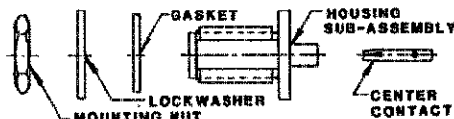


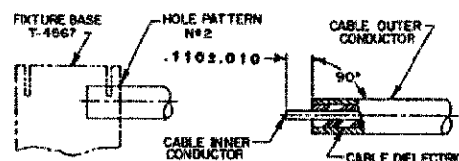
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OST STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT	.141 SEMI-RIGID MICROPOROUS .141 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5207-54 (T-4700-1) CENTER CONTACT HOLDER: 2098-5279-10 (T-4580) SOLDER GAGE: 2098-5281-02 (T-4562-6) LOCATOR TOOL: 2098-5283-02 (T-4574)

### CONNECTOR

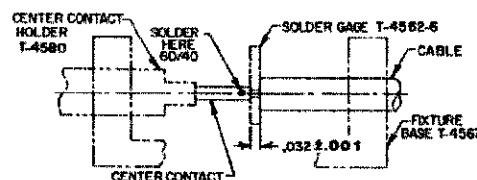


### ASSEMBLY OPERATIONS

- 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 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.

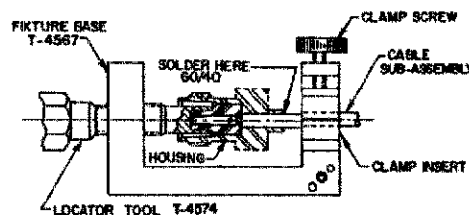


- 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.**
- 2.1 TIN INNER CONDUCTOR OF CABLE.
  - 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.
  - 2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST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



- 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO HOUSING.**
- 3.1 PLACE CONNECTOR HOUSING ON END OF CABLE SUB-ASSEMBLY.
  - 3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
  - 3.2.1 TIGHTEN CLAMP SCREW TO SECURE CABLE.
  - 3.2.2 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY AGAINST HOUSING.
  - 3.3 SOLDER CABLE TO HOUSING SUB-ASSEMBLY AS SHOWN.

NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY TO KEEP HOUSING SEATED AGAINST LOCATOR TOOL.



- 4.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY**
- 4.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.

