

3-546 (SHEET 1 OF 2)

| REVISIONS |                                    |
|-----------|------------------------------------|
| ISSUE     | CHANGES                            |
| 2         | CN 36286 E<br>ME 05/16/95          |
| 3         | CN 36563 E<br>KH 09/08/95          |
| 4         | CN 37081 E<br>KH 07/30/96          |
| 5         | CN 37395 E<br>KH 06/16/97          |
| 6         | CN 37558 C<br>JW 02/18/98          |
| 7         | CN 38676 E<br>DCT 10/2/2           |
| 8         | CN 39111 E<br>JJA 07/01/04         |
| 9         | CN 39657 C<br>PMC 10/09/06         |
| L         | REVISED PER ER12588<br>RM 12/09/08 |
| M         | REVISED PER ER14988<br>DRK 5/7/09  |



NOTE:  
INSTRUCTION SHEET TO BE IN WHITE  
SULPHUR FREE PAPER.

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3.25

4.75

STEP 1 (OPTION a & b):  
CUT CABLE END SQUARE. SLIDE K-GRIP SLEEVE (SHRINK TUBING OPTIONAL) OVER JACKET.  
(CAUTION: WHEN USING A SINGLE STEP W/P SLEEVE, SLIDE SMALL END OVER CABLE FIRST  
AS SHOWN, SEE STEP 1A) MAKE CUTS 1 AND 2 IN JACKET. (OPTION b ONLY).  
MAKE ADDITIONAL CUT 3 IN JACKET.


STEP 2 (OPTION a & b):  
REMOVE JACKET TO DIMENSION "A" (OPTION a) OR "E" (OPTION b). REMOVE ROUND BRAID AND FLAT BRAID  
AT EDGE OF JACKET. BE SURE ENDS OF FLAT BRAID ARE FLAT AGAINST DIELECTRIC. (IF USING OPTION a  
PROCEED TO STEP 4).

| CABLING INSTRUCTIONS |                   |
|----------------------|-------------------|
| DRAWN                | JCA DATE 05/22/92 |
| DESIGN               | JT DATE 05/26/92  |
| APPR.                | DATE              |

WINCHESTER  
ELECTRONICS  
Winchester Electronics  
100 North Main Street  
Wallingford, CT 06492

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| ISSUE   |                     | CHANGES      |          |
|---|---------------------|--------------|----------|
| 1   | CN 35407 E          | KH 04/04/94  |          |
| 2   | CN 36286 E          | ME 05/16/95  |          |
| 3   | CN 36563 E          | KH 09/08/95  |          |
| 4   | CN 37081 E          | KH 07/30/96  |          |
| 5   | CN 37395 E          | KH 06/16/97  |          |
| 6   | CN 37558 C          | JW 02/18/98  |          |
| 7   | CN 38676 E          | DCT 10/2/2   |          |
| 8   | CN 39111 E          | JLA 07/01/04 |          |
| 9   | CN 39657 C          | PMC 10/09/06 |          |
| L   | REVISED PER ER12588 | RM 12/08/08  |          |
| M   | REVISED PER ER14988 | DRK 5/7/09   |          |
| SCALE 1:1   |                     |              |          |
| APPROX SURFACE AREA   |                     |              |          |
| USED ON   |                     |              |          |
| REF:  |                     |              |          |
| CABLING INSTRUCTIONS  |                     |              |          |
| DRAWN   | JCA                 | DATE         | 05/22/92 |
| DESIGN  | JT                  | DATE         | 05/26/92 |
| APPR.   |                     | DATE         |          |
| <br>Winchester Electronics<br>82 Shennock Boulevard<br>Wallingford, CT 06492 |                     |              |          |
| 3-546 (SHEET 2 OF 2)  |                     |              |          |

- NOTE:  
INSTRUCTION SHEET TO BE IN WHITE  
SULPHUR FREE PAPER.
- STEP 3. (OPTION b ONLY):  
REMOVE JACKET TO DIMENSION "A". FLAR OR BULGE BACK ROUND BRAID ONLY AND TRIM AT EDGE OF JACKET.
- STEP 4. (OPTION a & b):  
REMOVE JACKET TO DIMENSION "B". FLAT BRAID IS VISIBLE ON OPTION b ONLY.
- STEP 5. (OPTION a & b):  
TRIM DIELECTRIC TO DIMENSION "C". EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO DIMENSION "D".
- STEP 6. (OPTION a & b):  
PLACE CONTACT ON CENTER CONDUCTOR AND BOTTOM AGAINST DIELECTRIC. SOLDER OR CRIMP CONTACT IN PLACE.
- STEP 7. (OPTION a & b):  
PUSH THE K-GRIP BODY OVER THE DIELECTRIC AND FLAT BRAID AND UNDER ROUND BRAID UNTIL CONTACT SNAPS IN PLACE. (ONCE THE FLAT BRAID IS UNDER THE K-GRIP BODY, A CAREFUL ROTATION OF THE DIELECTRIC AND FLAT BRAID WILL EASE ASSEMBLY UNDER THE ROUND BRAID).
- STEP 8. (OPTION a & b):  
SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON BODY AND FORM HEX BY CRIMPING.  
(HEAT SHRINK TUBING AS REQUIRED)

TRIM CODE CHART

| DASH NO. | OPTION | A    | B    | C    | D    | E    |
|----------|--------|------|------|------|------|------|
| -1       | a      | .275 |      | .432 | .156 |      |
|          | b      |      |      |      |      | .210 |
| -2       | a      | .375 |      | .500 | .188 |      |
|          | b      |      |      |      |      | .260 |
| -3       | a      | .293 | .312 | .512 | .094 |      |
|          | b      |      |      |      |      | .166 |
| -4       | a      | .625 |      | .750 | .188 |      |
|          | b      |      |      |      |      | .260 |
| -5       | a      | .218 | .250 | .398 | .093 |      |
|          | b      |      |      |      |      | .140 |
| -6       | a      | .250 | .343 | .437 | .156 |      |
|          | b      |      |      |      |      | .210 |
| -7       | a      | .552 | .270 | .634 | .188 |      |
|          | b      |      |      |      |      | .260 |
| -8       | a      | .275 | .281 | .400 | .156 |      |
|          | b      |      |      |      |      | .210 |
| -9       | a      | .563 | .312 | .687 | .188 |      |
|          | b      |      |      |      |      | .260 |

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