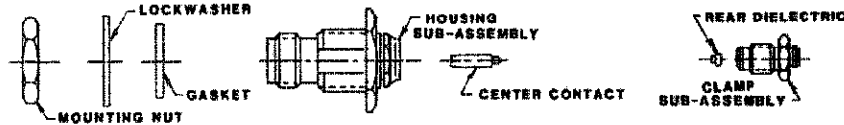


CONNECTOR TYPE OST BULKHEAD FEEDTHROUGH CABLE JACK SOLDER CLAMP ATTACHMENT	CABLE TYPE .065 SEMI-RIGID COAXIAL CABLE .141 SEMI-RIGID COAXIAL CABLE .141 SEMI-RIGID MICROPOROUS CABLE	TOOLS REQUIRED: FIXTURE BASE:2098-5206-54(T-4567) CLAMP INSERTS:2098-5207-54(T-4700-1) 2098-5208-54(T-4700-2) CENTER CONTACT HOLDER:2098-5276-10(T-4580) LOCATOR TOOL:2098-5276-02(T-4572)
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CONNECTOR



ASSEMBLY OPERATIONS

<p>1.0 PREPARATION OF CABLE 1.1 TRIM CABLE JACKET TO DIMENSION SHOWN.</p>	
<p>2.0 SOLDERING OF CABLE TO CLAMP ASSEMBLY 2.1 PLACE CLAMP ASSEMBLY ON END OF TRIMMED CABLE. 2.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN. 2.2.1 REST CABLE IN LOCATOR TOOL. 2.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE. 2.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY. 2.3 SLIDE CLAMP ASSEMBLY AGAINST LOCATOR TOOL. 2.4 MAINTAIN POSITION OF CLAMP ASSEMBLY AGAINST LOCATOR TOOL AND SOLDER. NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP CLAMP ASSEMBLY SEATED AGAINST LOCATOR TOOL.</p>	
<p>3.0 TRIMMING OF CABLE INNER CONDUCTOR 3.1 TRIM CABLE DIELECTRIC FLUSH WITH SLEEVE. 3.2 TRIM INNER CONDUCTOR OF CABLE TO .095 + .010. 3.3 TIN INNER CONDUCTOR OF CABLE (DO NOT ALLOW EXCESSIVE BUILD-UP OF SOLDER).</p>	
<p>4.0 PRESSING OF REAR DIELECTRIC INTO SLEEVE. 4.1 PRESS REAR DIELECTRIC INTO SLEEVE AS SHOWN.</p>	
<p>5.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR 5.1 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST REAR DIELECTRIC. 5.2 REMOVE EXCESS SOLDER.</p>	
<p>6.0 ASSEMBLE HOUSING SUB-ASSEMBLY ONTO CLAMP SUB-ASSEMBLY. 6.1 CAREFULLY INSERT THE CENTER CONTACT INTO THE DIELECTRIC I.D. OF THE HOUSING SUB-ASSEMBLY. 6.2 ENGAGE THREADS OF CLAMP NUT TO HOUSING SUB-ASSEMBLY AND TORQUE TO 25-30 IN.LBS. 6.3 ASSEMBLY IS NOW COMPLETE.</p>	
<p>7.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY. 7.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.</p>	