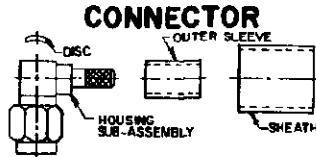
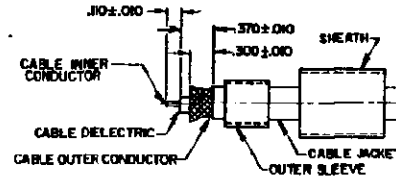


CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSSM RIGHT ANGLE CABLE PLUG CRIMP ATTACHMENT	RG174/U,179 187,188,316	LOCATOR TOOL 2098-5238-021T-1000 CRIMP TOOL 2098-0105-04 DIE #FC

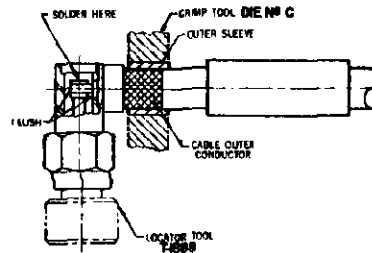


## ASSEMBLY OPERATIONS

- 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 TRIM CABLE DIELECTRIC TO LENGTH.  
 1.5 TRIM INNER CONDUCTOR TO LENGTH.  
 1.6 FLARE OUTER CONDUCTOR.

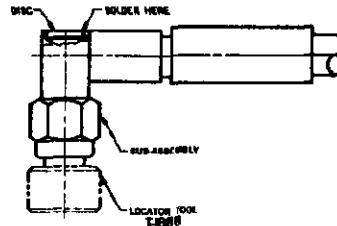


- 2.0 SOLDERING OF CABLE INNER CONDUCTOR TO HOUSING SUB-ASSEMBLY**  
 2.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.  
 2.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.  
 2.3 TIN INNER CONDUCTOR OF CABLE.  
 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY.  
 2.4.1 NEST INNER CONDUCTOR IN CONTACT SLOT.  
 2.4.2 HOLD DIELECTRIC FLUSH AS SHOWN.  
 2.5 PLACE SOLDERING IRON ON TIP OF CONTACT AND SOLDER.



- 3.0 CRIMPING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY**  
 3.1 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.  
 3.2 CRIMP OUTER SLEEVE IN PLACE.  
 3.3 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.

- 4.0 SEAL OPENING IN HOUSING**  
 4.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY
- OPTION 1:** TIN PERIMETER OF OPENING AND PRESS DISC INTO POSITION; APPLY HEAT TO CAP, DO NOT ALLOW SOLDER TO PENETRATE HOUSING.
- OPTION 2:** DISC MAY BE EPOXYED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.



- 5.0 SHRINK SHEATH TO CABLE**  
 5.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.  
 5.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.  
 5.3 REMOVE LOCATOR TOOL.

