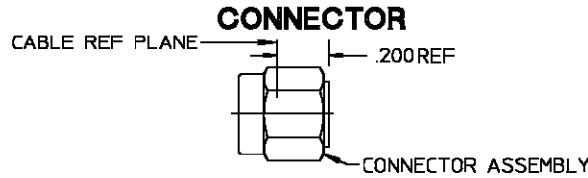


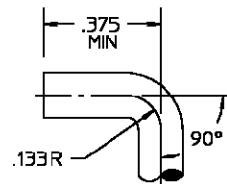
CONNECTOR TYPE	CABLE TYPE	TOOLS REQUIRED:
OSM STRAIGHT CABLE PLUG COMPRESSION CRIMP ATTACHMENT LOW PROFILE	RG405/U .085 S.R. COAXIAL CABLE	CRIMP TOOL KIT: 2598-5200-54 OPTIONAL TOOLING- -HAND TRIM & POINT TOOL:2598-5116-54 -PRODUCTION TOOLING AVAILABLE UPON REQUEST



ASSEMBLY OPERATIONS

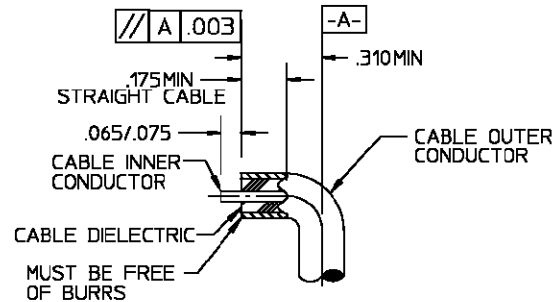
1.0 BENDING OF CABLE

- 1.1 BEND CABLE TO DIMENSION SHOWN.



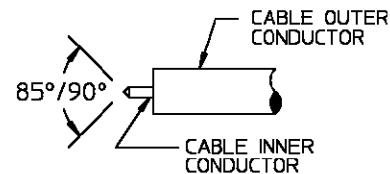
2.0 TRIMMING OF CABLE

- 2.1 TRIM CABLE TO DIMENSIONS SHOWN.



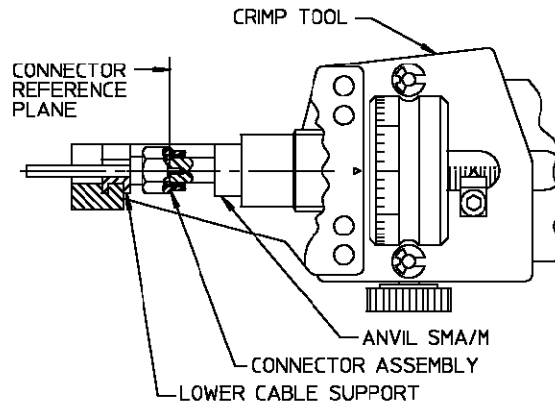
3.0 SHAPE INNER CONDUCTOR OF CABLE

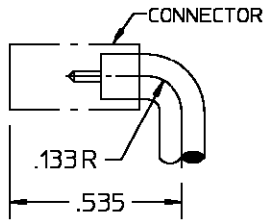
- 3.1 SHAPE BLUNT END OF INNER CONDUCTOR TO AN 85°-90° CONE.



4.0 INSTALL CABLE INTO CONNECTOR ASSEMBLY

- 4.1 INSTALL LOWER CABLE SUPPORT (FOR .141 CABLE) AND ANVIL (SMA/M) INTO CRIMP TOOL.
4.2 SET CRIMP LENGTH ON CRIMP TOOL TO .230
4.3 CAREFULLY INSERT CABLE INNER CONDUCTOR INTO PRE ASSEMBLED CENTER CONTACT OF CONNECTOR ASSEMBLY UNTIL CABLE BOTTOMS ON SHOULDER IN CONNECTOR ASSEMBLY.
4.4 PLACE ASSEMBLY INTO CRIMP TOOL, BOTTOMING THE CONNECTOR REFERENCE PLANE AGAINST ANVIL AND ALLOWING THE CABLE TO SETTLE IN THE LOWER CABLE SUPPORT.
4.5 SQUEEZE HANDLES OF CRIMP TOOL UNTIL RATCHET RELEASES.
4.6 ASSEMBLY IS NOW COMPLETE.





WHEN .535 DIMENSION IS DESIRED, .133 R, MUST BE MAINTAINED. IF THE RADIUS IS LARGER THAN, .133 THEN THE CABLE OUTER CONDUCTOR TRIM DIMENSIONS MUST CHANGE ACCORDINGLY.
