

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSP FLOATING PANEL FEEDTHRU REAR MOUNT CABLE JACK-CRIMP ATTACHMENT	RG174/U,179 187,188,316	CRIMP TOOL:6608-5014(T-4718) CRIMP DIE:6608-5015-54(T-4702-1)DIE NO C

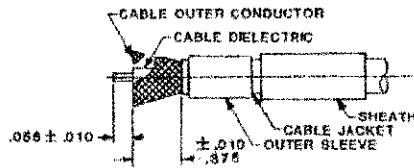
### CONNECTOR



### ASSEMBLY OPERATIONS

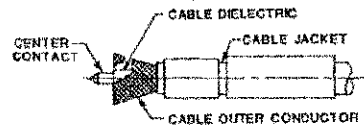
#### 1.0 PREPARE COAXIAL CABLE END.

- 1.1 PLACE SHEATH AND 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.



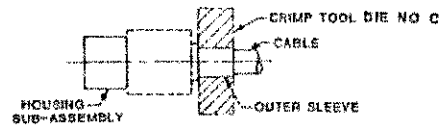
#### 2.0 SOLDER CENTER CONTACT TO CABLE INNER CONDUCTOR

- 2.1 TIN INNER CONDUCTOR.
- 2.2 HEAT CENTER CONTACT WITH SOLDERING IRON AND CAREFULLY PUSH IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST DIELECTRIC.
- 2.3 REMOVE EXCESS SOLDER OR SPATTER.



#### 3.0 CRIMP CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY

- 3.1 BEING SURE THAT THE CENTER CONTACT ENTERS THE PRE-ASSEMBLED HOUSING CONTACT; INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT CABLE FIRMLY.
- 3.2 SLIDE OUTER SLEEVE OVER FLARED PORTION OF CABLE OUTER CONDUCTOR.
- 3.3 HOLD CABLE FIRMLY SEATED AND CRIMP OUTER SLEEVE IN PLACE.
- 3.4 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 ASSEMBLY IS NOW COMPLETE.

