Instruction Sheet 408–4675 07 FEB 00 Rev O EC 0990-0134-00

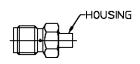
CONNECTOR **TYPE**

OSM STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT

CABLE TYPE TOOLS REQUIRED:

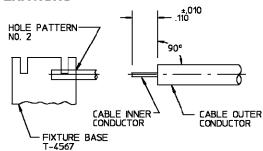
.085 SEMI-RIGID COAXIAL CABLE FIXTURE BASE: 2098-5206-54(T-4567) LOCATOR TOOL: 2098-5625-02(T-948) CLAMP INSERTS: 2098-5208-54(T-4700-2)

CONNECTOR

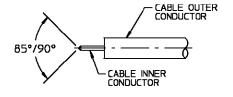


ASSEMBLY OPERATIONS

- PREPERATION OF CABLE 1.0
 - INSERT SQUARED CABLE END INTO FIXTURE
 BASE HOLE PATTERN #2. 1.1
 - PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
 - REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.
 - BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM
 - CABLE
 COMPLETE TRIMMING OF CABLE INNER
 CONDUCTOR TO DIMENSION SHOWN. 1.5



- SHAPE INNER CONDUCTOR OF CABLE
 1 TRIM INNER CONDUCTOR TO LENGTH AS 2.0
 - SHOW. FILE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° CONE.

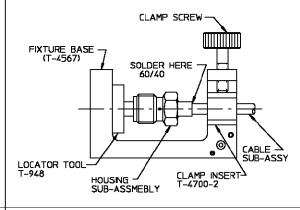


- 3.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY.
 3.1 FIXTURE BASE SHOULD BE CLAMPED IN VISE VERTICALLY TO KEEP LOCATOR TOOL SEATED AGAINST FIXTURE BASE WALL.
 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN LOCATOR TOOL.
 3.3 CAREFULLY INSERT INNER CONDUCTOR OF CABLE INTO PRE-ASSEMBLED CENTER CONTACT OF HOUSING SUB-ASSEMBLY.
 3.4 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOW

 - AS SHOW.

 3.4.1 MAINTAIN SEATED POSITION OF CABLE FIRMLY AND TIGHTEN CLAMP SCREW TO SECURE CABLE.

 3.5 SOLDER WHERE SHOWN.



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

