

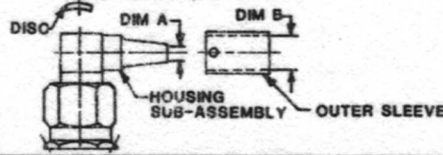
CONNECTOR TYPE
OSM RIGHT ANGLE
CABLE PLUG
SOLDER
ATTACHMENT

CABLE TYPE
SEE TABLE

TOOLS REQUIRED:
OPTIONAL:
LOCATOR TOOL 2098-5218-02(T-2367)

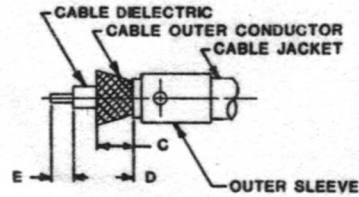
SUPERCEDES AP-252

CONNECTOR

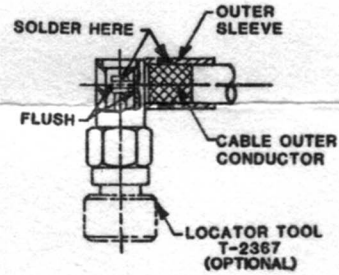


ASSEMBLY OPERATIONS

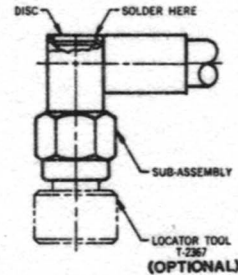
- 1.0 PREPARE COAXIAL CABLE END.**
 1.1 PLACE OUTER SLEEVE ON CABLE.
 1.2 REMOVE END PORTION OF CABLE JACKET TO EXPOSE CABLE OUTER CONDUCTOR.
 1.3 TRIM OUTER CONDUCTOR TO LENGTH.
 1.4 TRIM CABLE DIELECTRIC TO LENGTH.
 1.5 TRIM INNER CONDUCTOR TO LENGTH.
 1.6 FLARE OUTER CONDUCTOR.



- 2.0 SOLDER CABLE 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.
 2.6 SLIDE OUTER SLEEVE OVER FLARED PORTION OF OUTER CONDUCTOR, AND SOLDER AS SHOWN.
 2.7 TRIM AND REMOVE EXCESS OUTER CONDUCTOR STRANDS.



- 3.0 SEAL OPENING IN HOUSING**
 3.1 PRESS DISC INTO OPENING IN REAR OF HOUSING SUB-ASSEMBLY
 3.2 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.



ADHERENCE TO STEPS GIVEN WILL YIELD TOLERANCES SHOWN ON M39012/56 FIGURE 2.

TRIM DIMENSIONS

MILITARY P/N M39012/56-	OMNI-SPECTRA P/N PASSIVATE	CABLE TYPE	DIM. A	DIM. B
-3007	2037-8007-92	RG174/U	.067	.128
-3107*	2037-8107-92	RG316/U		
-3009	2037-8009-92	RG 58/U	.122	.219
-3109*	2037-8109-92	RG142/U RG223/U		
-3010	2037-8010-92	RG303/U	.122	.219
-3110*	2037-8110-92			

DIM. C	DIM. D	DIM. E
.250	.325	.110
.250	.420	.110
.250	.420	.110

*NO SAFETY WIRE HOLES.