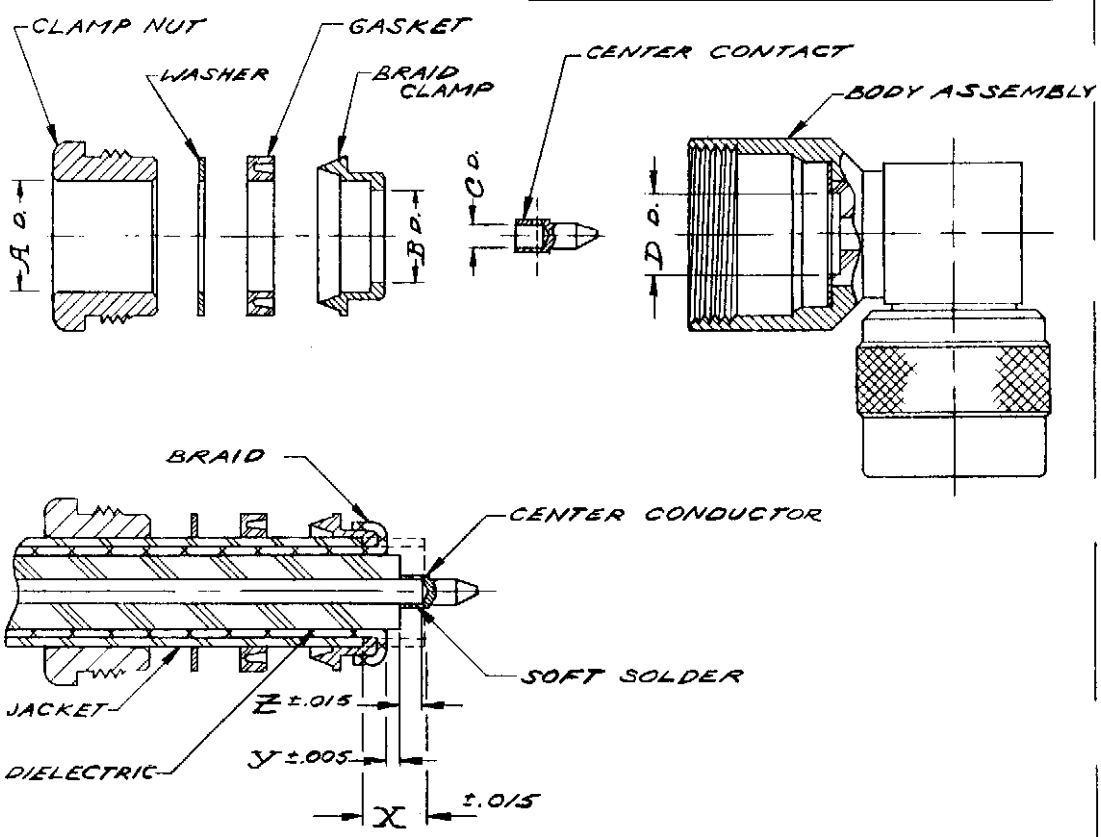
CABLING INSTRUCTIONS D-59-134-5



WHEN USING CABLE GROUP	PIECE PART REF. DIM'S.				TRIMMING DIM'S			TRIM CODE
	A	B	C	D	X	Y	Z	
RG-165, 213, 214 & 225	.44	.37	.10	.30	.25	.045	.09	CP-1030
RG-115								

1. CUT CABLE END SQUARE. SLIDE CLAMP NUT, WASHER AND GASKET OVER CABLE JACKET.
2. REMOVE JACKET TO DIMENSION X WITHOUT NICKING BRAID.
3. COMB OUT BRAID AND TAPER FORWARD. SLIDE BRAID CLAMP OVER BRAID AGAINST JACKET SHOULDER.
4. FLARE BRAID BACK OVER BRAID CLAMP SHOULDER AND TRIM AS SHOWN.
5. REMOVE DIELECTRIC TO Y DIMENSION. DO NOT NICK CENTER CONDUCTOR.
6. CUT CENTER CONDUCTOR TO Z DIMENSION, AND TIN.
7. ASSEMBLE CENTER CONTACT ON CABLE, BOTTOM ON DIELECTRIC FACE AND SOLDER IN POSITION. DO NOT DISTORT DIELECTRIC BY OVERHEATING.
8. THREAD ASSEMBLY INTO CONNECTOR BODY AND TIGHTEN. (RECOMMENDED CLAMP NUT TIGHTENING TORQUE 55-60 IN-LBS.)

REDUCE TO 4 INCHES

D-59-134-5

UNLESS OTHERWISE SPECIFIED:
1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS ± .010 3 PLACE DECIMALS ± .004 ANGLES ± 0° 30'
2. REMOVE ALL BURRS. BREAK SHARP EDGES .005 MAX.
3. NO FILLETS PERMITTED.
4. SURFACE ROUGHNESS 63 MICROINCHES RMS MAX.
5. ALL DIMENSIONS PRIOR TO PLATING.
T.I.R. CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.

NOTES:
1. INSTRUCTION SHEET TO BE WHITE SULPHUR FREE PAPER.

ITEM	REQ'D	DESCRIPTION	DRAWING NO.

DIETZGEN 199M 11223

CABLING INSTRUCTION

DRAWN NLA DATE 17 DEC 71
APPR. LI DATE 21 DEC 71

KINGS ELECTRONICS
40 MARBLEDALE ROAD
TUCKAHOE, N.Y. 10707

D-59-134-5

SPEC.
MATL.
SPEC.
FINISH
SPEC.
REF.

REVISIONS
ISSUE CHANGES