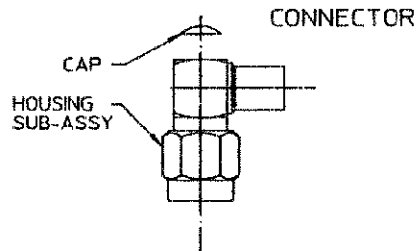


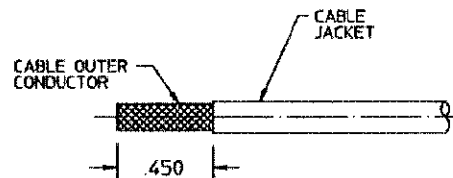
CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OSM RIGHT ANGLE CABLE PLUG, DIRECT SOLDER ATTACHMENT	ADAMS RUSSELL FA19RX	NO SPECIAL TOOLS REQUIRED



ASSEMBLY OPERATIONS

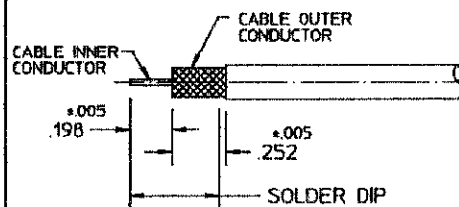
1.0 PREPARATION OF CABLE

- 1.1 REMOVE CABLE JACKET TO DIMENSION SHOWN TO EXPOSE CABLE OUTER CONDUCTOR.



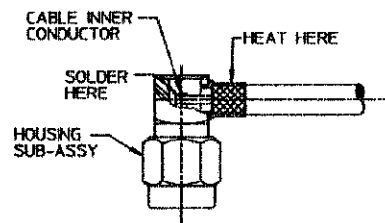
2.0 SOLDER DIPPING OUTER AND INNER CONDUCTOR

- 2.1 TRIM OUTER CONDUCTOR AND CABLE DIELECTRIC TO LENGTH SHOWN TO EXPOSE INNER CONDUCTOR
- 2.2 TRIM INNER CONDUCTOR TO LENGTH
- 2.3 SOLDER DIP COMPLETE CABLE END AS SHOWN BY DIPPING INTO SOLDER POT, SOLDERING FOIL ONTO BRAID AND TINNING BRAID.



3.0 SOLDERING OF CABLE INNER CONDUCTOR TO CENTER CONTACT AND CABLE TO HOUSING SUB-ASSY

- 3.1 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 3.2 INSERT CABLE INTO HOUSING SUB-ASSEMBLY UNTIL IT BOTTOMS
- 3.2.1 NEST CABLE INNER CONDUCTOR IN CENTER CONTACT SLOT
- 3.3 HOLDING CABLE FIRMLY PLACE SOLDERING IRON ON TIP OF CENTER CONTACT AND SOLDER.
- 3.4 SOLDER HOUSING SUB-ASSY TO CABLE AS SHOWN.



4.0 SEAL OPENING IN HOUSING

- 4.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSY

OPTION 1: TIN PERIMETER OF OPENING AND PRESS DISC INTO POSITION. APPLY HEAT TO CAP. DO NOT ALLOW SOLDER TO PENETRATE INTO HOUSING.

OPTION 2: DISC MAY BE EPOXIED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INTO HOUSING.

