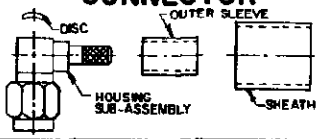
AMP

OSSM Right Angle Cable Plug Crimp Attachment 1251889–1, 1045520–1, 1045469–1, and 1045519–1

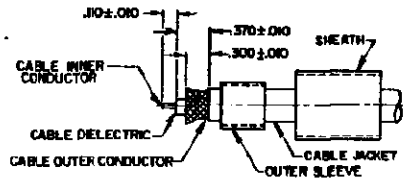
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSSM RIGHT ANGLE CABLE PLUG CRIMP ATTACHMENT	RG174/U,179 187,188,316	LOCATOR TOOL:2098-5236-02(T-1888) CRIMP TOOL:2098-0105-04 DIE N°C

CONNECTOR

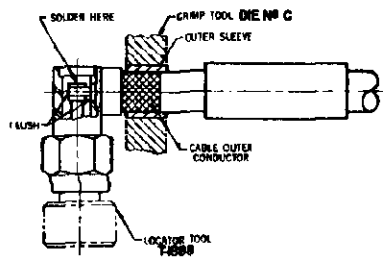


ASSEMBLY OPERATIONS

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.

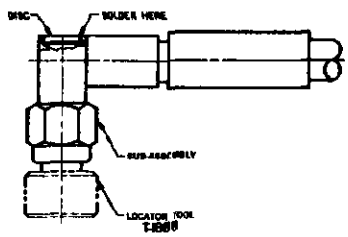


3.0 CRIMPING OF CABLE SUB-ASSEMBLY TO HOUSING SUB-ASSEMBLY
- 3.1 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 3.2 CRIMP OUTER SLEEVE IN PLACE.
- 3.3 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.

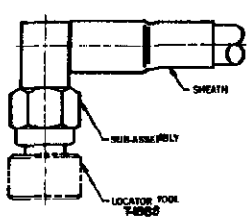
4.0 SEAL OPENING IN HOUSING
- 4.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY

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 EPOXIED 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.



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