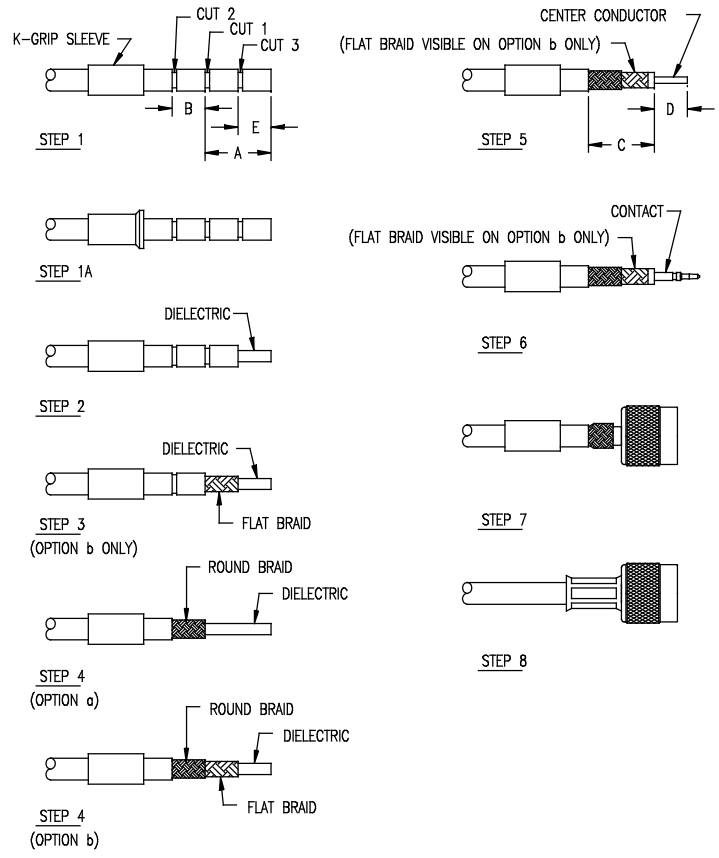


NOTE:  
INSTRUCTION SHEET TO BE IN WHITE  
SULPHUR FREE PAPER.

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).

3-546

3.25

3-546 (SHEET 1 OF 2)

| REVISIONS  |  |
|--|--|
| ISSUE  | CHANGES  |
| 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>JLA 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  |
| N  | REVISED PER ER25429<br>JUN 07/19/10                                      |
| P  | REVISED PER ER30416<br>DW 01/13/11                                       |
| R  | REVISED PER DMF304 &<br>ADDED -14 SHT 2 OF 2<br>ER040416<br>KPL 02/28/12 |
| THIS DRAWING, THE DESIGNS AND IDEAS EMBODIED IN THE DEVICE TO WHICH IT RELATES, AND THE METHOD OF PRODUCING THE DEVICE, ARE THE PROPERTY OF WINCHESTER ELECTRONICS CORPORATION AND SHALL NOT BE EMPLOYED, COPIED, OR DISCLOSED TO ANYONE, IN ANY MANNER WITHOUT THE CONSENT OF WINCHESTER ELECTRONICS CORPORATION. |  |
| 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   |
|  Winchester Electronics<br>62 Barnes Industrial<br>Road North<br>Wallingford, CT 06492  |  |

3-546 (SHEET 1 OF 2)

NOTE:

INSTRUCTION SHEET TO BE IN WHITE  
SULPHUR FREE PAPER.

4.75

**STEP 3 (OPTION b ONLY):**  
REMOVE JACKET TO DIMENSION "A". FLAIR 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 | .312 | .432 | .156 | _____ |       |
|          | b      |      |      |      |      | .210  |       |
| -2       | a      | .375 |      | .500 | .188 | _____ |       |
|          | b      |      |      |      |      | .260  |       |
| -3       | a      | .293 |      | .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  |       |
| -10      | a      | .622 | .319 | .786 | .156 | _____ |       |
|          | b      |      |      |      |      | .210  |       |
| -11      | a      | .455 | .312 | .579 | .188 | _____ |       |
|          | b      |      |      |      |      | .260  |       |
| -12      | a      | .398 | .312 | .554 | .188 | _____ |       |
|          | b      |      |      |      |      | .210  |       |

3-546

3.25

3-546 (SHEET 2 OF 2)

REVISIONS

| ISSUE | CHANGES   |
|-------|---|
| 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>JLA 07/01/04                                    |
| 9     | CN 39657 C<br>PMC 10/09/06                                    |
| L     | REVISED PER ER12588<br>RM 12/08/08                            |
| M     | REVISED PER ER14988<br>DRK 5/7/09                             |
| N     | REVISED PER ER25429<br>JUN 07/19/10                           |
| P     | REVISED PER ER30416<br>DW 01/13/11                            |
| R     | REVISED PER DMF304 &<br>ADDED -12<br>ERO40416<br>KPL 02/28/12 |

THIS DRAWING, THE DESIGNS AND IDEAS EMBODIED IN THE DEVICE TO WHICH IT RELATES, AND THE METHOD OF PRODUCING THE DEVICE, ARE THE PROPERTY OF WINCHESTER ELECTRONICS CORPORATION AND SHALL NOT BE EMPLOYED, COPIED, OR DISCLOSED TO ANYONE, IN ANY MANNER WITHOUT THE CONSENT OF WINCHESTER ELECTRONICS CORPORATION.

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          |



Winchester Electronics  
62 Barnes Industrial  
Road North  
Wallingford, CT 06492

3-546 (SHEET 2 OF 2)