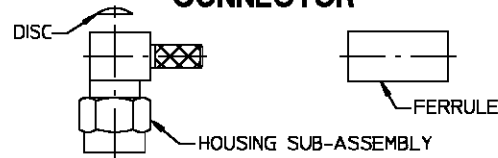


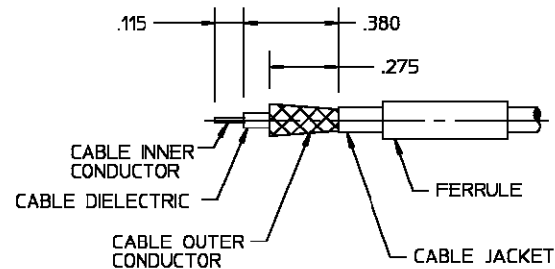
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM RIGHT ANGLE CABLE PLUG CRIMP ATTACHMENT	SEE TABLE	LOCATOR TOOL: 2098-5218-02 (T-2367) CRIMP TOOL: 5698-5014-54 CRIMP DIE: SEE TABLE OPTIONAL CRIMP TOOLING: CRIMP TOOL: 2598-5006-54 CRIMP DIES: 2598-5007-54 (.213 HEX & .128 HEX) 2598-5380-54 (.151 HEX)

CONNECTOR

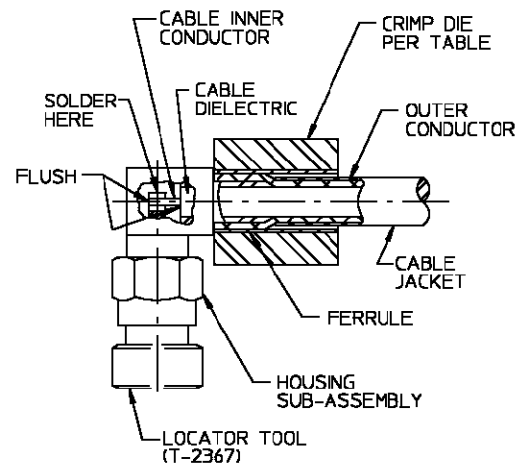


ASSEMBLY OPERATIONS

- 1.0 PREPARE COAXIAL CABLE END
- 1.1 PLACE FERRULE 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.

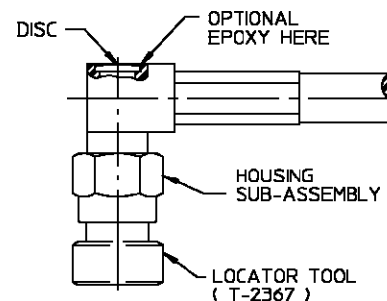


- 2.0 SOLDERING OF CABLE INNER CONDUCTOR HOUSING SUB-ASSEMBLY.
- 2.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
 - 2.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
 - 2.3 TIN INNER CONDUCTOR OF CABLE.
 - 2.4 INSERT CABLE INTO HOUSING SUB-ASSEMBLY
 - 2.4.1. NEST INNER CONDUCTOR IN CONTACT SLOT
 - 2.4.2. HOLD CABLE DIELECTRIC AND INNER CONDUCTOR 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 FERRULE OVER FLARED PORTION OF OUTER CONDUCTOR.
 - 3.2 CRIMP FERRULE IN PLACE.
 - 3.3 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.

4. SEAL OPENING IN HOUSING
- 4.1 PRESS DISC INTO OPENING IN REAR HOUSING SUB-ASSEMBLY.
 - 4.2 DISC MAY BE EPOXIED INTO PLACE. DO NOT ALLOW EPOXY TO PENETRATE INSIDE HOUSING.
 - 4.3 REMOVE LOCATOR TOOL.



CONNECTOR NO.	CRIMP DIE	HEX SIZE	CABLE TYPE
2837-7316-02	2098-0323-54	.151	RD-316/U DOUBLE BRAID
2837-7341-02	5698-5015-54 NO. B	.213	RG-142/U, RG-55, RG-223, RG-400
2837-7358-02	5698-5015-54 NO. B	.213	RG-58/U, RG-141/U, RG-303/U
2837-7388-02	5698-5015-54 NO. C	.128	RG-174/U, RG-188/U, RG-316/U