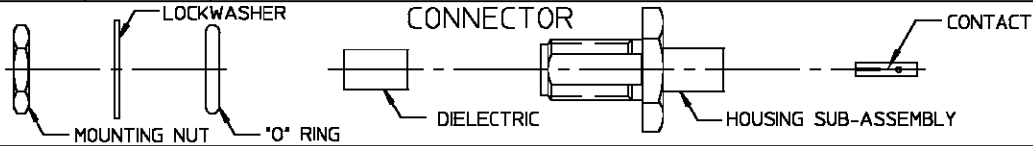
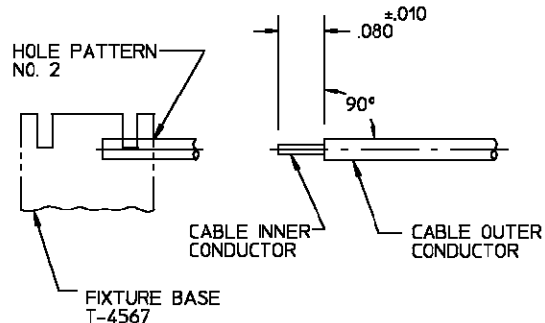


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSM BULKHEAD FEEDTHRU CABLE JACK DIRECT SOLDER ATTACHMENT	.085 DIA SEMI-RIGID CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5208-54 (T-4700-2) CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) SOLDER GAGE: 2098-5212-02 (T-4562-1) LOCATOR TOOL: 2098-5210-02 (T-4569) DIELECTRIC INSERT TOOL: 2098-5215-02 (T-4551)

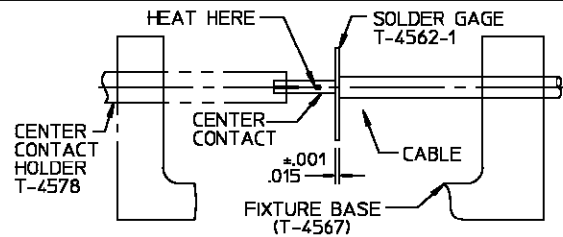


### ASSEMBLY OPERATIONS

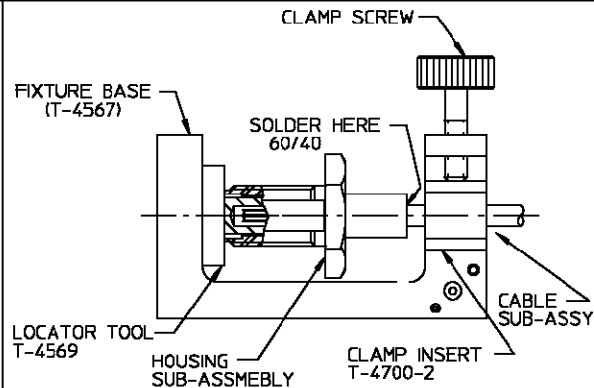
- 1.0 PREPARATION OF CABLE.
  - 1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #2.
  - 1.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.
  - 1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.
  - 1.4 TRIM CABLE INNER CONDUCTOR TO LENGTH.



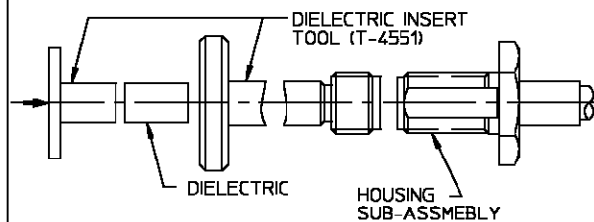
- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.
  - 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.
  - 2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST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



- 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY.
  - 3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.
  - 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
    - 3.2.1 NEST CENTER CONTACT IN LOCATOR TOOL.
    - 3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
    - 3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.
  - 3.3 SLIDE HOUSING OVER LOCATOR TOOL.
  - 3.4 MAINTAIN POSITION OF HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.



- 4.0 PRESSING OF DIELECTRIC INTO HOUSING SUB-ASSEMBLY.
  - 4.1 THREAD INSERT TOOL INTO HOUSING SUB-ASSEMBLY.
  - 4.2 INSERT DIELECTRIC INTO INSERT TOOL HOUSING.
  - 4.3 PLACE INSERT TOOL PLUNGER INTO POSITION AND PRESS UNTIL FLANGE BOTTOMS ON TOOL HOUSING.
  - 4.4 ASSEMBLY IS NOW COMPLETE.



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

