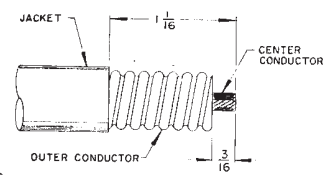
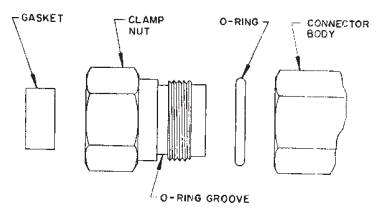


CABLING PROCEDURE FOR CONNECTORS USING CORRUGATED COPPER OUTER CONDUCTOR CABLE.

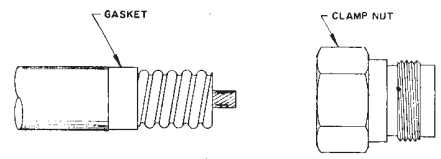
UNLESS OTHERWISE SPECIFIED:
 1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS ± .010
 3 PLACE DECIMALS ± .004
 ANGLES ± 0°-30'
 T, I, R, CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.

2. REMOVE ALL BURRS, BREAK SHARP EDGES .005 MAX.
 3. NO FILLETS PERMITTED.
 4. SURFACE ROUGHNESS 63 MICRONS RMS MAX.
 5. ALL DIMENSIONS PRIOR TO PLATING.
 6. ALL PLATING IN ACCORDANCE WITH KER 10004.

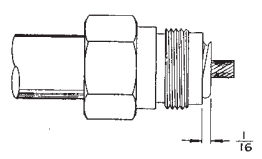
NOTES:
 1. INSTRUCTIONS TO BE PRINTED ON WHITE, SULPHUR FREE PAPER.



CUT CABLE END SQUARE, TRIM JACKET TO 1 1/16 DIM. TAKING CARE THAT JACKET END IS SQUARE. CUT OUTER CONDUCTOR AND FOAM DIELECTRIC TO 3/16 DIM. CAREFUL NOT TO NICK CENTER CONDUCTOR.



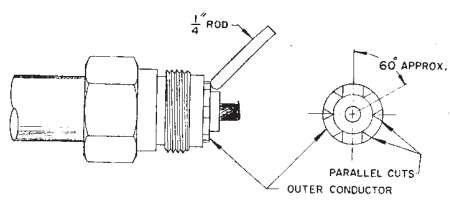
SLIDE GASKET ONTO OUTER CONDUCTOR AS SHOWN. APPLY A THIN COATING OF SILICONE GREASE TO OUTSIDE OF GASKET AND INSIDE SURFACE OF CLAMP NUT.



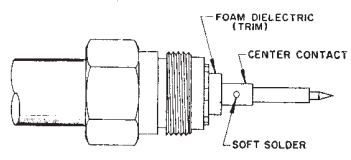
THREAD CLAMP NUT ONTO CONDUCTOR UNTIL OUTER CONDUCTOR IS EXPOSED 1/16.

3-260

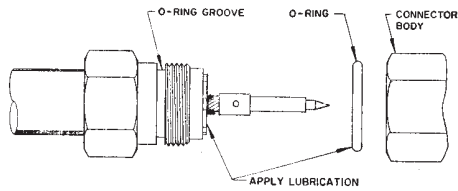
KINGS ELECTRONICS CO INC



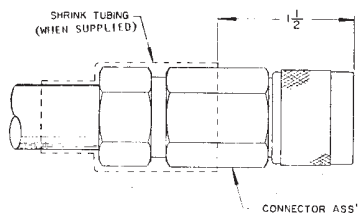
USING A KNIFE AND MALLET MAKE 6 CUTS IN THE CABLE. MAKE THE CUTS BY PLACING THE KNIFE AGAINST THE CENTER CONDUCTOR AND CUTTING TOWARD AND UP TO THE CLAMP NUT FACE. MAKE 2 PARALLEL CUTS, ONE ON EACH SIDE OF THE CENTER CONDUCTOR AND THEN MAKE 4 MORE CUTS AT 60 DEG. TO THE FIRST TWO CUTS AS SHOWN. WITH THE TIP OF THE KNIFE BEND EACH OF THE SECTIONS OF THE OUTER CONDUCTOR FORWARD, TAP SECTIONS AGAINST CLAMP NUT WITH MALLET AND 1/4 INCH NON-METALLIC ROD. DO NOT FLATTEN TABS, REDUCING MATERIAL THICKNESS. TRIM EXCESS TAB MATERIAL FLUSH WITH OUTER DIAMETER OF CLAMP NUT.



TIN CENTER CONDUCTOR AND ROUND OFF END. SLIDE CENTER CONTACT ONTO CENTER CONDUCTOR AND AGAINST DIELECTRIC. SOLDER IN PLACE, BEING CAREFUL NOT TO APPLY EXCESS HEAT AND NOT TO PUSH CONTACT INTO FOAM DIELECTRIC. TRIM DIELECTRIC FLUSH WITH FACE OF OUTER CONDUCTOR.



REMOVE ALL COPPER PARTICLES FROM DIELECTRIC AND SEAL EXPOSED DIELECTRIC WITH SILICONE GREASE. APPLY SILICONE GREASE TO O-RING AND INSTALL IN GROOVE ON CLAMP NUT. THREAD CONNECTOR BODY ONTO CLAMP NUT AND TIGHTEN SECURELY MAKING SURE THE CLAMP NUT IS HELD STATIONARY.



SLIDE SHRINK TUBING OVER ASSEMBLED CONNECTOR AS SHOWN AND APPLY JUST ENOUGH HEAT TO SHRINK TUBING TO OBTAIN A TIGHT SEAL. DO NOT OVERHEAT.

092-E

REVISIONS	
ISSUE	CHANGES
1	CN 35648 C KH 08/05/94

SCALE	
USED ON	
REF	
CABLING INSTRUCTIONS	
DRAWN	GL
DATE	9 MAR 93
APPR	JLC
DATE	10 MAR 93
KINGS ELECTRONICS CO INC TECHNICAL DEPARTMENT TECHNICAL, NEW YORK 10072	
3-260	