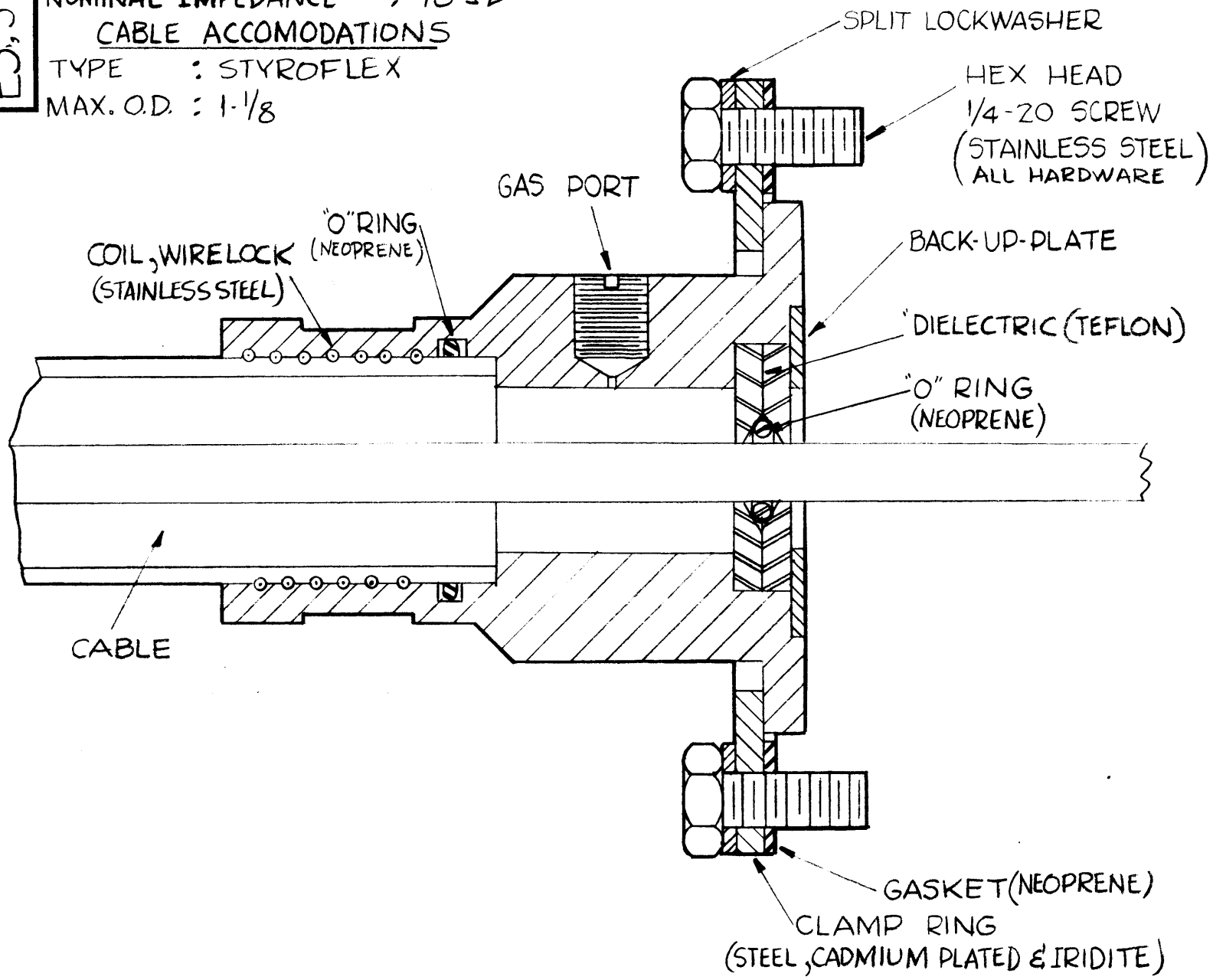


ES, ST-71125 A

**SPECIFICATIONS**

SERIES : ES  
 DIELECTRIC : TEFLON  
**ELECTRICAL DATA**  
 MAX. PEAK OPER. VOLT. : 3.1 KV  
 NOMINAL IMPEDANCE : 70 Ω  
**CABLE ACCOMODATIONS**  
 TYPE : STYROFLEX  
 MAX. O.D. : 1-1/8



**INSTALLATION INSTRUCTIONS**

1. Using a sharp tubing cutter, score cable 1" to 2" from end. Do not cut through aluminum jacket.
2. Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
3. Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/3" of Styrene sleeve is exposed.
4. Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
5. Cut off center conductor 2-1/2 inches from end of cable. Remove cut-off burr from center conductor. Take care not to allow chips to enter cable.
6. Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. The sleeve should slide freely over cable.
7. Grease sleeve "O" ring with "O" ring grease, GL-118, (No. 4 compound), and install in sleeve.
8. Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound, (GL-117). Use the compound sparingly and wipe off any excess before starting sleeve on cable.
9. Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
10. Push bead over center conductor with countersink facing outward. Apply "O" ring grease, GL-118, (No. 4 compound), to small "O" ring and push it on center conductor. Push second bead on center conductor with countersink facing inward.
11. Place back-up plate over center conductor and push toward sleeve so that beads and back-up plate seat in sleeve counterbores.
12. Bring up sleeve assembly to box and place gasket over tapped holes in box.
13. Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

**NOTE:** GL-118 (#4 compound) Supplied By  
 GL-117 (Lubricant, Thread) TMC

A PART NO. WAS ESW-71125, SERIES WAS ESW		8-30-62	7169	SG	VD	9/62
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
UNLESS OTHERWISE SPECIFIED:		SCALE: S-401-70-9009				
DIMENSIONS ARE IN INCHES		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°		REMOVE ALL BURRS AND SHARP EDGES				

RAC SERIES		4-1-61	
REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.
USED ON			

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
STOCK SIZE				
CONNECTOR, BOX, 1 1/8 STYROFLEX 70 OHM.				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKER
			ES, ST-71125	A
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	