TOOL AND SOLDER.
- NOTE:** FIXTURE BASE SHOULD BE CLAMPED VERTICAL IN A VISE TO KEEP CONNECTOR SUB-ASSEMBLY SEATED AGAINST LOCATOR TOOL.

