

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSP FLANGE MOUNT CABLE JACK- FLOATING REAR MOUNT DIRECT SOLDER ATTACHMENT	RQ405/U .085 SEMI-RIGID COAXIAL CABLE	FIXTURE BASE: 2098-5208-54 (T-4567) CLAMP INSERT: 2098-5208-54 (T-4700-2) LOCATOR TOOL: 4588-5004-02

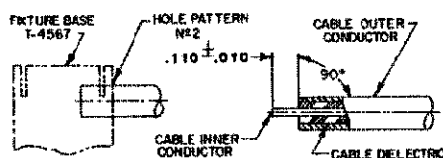
CONNECTOR



ASSEMBLY OPERATIONS

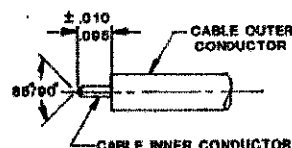
1.0 PREPARATION OF CABLE

- 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.
- 1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR TO DIMENSION SHOWN.



2.0 SHAPE INNER CONDUCTOR OF CABLE

- 2.1 FILE INNER CONDUCTOR TO LENGTH AS SHOWN.
- 2.2 FILE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° CONE.



3.0 SOLDERING OF CABLE TO CONNECTOR SUB-ASSEMBLY

- 3.1 ASSEMBLE CABLE INTO CONNECTOR SUB-ASSEMBLY.
 - 3.1.1 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE-ASSEMBLED CENTER CONTACT OF CONNECTOR 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 CONNECTOR SUB-ASSEMBLY FIRMLY.
- 3.3 MAINTAIN POSITION OF CONNECTOR SUB-ASSEMBLY FIRMLY AGAINST LOCATOR TOOL AND SOLDER.

NOTE: FIXTURE BASE SHOULD BE CLAMPED VERTICAL IN A VISE TO KEEP CONNECTOR SUB-ASSEMBLY SEATED AGAINST LOCATOR TOOL.

