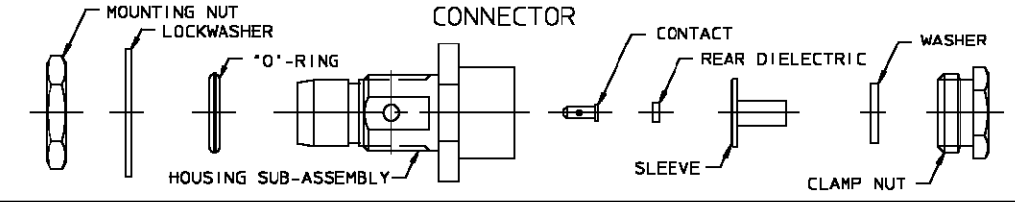
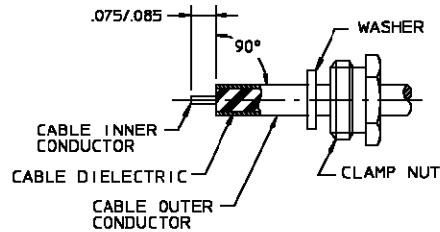


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSP BULKHEAD FEEDTHRU CABLE PLUG SOLDER CLAMP ATTACHMENT	.047 SEMI-RIGID CABLE	FIXTURE BASE: 2098-5206-34 (T-4567) CLAMP INSERT: 2098-5797-34 (T-4700-6) CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) LOCATOR TOOL: 2598-5411-02

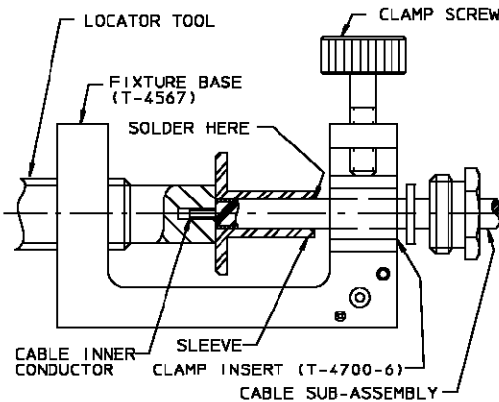


ASSEMBLY OPERATIONS

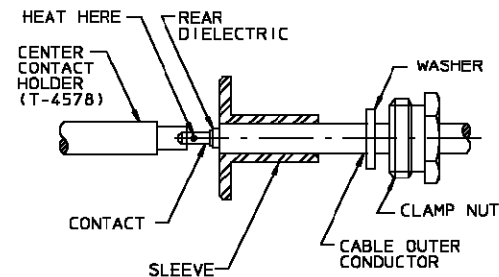
- 1.0 PREPARATION OF CABLE.
 1.1 TRIM CABLE TO DIMENSIONS SHOWN.
 1.2 PLACE CLAMP NUT AND WASHER ON END OF CABLE AND SLIDE BACK OUT OF THE WAY.



- 2.0 SOLDERING OF CABLE SUB-ASSEMBLY TO SLEEVE.
 2.1 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 2.1.1 NEST CABLE INNER CONDUCTOR IN LOCATOR TOOL.
 2.1.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 2.1.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
 2.2 SLIDE SLEEVE AGAINST THE LOCATOR TOOL. MAINTAIN POSITION OF THE SLEEVE FIRMLY AND SOLDER.
 NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP SLEEVE SEATED AGAINST THE REAR DIELECTRIC.



- 3.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.
 3.1 TIN INNER CONDUCTOR OF CABLE.
 3.2 PLACE REAR DIELECTRIC ONTO CABLE INNER CONDUCTOR, FLUSH WITH THE OUTER CONDUCTOR.
 3.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF THE CABLE WITH THE LARGE DIAMETER OF THE CONTACT RESTING FIRMLY AGAINST THE REAR DIELECTRIC.
 3.4 REMOVE EXCESS SOLDER.



- 4.0 SECURE HOUSING SUB-ASSEMBLY TO CLAMP NUT.
 4.1 CAREFULLY INSERT THE CENTER CONTACT INTO THE PRE-ASSEMBLED CENTER CONTACT OF THE HOUSING SUB-ASSEMBLY.
 4.2 ENGAGE THREADS OF THE CLAMP NUT TO HOUSING SUB-ASSEMBLY AND TORQUE TO 7-10 in-lbs.

