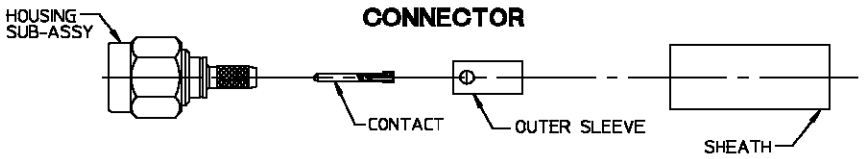
OSM Straight Cable Plug Solder Attachment 1056386–1, 1051643–1, 1051644–1, 1328215–1, 1063854–1, and 1069218–1

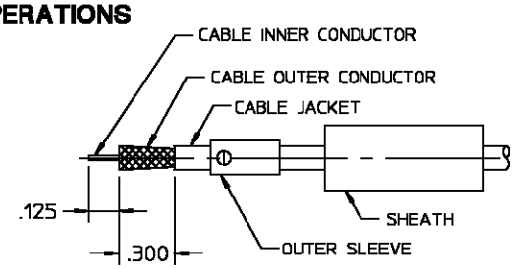
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
"OSM" STRAIGHT CABLE PLUG SOLDER ATTACHMENT	RG-174/U, 179, 187, 188, 316, RD-316/U	CENTER CONTACT HOLDER: 2098-5221-10 (T-4578) LOCATOR TOOL: 2098-5218-02 (T-2367)

CONNECTOR

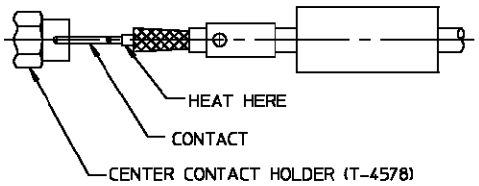


ASSEMBLY OPERATIONS

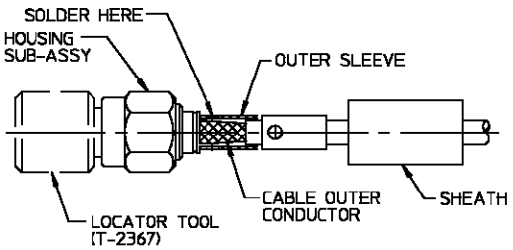
1.0 PREPARE COAXIAL CABLE END.
- 1.1 PLACE SHEATH AND SLEEVE ON CABLE.
- 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
- 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
- 1.4 TRIM CABLE DIELCTRIC TO LENGTH.
- 1.5 TRIM INNER CONDUCTOR TO LENGTH.
- 1.6 FLARE OUTER CONDUCTOR.



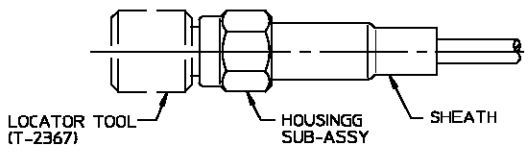
2.0 SOLDERING OF CONTACT TO CABLE INNER CONDUCTOR.
- 2.1 TIN INNER CONDUCTOR OF CABLE.
- 2.2 PLACE CENTER CONTACT IN HOLDER, HEAT CENTER CONTACT AND PUSH IT OVER INNER CONDUCTOR OF CABLE TO REST FIRMLY AGAINST CABLE DIELECTRIC.
- 2.3 REMOVE EXCESS SOLDER.



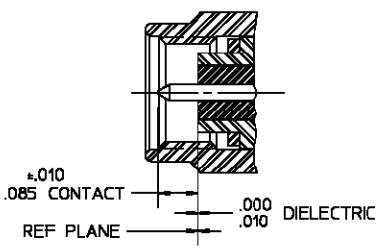
3.0 SOLDER CABLE TO HOUSING SUB-ASSEMBLY
- 3.1 SECURE LOCATOR TOOL TO THREADS OF HOUSING SUB-ASSEMBLY.
- 3.2 POSITION AND SECURE HOUSING SUB-ASSEMBLY IN A SMALL BENCH VISE.
- 3.3 INSERT CABLE INTO HOUSING SUB-ASSEMBLY AND SEAT FIRMLY.
- 3.4 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR.
- 3.5 HOLD CABLE FIRMLY SEATED AND SOLDER THROUGH HOLES IN OUTER SLEEVE.
- 3.6 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



4.0 SHRINK SHEATH TO CABLE.
- 4.1 POSITION SHEATH OVER OUTER SLEEVE AS SHOWN.
- 4.2 APPLY INDIRECT HEAT WITH THERMO GUN TO SHRINK SHEATH.
- 4.3 REMOVE LOCATOR TOOL.



5.0 INSPECT COMPLETED ASSEMBLY.
- 5.1 ADHERENCE TO ASSEMBLY STEPS GIVEN SHOULD YIELD TOLERANCES SHOWN.



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