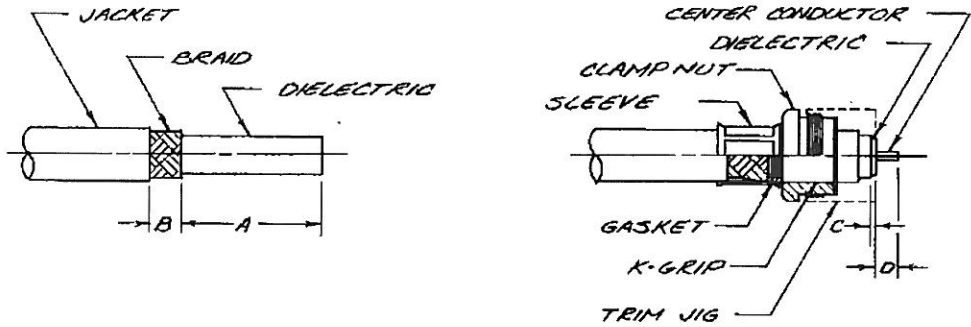


CABLING INSTRUCTIONS FOR KS-89-24, K-GRIP



1. TOLERANCES: .010 DECIMALS & .004 ANGLES & 0°-30° FRACTIONS & .010 DECIMALS & .004 ANGLES & 0°-30° T.I.R. CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED THE SUM OF THEIR TOLERANCES.

UNLESS OTHERWISE SPECIFIED:
 2. REMOVE ALL BURRS, BREAK SHARP EDGES .003 MAX.
 3. NO FILLETS PERMITTED.
 4. SURFACE ROUGHNESS 100 MICRONS INCHES RMS MAX.
 5. ALL DIMENSIONS PRIOR TO PLATING.

1. Cut cable and square and slide K-grip sleeve over jacket.
2. Cut through jacket and braid to dimension A, leaving out jacket and braid in place until step 3 below. This may be conveniently done with a B-T stripper which will cut cleanly through both jacket and braid. When cutting through braid avoid tangling strand ends.
3. Remove jacket to dimension B, without nicking braid. Remove braid cut to dimension A in step 2, above.
4. Flare out braid slightly to permit slotted end of K-grip to enter between dielectric and braid. Flaring tool S-89-24-5 may be used for this operation.
5. Assemble K-grip gasket and clamp nut on K-grip.
6. Push K-grip over dielectric and under braid as far as it will go.
7. Slide K-grip sleeve forward over braid and K-grip gasket up to small shoulder on K-grip. Place assembly in K-grip forming tool centering sleeve between die halves and form hex.
8. Assemble dielectric trim jig to clamp nut, remove dielectric flush with jig and trim center conductor in usual manner.
9. Solder or crimp center contact to center conductor. Remove dielectric trim jig. Place connector gasket and braid clamp on K-grip. Then insert assembly into connector body and lock securely by clamp nut.

CABLE TRIM CODE

CODE	A	B	C	D
I	1 ⁵ / ₃₂	1/4	.043	3/16
II	1 ²⁵ / ₃₂	1/4	.666	3/16
III	1 ⁷ / ₁₆	1/4	.297	1/32
IV	1 ¹ / ₈	1/4	.043	5/32
V	1 ¹³ / ₃₂	1/4	.333	5/32
VI	1 ³ / ₃₂	1/4	.044	1/8
VII	1 ⁸³ / ₆₄	1/4	.487	2 ³ / ₃₂

* In step 9, after soldering contact to center conductor, taper dielectric with TL-612/U cable dresser.

9-82-68-5

ISSUE	1	REVISED & REWORKED BY SWAN 6/1
2.	CABLE TRIM CODE III ADDED. 8 AUG 61	
3.	CN 1214	SWAN 6/1
REVISIONS		
CHANGED		
DATE	DATE	DATE
APPR.		
DRWEN		
DATE		
CABLING INSTRUCTIONS		
KINGS ELECTRONICS		
40 MARSHALL ROAD		
TUCUMPHON, N. Y.		
S-89-24-6		