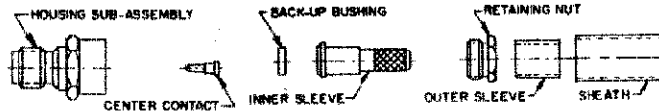


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM Straight Cable Jack Crimp Attachment	RG 58/U, 141, 303	Center Contact Holder 2098-5221-10 (T4578) Crimp Tool 2098-0105-54 Die No. B

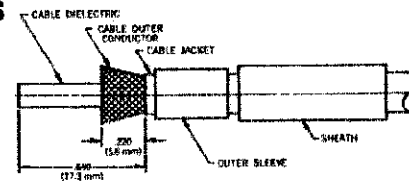
CONNECTOR



ASSEMBLY OPERATIONS

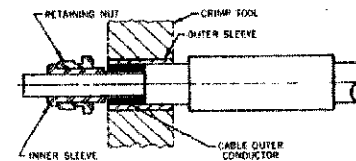
1.0 PREPARE COAXIAL CABLE END

- 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 FLARE OUTER CONDUCTOR.



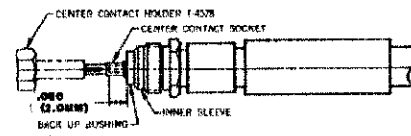
2.0 CRIMP CABLE TO INNER SLEEVE

- 2.1 INSERT INNER SLEEVE INTO RETAINING NUT.
- 2.2 POSITION LOOSE UNIT ON DIELECTRIC AS SHOWN.
- 2.3 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 2.4 HOLD RETAINER UNIT SEATED AND CRIMP OUTER SLEEVE IN PLACE. (SEE NOTE FOR SUGGESTED CRIMP TOOL SELECTION).
- 2.5 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



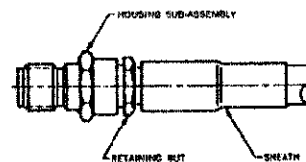
3.0 SOLDER CENTER CONTACT TO CABLE INNER CONDUCTOR

- 3.1 TRIM CABLE DIELECTRIC FLUSH WITH END OF INNER SLEEVE TO EXPOSE INNER CONDUCTOR.
- 3.2 PLACE BACK UP BUSHING ON INNER CONDUCTOR.
- 3.3 TRIM AND DE-BURR INNER CONDUCTOR PROJECTION TO LENGTH AS SHOWN.
- 3.4 TIN INNER CONDUCTOR.
- 3.5 PLACE CENTER CONTACT IN HOLDER.
- 3.6 HEAT CENTER CONTACT WITH SOLDERING IRON AND CAREFULLY PUSH IT OVER INNER CONDUCTOR TO REST FIRMLY AGAINST BUSHING.
- 3.7 REMOVE EXCESS SOLDER OR SPLATTER.



4.0 SECURE HOUSING TO RETAINING NUT AND SHRINK SHEATH

- 4.1 CAREFULLY INSERT THE CENTER CONTACT INTO THE DIELECTRIC BUSHING I.D. OF THE HOUSING SUB-ASSEMBLY.
- 4.2 ENGAGE THREADS OF RETAINING NUT TO HOUSING AND TORQUE TO 12-15 IN.-LBS.
- 4.3 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
- 4.4 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.



5.0 INSPECT COMPLETED ASSEMBLY

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

