

CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSSM RIGHT ANGLE CABLE PLUG DIRECT SOLDER ATTACHMENT	.085 SEMI-RIGID COAXIAL CABLE  .070 SEMI-RIGID COAXIAL CABLE	

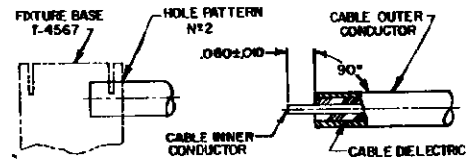
## CONNECTOR



## ASSEMBLY OPERATIONS

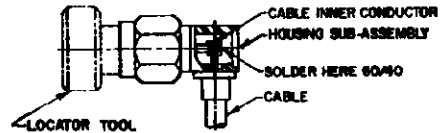
### 1.0 PREPARATION OF CABLE

- 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.
- 1.5 COMPLETE TRIMMING OF CABLE INNER CONDUCTOR TO DIMENSION SHOWN.



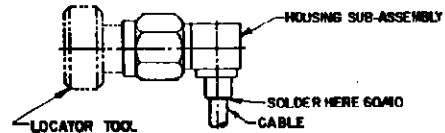
### 2.0 SOLDERING OF CENTER CONTACT TO CABLE INNER CONDUCTOR

- 2.1 SECURE LOCATOR TOOL TO THREADS OF COUPLING NUT.
- 2.2 TIN INNER CONDUCTOR OF CABLE.
- 2.3 POSITION CABLE INNER CONDUCTOR IN CENTER CONTACT SLOT AND OUTER CONDUCTOR FLUSH WITH HOUSING I.D.
- 2.4 PLACE PRE-HEATED SOLDERING IRON ON TIP OF CONTACT AND SOLDER AS SHOWN.



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

- 3.1 SOLDER HOUSING SUB-ASSEMBLY TO CABLE AS SHOWN.



### 4.0 SEAL OPENING IN HOUSING

- 4.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY
  - 4.2 REMOVE LOCATOR TOOL.
- 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 EPOXIED INTO PLACE, DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.

