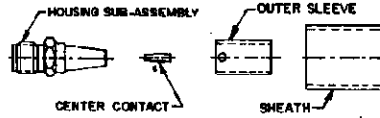


CONNECTOR TYPE OSSM STRAIGHT CABLE JACK SOLDER ATTACHMENT	CABLE TYPE	TOOLS REQUIRED: CENTER CONTACT HOLDER: 2098-5238-10(1-4579) LOCATOR TOOL: 2098-5238-02(1-2108)
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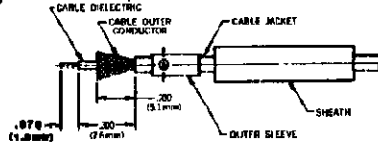
CONNECTOR



ASSEMBLY OPERATIONS

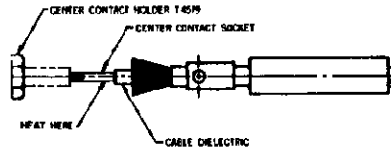
1.0 PREPARE COAXIAL CABLE END

- 1.1 PLACE SHEATH AND OUTER SLEEVE ON CABLE.
- 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
- 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
- 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
- 1.5 TRIM INNER CONDUCTOR TO LENGTH.
- 1.6 FLARE OUTER CONDUCTOR.



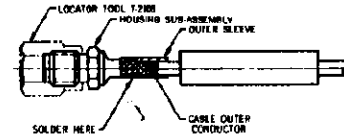
2.0 SOLDER CENTER CONTACT TO CABLE INNER CONDUCTOR

- 2.1 TRIM INNER CONDUCTOR.
- 2.2 PLACE CENTER CONTACT IN HOLDER.
- 2.3 HEAT CENTER CONTACT WITH SOLDERING IRON AND CAREFULLY PUSH IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST DIELECTRIC.
- 2.4 REMOVE EXCESS SOLDER OR SPLATTER.



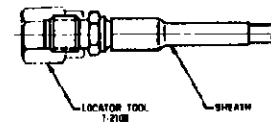
3.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY

- 3.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
- 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 3.3 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
- 3.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 3.5 HOLD CABLE FIRMLY SEATED AND SOLDER THROUGH HOLES IN OUTER SLEEVE.
- 3.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



4.0 SHRINK SHEATH TO CABLE

- 4.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
- 4.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.
- 4.3 REMOVE LOCATOR TOOL.



5.0 INSPECT COMPLETED ASSEMBLY

- 5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN.

