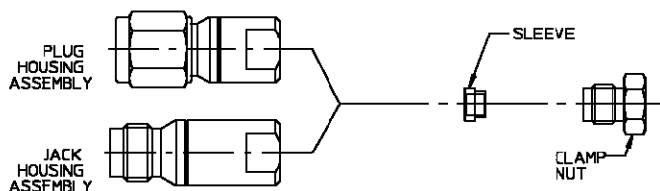


CONNECTOR TYPE	CABLE TYPE	TOOLS REQ'D
OS-50 STRAIGHT CABLE CONNECTORS SOLDER CLAMP ATTACHMENT	.085 S/R COAXIAL CABLE	FIXTURE BASE: 2098-5206-54 CLAMP INSERT: 2098-5208-54 INTERFACE LOCATING TOOL: 2598-5110-02 METAL FILE, SOLDER (60/40), FLUX, CLEANING ALCOHOL, RAZOR BLADE

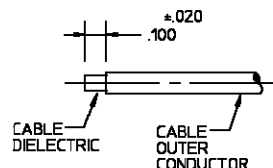
CONNECTOR

■ NOTE: THIS AP CAN BE USED FOR
FLANGE MOUNT AND BULKHEAD
FEEDTHRU CONNECTORS ALSO.

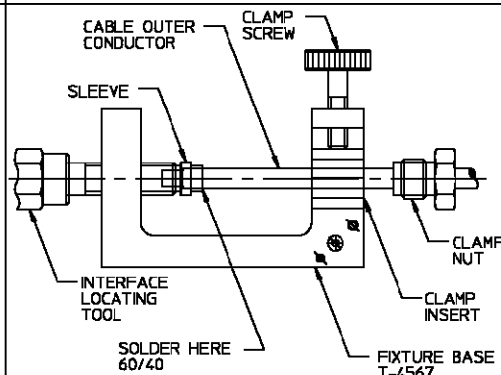


ASSEMBLY OPERATIONS

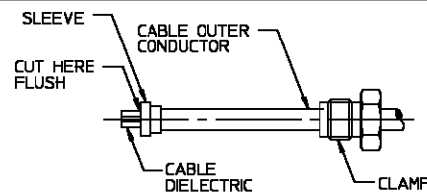
- 1.0 PREPARATION OF COAXIAL CABLE:
 - 1.1 CUT CABLE TO DESIRED LENGTH.
 - 1.2 TRIM END OF CABLE TO DIMENSION SHOWN TO EXPOSE CABLE DIELECTRIC.
 - 1.3 REMOVE BURRS AND CLEAN WITH ALCOHOL.



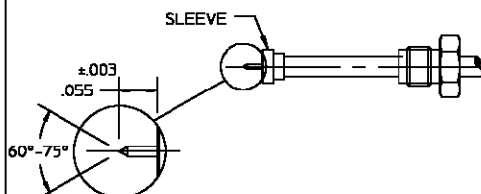
- 2.0 SOLDERING OF SLEEVE TO CABLE:
 - 2.1 PLACE THE CLAMP NUT ON CABLE WITH EXTERIOR THREAD FACING TOWARD THE CUT END OF THE CABLE.
 - 2.2 PLACE THE SLEEVE ON THE CABLE WITH THE LARGER DIAMETER OF THE SLEEVE CLOSEST TO THE CABLE END. PUSH SLEEVE UNTIL FIRMLY SEATED AGAINST THE CABLE.
 - 2.3 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.
 - 2.3.1 NEST EXPOSED DIELECTRIC INTO INTERFACE LOCATING TOOL, BOTTOMING SLEEVE AGAINST LOCATOR TOOL AS SHOWN.
 - 2.3.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.
 - 2.3.3 ENSURE LOCATOR TOOL IS FIRMLY SEATED AGAINST THE SLEEVE.
 - 2.4 MAINTAIN POSITION OF SLEEVE AGAINST LOCATOR TOOL AND APPLY A SMALL AMOUNT OF FLUX AROUND THE CABLE/SLEEVE JUNCTION. APPLY ONLY ENOUGH SOLDER TO FIRMLY ATTACH THE SLEEVE TO THE CABLE.
 - 2.5 VERIFY THAT NO VOIDS EXIST AT EITHER END OF SLEEVE.
 - 2.6 REMOVE EXCESS SOLDER OR SPLATTER.



- 3.0 TRIMMING CABLE DIELECTRIC:
 - 3.1 PLACE CUTTING BLADE FLUSH WITH SLEEVE FACE AND CUT THROUGH THE DIELECTRIC WHILE ROTATING THE CABLE. A CUTTING OR SLICING MOTION WILL WORK EASIER THAN A SAWING MOTION.
 - 3.2 FINISH CUTTING DIELECTRIC WITH CUTTING BLADE TAKING CARE NOT TO SCORE THE CENTER CONDUCTOR OF CABLE. BARE INNER CONDUCTOR BY PRYING THE DIELECTRIC FROM THE CABLE.



- 5.0 TRIM END OF CLAMP ASSEMBLY:
 - 5.1 CUT EXPOSED CENTER CONDUCTOR TO DIMENSION SHOWN.
 - 5.2 FILE BLUNT END OF INNER CONDUCTOR TO A 60°-75° CONE AS SHOWN, MAINTAINING .055 ±.003 DIMENSION.
 - 5.3 CLEAN WITH ALCOHOL.



- 5.0 SECURE HOUSING ASSEMBLY TO CABLE ASSEMBLY:
 - 5.1 INSERT THE CABLE SUB-ASSY INTO THE HOUSING SO THAT THE CABLE CENTER CONDUCTOR IS ACCEPTED BY THE CONTACT IN THE CONNECTOR.
 - 5.2 HOLDING THE CABLE STEADY, SLIDE NUT FORWARD AS SHOWN.
 - 5.3 ENGAGE THREADS OF NUT TO HOUSING ASSEMBLY AND TORQUE TO 25 in.-lbs.

