

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSN STRAIGHT CABLE JACK DIRECT SOLDER ATTACHMENT		FIXTURE BASE: 2098-5208-54(T-4567) CLAMP INSERT: 2098-5207-54(T-4700-1) CENTER CONTACT HOLDER: 2098-5277-02(T-4581) SOLDER GAGE: 2098-5212-02(T-4562-1) LOCATOR TOOL: 2098-5276-02(T-4572)
<b>CONNECTOR</b>		
<b>ASSEMBLY OPERATIONS</b>		
<p><b>1.0 PREPARATION OF CABLE</b></p> <p>1.1 INSERT SQUARED CABLE END INTO FIXTURE BASE HOLE PATTERN #2.</p> <p>1.2 PLACE SAW IN SAW SLOT AND CUT THROUGH OUTER CONDUCTOR AND INTO DIELECTRIC WHILE ROTATING CABLE.</p> <p>1.3 REMOVE CABLE FROM FIXTURE AND FINISH CUTTING DIELECTRIC WITH CUTTING BLADE.</p> <p>1.4 BARE INNER CONDUCTOR BY PRYING CUT OUTER CONDUCTOR AND DIELECTRIC FROM CABLE.</p>		
<p><b>2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR.</b></p> <p>2.1 TIN INNER CONDUCTOR OF CABLE.</p> <p>2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR. FLUSH WITH END OF OUTER CONDUCTOR.</p> <p>2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.</p> <p>2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER.</p> <p>*FOR MICROPOROUS CABLE DO NOT USE FLUX OR SOLVENT IN CABLE DIELECTRIC AREA.</p>		
<p><b>3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO REAR HOUSING.</b></p> <p>3.1 PLACE REAR HOUSING ON END OF CABLE SUB-ASSEMBLY.</p> <p>3.2 PLACE LOOSE ASSEMBLY IN FIXTURE BASE AS SHOWN.</p> <p>3.2.1 REST CENTER CONTACT IN LOCATOR TOOL.</p> <p>3.2.2 TIGHTEN CLAMP SCREW TO SECURE CABLE.</p> <p>3.2.3 TIGHTEN LOCATOR TOOL TO SEAT CABLE FIRMLY.</p> <p>3.3 SLIDE REAR HOUSING OVER LOCATOR TOOL.</p> <p>3.4 MAINTAIN POSITION OF REAR HOUSING FIRMLY AGAINST LOCATOR TOOL AND SOLDER.</p> <p>NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE TO KEEP REAR HOUSING SEATED AGAINST LOCATOR TOOL.</p>		
<p><b>4.0 INSERT DIELECTRIC AND ASSEMBLE "O" RING.</b></p> <p>4.1 INSERT THE DIELECTRIC BUSHING (COUNTERBORE TOWARD FRONT) OVER THE CENTER CONTACT INTO THE HOUSING.</p> <p>4.2 ASSEMBLE "O" RING ONTO REAR HOUSING AS SHOWN.</p>		
<p><b>5.0 ASSEMBLE HOUSING ONTO REAR HOUSING SUB-ASSEMBLY.</b></p> <p>5.1 SECURE HOUSING TO THREADS OF REAR HOUSING SUB-ASSEMBLY.</p> <p>5.2 TIGHTEN WITH A TORQUE OF 25-30 IN.LBS.</p>		
<p><b>6.0 INSPECTION OF COMPLETED CONNECTOR ASSEMBLY.</b></p> <p>6.1 ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN.</p>		