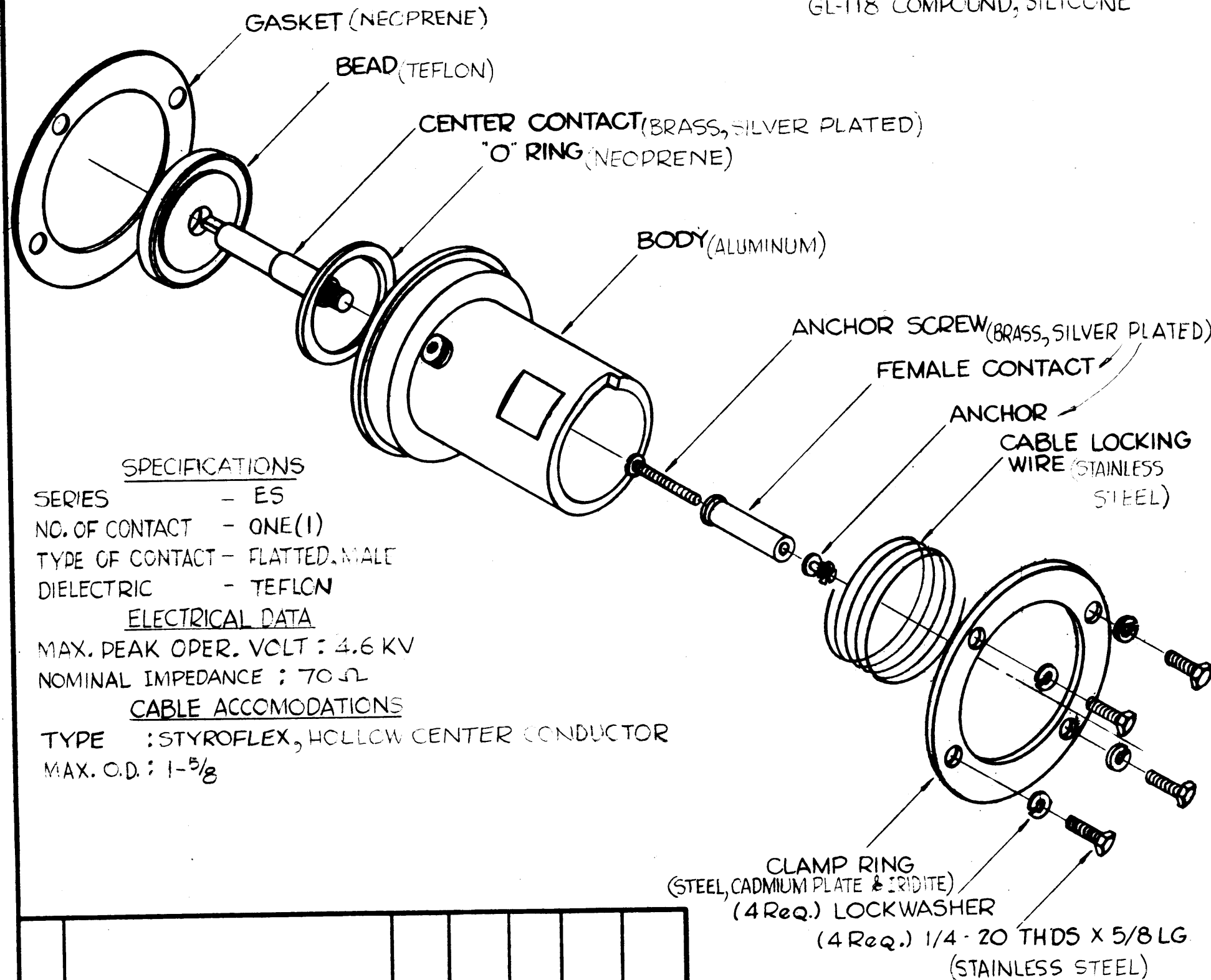


SUPPLIED BY TMC
 GL-117 LUBRICANT THREAD
 GL-118 COMPOUND, SILICONE



- Using a sharp tubing cutter, score cable 3" from end. Do not cut through aluminum jacket.
- 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.
- 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 1/8" of Styrene sleeve is exposed.
- 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.
- Saw off center conductor 1/8" from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor being careful to keep chips out of cable.
- Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
- Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. Sleeve should slide freely over cable.
- Grease sleeve "O" ring with "O" grease, TMC-GL-118 No. 4 Compound, and install in sleeve.
- Push on wire coil over jacket until coil is entirely in jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound TMC-GL-117. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
- 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.
- Screw center contact into female contact.
- Push bead over center contact with countersink facing outward. Grease with Dow Corning No. 4 Compound and mount "O" rings in place, and mount second bead over center contact. Push entire bead assembly down into sleeve counterbore.
- Bring up sleeve assembly to box and place gasket over tapped holes in box.
- Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

SPECIFICATIONS

SERIES - ES
 NO. OF CONTACT - ONE (1)
 TYPE OF CONTACT - FLATTED, MALE
 DIELECTRIC - TEFLON

ELECTRICAL DATA

MAX. PEAK OPER. VOLT : 4.6 KV
 NOMINAL IMPEDANCE ; 70 Ω

CABLE ACCOMODATIONS

TYPE : STYROFLEX, HOLLOW CENTER CONDUCTOR
 MAX. O.D. : 1-5/8

DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
8-30-61	7169	SB		
SCALE: S-401-70-9011				
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE
				3-30-61

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
STOCK SIZE				
BOX CONNECTOR ASS'Y				
MATERIAL				
1-5/8 STYROFLEX, 70Ω, HOLLOW CENTER CONDUCTOR				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKER
			J.C. Biele	
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	FINAL APPROVAL
				ES, ST-71625 A