

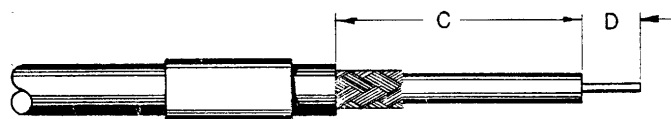
1. Cut cable end square, slide shrink tubing and K-grip sleeve over jacket and with jacket trim jig make cuts 1 and 2 in jacket.



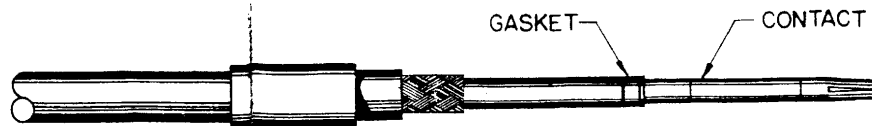
2. Remove jacket to dimension "A", flare or bluge back braid and trim with scissors at edge of jacket.



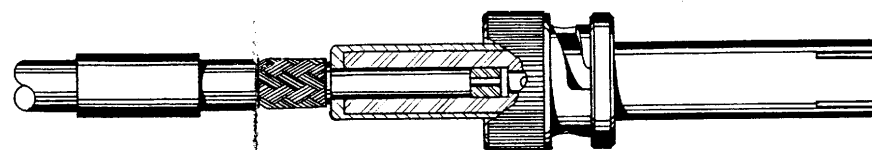
3. Remove jacket to dimension "B."



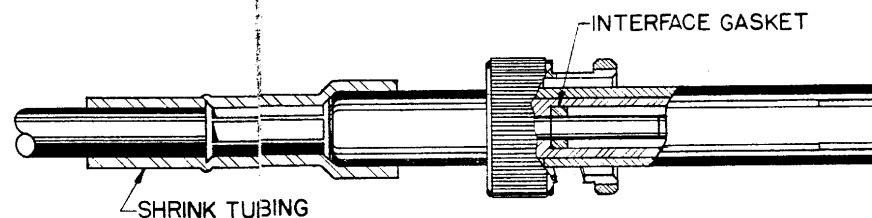
4. Using dielectric trim jig, trim dimension "C." Exposed center conductor length will be equal to dimension "D" of trim code.



5. Place cable seal gasket over center conductor against dielectric then solder contact to center conductor. Gasket must be under compression after soldering is completed.



6. Push connector over dielectric and under braid until contact bottoms in insulator.



7. Slide K-grip sleeve over K-grip and braid to within 1/64 inch of shoulder of body and form hex. Then place tubing in position and shrink onto body and cable by heating (300°F Max). Install interface gasket over contact. (When Supplied) When Weatherproof Sleeve is used Heat Shrink Tubing is not required.

DASH NO.	TRIM CODE	TRIM DIMENSIONS			
		A	B	C	D
-1	CP474	15/16	3/16	.890	15/64
-2	CP475	1 3/4	3/16	1.627	5/16
-3	CP476	2 35/64	3/16	2.415	5/16
-4	CP484	1	3/16	.948	15/64

UNLESS OTHERWISE SPECIFIED:

1. TOLERANCES:  
FRACTIONS ± .010 DECIMALS ± .004 ANGLES ± 0° 30'  
T. I. R. CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED 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.

REVISIONS

ISSUE	CHANGES
1	CN 6103A 21 JUNE 68 HFE.
2	CN 8138A L.R. 17 DEC. 69
3	CN 10830A CC 29 FEB 72
4	CN 11555A LI 13 OCT 72
5	CN 12321A J.G.L. 6 JUN 73
6	CN 12419A JL 11 JUL 73

REF:

FINISH

SPEC.

MATL.

SPEC.

CABLING PROCEDURE

DRAWN H.F.E. DATE 18 JAN 68  
APPR. FETE DATE 19 JAN 68

KINGS ELECTRONICS  
40 MARLBOROUGH ROAD  
TUCKAHOE, N. Y.

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