

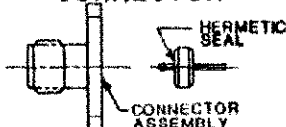
CONNECTOR TYPE

OSM HERMETIC JACK
FLANGE MOUNT FIELD REPLACEABLE
SOLDER ON GLASS SEAL

TOOLS REQUIRED:

HERMETIC SEAL SOLDERING FIXTURE: 2098-5615-54
HARDWARE NOT SUPPLIED BY MANUFACTURER:
FOUR (4) MACHINE SCREWS: #2-56, UNC-2A X .125 LONG
SOLDER PREFORM (TYPE OPTIONAL) .015-.020 RECOMMENDED DIA.

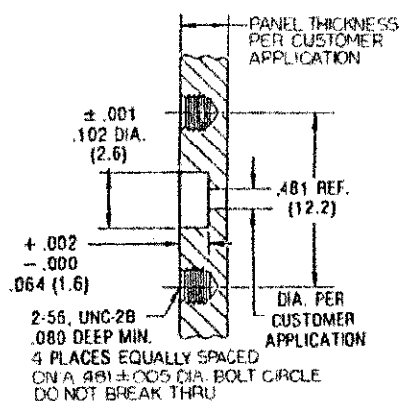
CONNECTOR



ASSEMBLY OPERATIONS

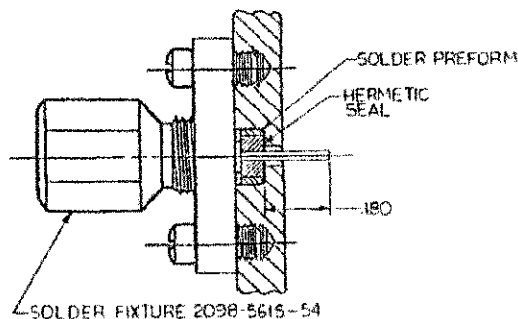
1.0 MOUNTING HOLE PREPARATION

- 1.1 DRILL PILOT HOLE THRU PANEL
DIAMETER PER CUSTOMER APPLICATION.
- 1.2 INSERT STEP REAMER INTO PILOT
HOLE AND REAM .102 $\pm$.001 DIA HOLE TO
DEPTH AS SHOWN.
- 1.3 DRILL AND TAP #2-56UNC-2B
THREAD 4 PLACES AS SHOWN.
- 1.4 PLATE PER CUSTOMER APPLICATION
- 1.5 CLEAN IN SOLVENT



2.0 INSTALLATION OF HERMETIC SEAL ASSEMBLY

- 2.1 CLEAN HERMETIC SEAL IN SOLVENT (DO
NOT HANDLE HERMETIC SEALS AFTER CLEANING)
- 2.2 ASSEMBLE FLANGE ASSEMBLY, OF HERMETIC
SEAL SOLDERING FIXTURE, ONTO PANEL
AS SHOWN.
- 2.3 ASSEMBLE APPROPRIATE SOLDER PREFORM INTO
MOUNTING HOLE.
- 2.4 THINLY COAT O.D. OF HERMETIC SEAL WITH
FLUX (DO NOT FLUX CONTACT EXTENSION).
- 2.5 USING TWEEZERS, ASSEMBLE HERMETIC SEAL
ASSEMBLY INTO MOUNTING HOLE AS SHOWN.
- 2.6 THREAD HERMETIC SEAL SOLDERING FIXTURE
INTO FLANGE ASSEMBLY AND BOTTOM.
- 2.7 APPLY SUFFICIENT HEAT TO FLOW SOLDER.
- 2.8 DISASSEMBLE FLANGE ASSEMBLY AND HERMETIC
SEAL SOLDERING FIXTURE.



3.0 INSTALLATION OF CONNECTOR ONTO PANEL

- 3.1 INSTALL CONNECTOR ONTO PANEL AS
SHOWN, BEING SURE THAT HERMETIC
SEAL PIN ENTERS CENTER CONTACT OF
CONNECTOR.
- 3.2 ASSEMBLY IS NOW COMPLETE.

