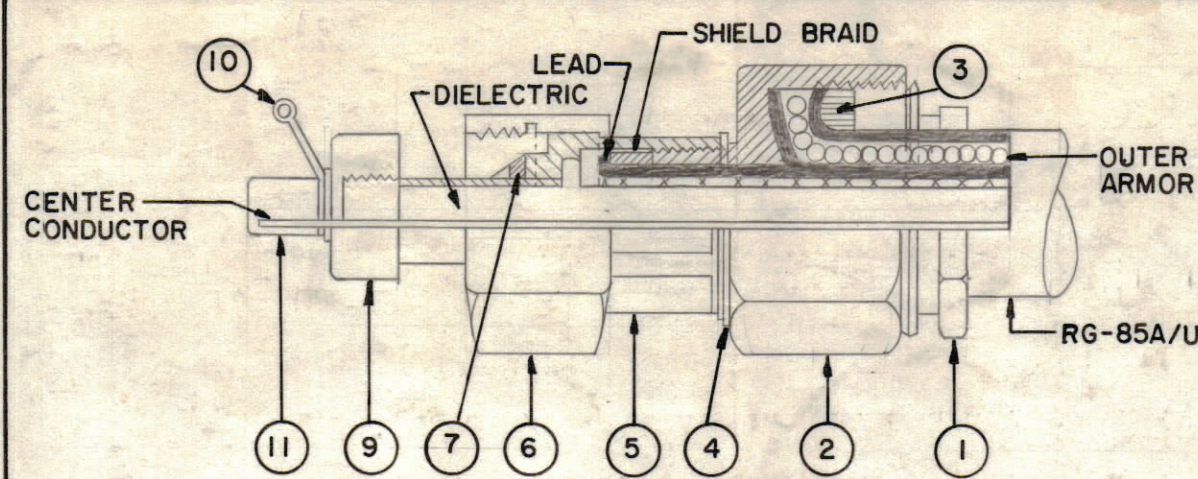


*APPROX. 1/2" HAS BEEN ALLOWED FOR WASTE AFTER ASSEMBLY

WIRE STRIPPING DETAIL



REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
	A	REDRAWN & REVISED FROM A WAS 1-SIZE	5-22-62	6707		

ASSEMBLING ADAPTOR; END SEAL TO RG85/U CABLE

OPERATION:

- (a) PLACE ARMOR GLAND NUT OVER RG85/U CABLE.

(b) PLACE ARMOR RING OVER RG85/U CABLE, TO A DISTANCE OF APPROXIMATELY ELEVEN INCHES FROM THE END OF CABLE.
- (a) CUT END OF CABLE SQUARE AND CLEAN.

(b) CLAMP BOTH HALVES OF FORMING CLAMP, TMC PART A-882, AROUND OUTER ARMOR OF RG85/U CABLE AT DISTANCE OF SEVEN INCHES FROM END OF CABLE.

(c) BEND OUTER ARMOR TO FORM FLARE AS SHOWN ON DETAIL SKETCH.

(d) AFTER FORMING FLARE INTO TRUE RADIUS OF 5/16" (INSIDE RADIUS), NIP OFF ARMOR WIRES.

(e) GRIND OFF ALL ROUGH EDGES OF ARMOR WIRE FLARE TO A SMOOTH SURFACE, BEING CAREFUL TO MAINTAIN TRUE OUTSIDE DIAMETER OF APPROXIMATELY 1/32 OF AN INCH LESS THAN 2-5/8 INCHES IN DIAMETER.

(f) REMOVE CLAMPS.
- (a) ASSEMBLE ARMOR COUPLING GLAND ARMOR RING AND ARMOR GLAND NUT MAKING SURE ASSEMBLY IS TIGHT. CUT OFF LEAD SHEATH 1/16" LONGER THAN ASSEMBLY AND SOLDER TO ARMOR COUPLING GLAND, ON THE FINISHED END SURFACE.

(b) THE VINYLLITE JACKET SHOULD EXTEND 3/16" BEYOND THE ABOVE GLAND AND LEAD SHEATH ASSEMBLY.

(c) CUT COPPER BRAID ONE INCH LONGER THAN COUPLING GLAND AND LEAD SHEATH.

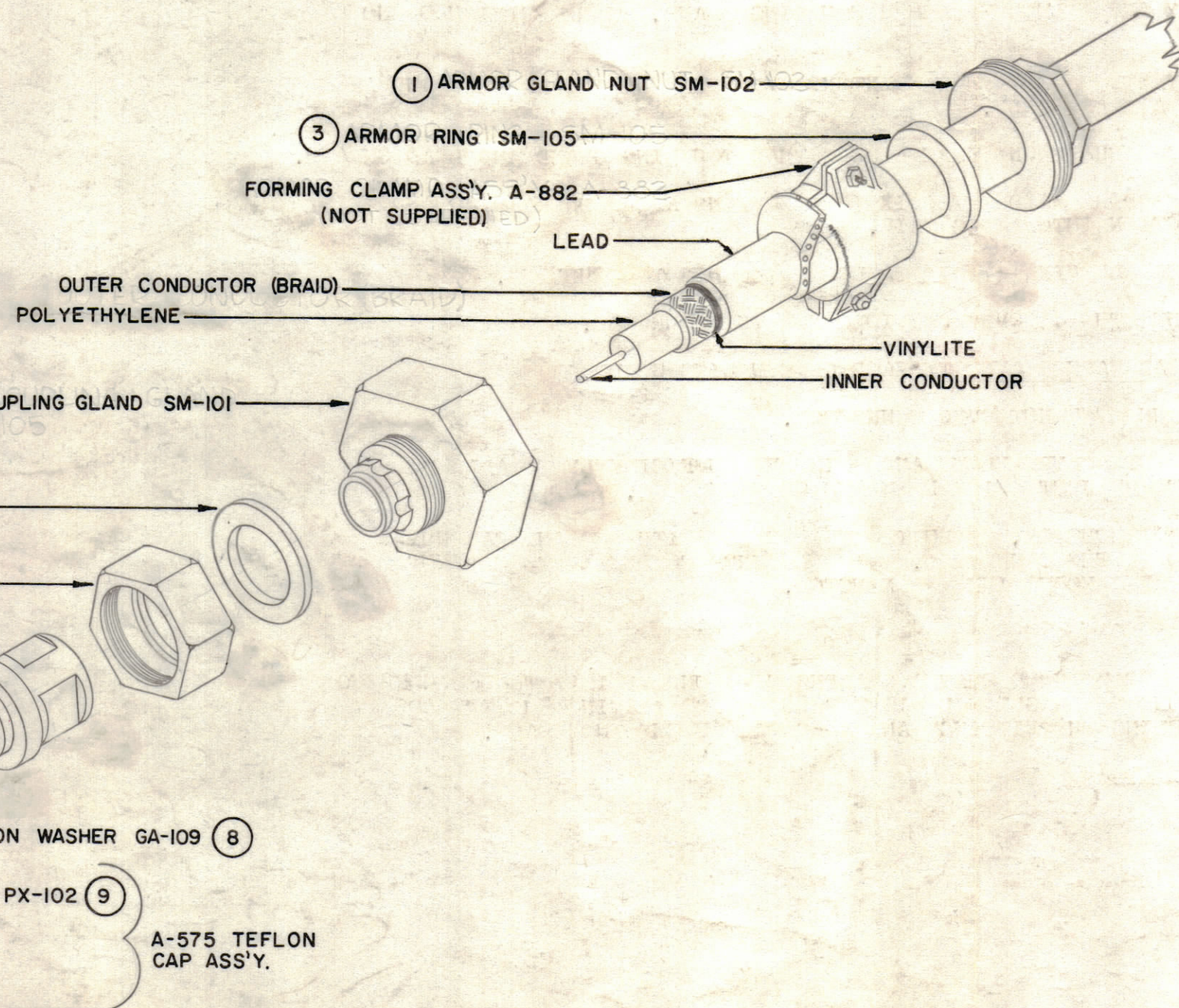
(d) DIVIDE COPPER BRAID INTO SIX (6) SECTIONS AFTER UNBRAIDING AND TWIST EACH SECTION INTO A PIG TAIL.

(e) BEND BACK ALL SIX (6) PIG TAILS AND SOLDER TO COUPLING GLAND INTO THE GROOVES PROVIDED FOR THIS PURPOSE.

(g) PLACE SEAL WASHER OVER THREADS OF COUPLING GLAND.

(h) PLACE CONNECTOR NUT OVER CONNECTOR.
- (a) MEASURE OFF POLYETHYLENE AND TRIM OFF SUFFICIENTLY TO ALLOW GASKET TO PROJECT 1/16" FROM END OF CONNECTOR.

(b) OVER THE CONDUCTOR, SCREW THE TEFLON CAP WITH LUG AND CAP NUT ATTACHED TO THE CONNECTOR. SOLDER INNER CONDUCTOR TO CAP NUT AND CUT OFF EXCESS INNER CONDUCTOR.



NOTE 1 - IT IS RECOMMENDED THAT A SEALING COMPOUND SIMILAR TO DOW CORNING COMPOUND #4 OR GLYPTOL #1202 BE USED FOR COATING THE THREADS IN ASSEMBLING THE FITTINGS AND ADAPTOR OF THE END SEALS.

ES-85/U
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REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
LIST OF MATERIAL				
MATERIAL			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH			TITLE END SEAL ASSEMBLY FOR RG-85A/U CABLE	
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.	DRAWN	DATE
SCALE	CODE	S-401-70-2353	G. GOLDBERG	5-22-62
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES			CHECKED	DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005			DATE	6/15/62
FRACTIONS ± 1/64 ANGLES ± 0° 30'			ELECT. DES.	DATE
TOLERANCES			MECH. DES.	DATE
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.			DATE	6/15/62
NOTES			DATE	6/15/62
			DATE	6/15/62

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