

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM Straight Cable Jack Crimp Attachment	RG-174/U	Crimp Tool: 2098-0105-54 Center Contact Holder: 2098-5221-10 (T-4578)
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. 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 INNER SLEEVE SUB-ASSEMBLY AND SHRINK SHEATH 4.1 ASSEMBLE DIELECTRIC OVER CENTER CONTACT. 4.2 ENGAGE THREADS OF INNER SLEEVE SUB-ASSEMBLY 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.		