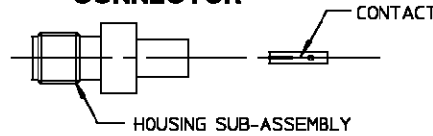


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OST STRAIGHT CABLE JACK DIRECT SOLDER ATTACH	.085 SEMI-RIGID COAX CABLE	FIXTURE BASE: 2098-5206-54 (T-4567) CLAMP INSERT: 2098-5208-54 (T-4700-2) CENTER CONTACT HOLDER: 2098-5279-10 (T-4580) SOLDER GAGE: 2098-5281-02 (T-4562-6) LOCATOR TOOL: 2098-5283-02 (T-4574)

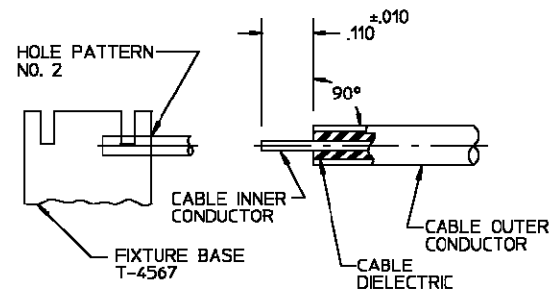
### CONNECTOR



### ASSEMBLY OPERATIONS

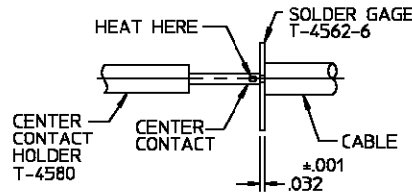
#### 1.0 PREPARATION OF CABLE.

- 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.



#### 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

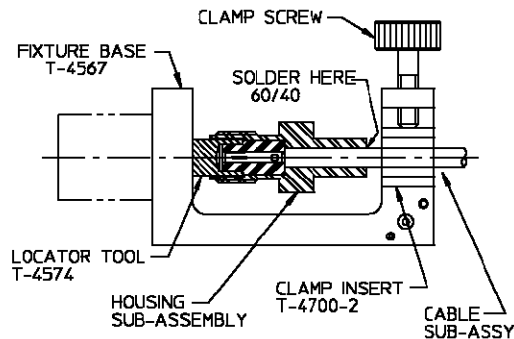
- 2.1 TIN INNER CONDUCTOR OF CABLE.
- 2.2 PLACE SOLDER GAGE ON INNER CONDUCTOR, FLUSH WITH END OF OUTER CONDUCTOR.
- 2.3 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST SOLDER GAGE.
- 2.4 REMOVE SOLDER GAGE AND EXCESS SOLDER.



#### 3.0 SOLDERING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY.

- 3.1 PLACE CONNECTOR HOUSING SUB-ASSEMBLY ON END OF CABLE 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 CABLE FIRMLY.
- 3.3 SOLDER CABLE TO HOUSING SUB-ASSEMBLY AS SHOWN.

NOTE: FIXTURE SHOULD BE CLAMPED VERTICALLY IN VISE.



NOTES:  
 INTERFACE DIMENSIONS PER MIL-STD-384A-313.2