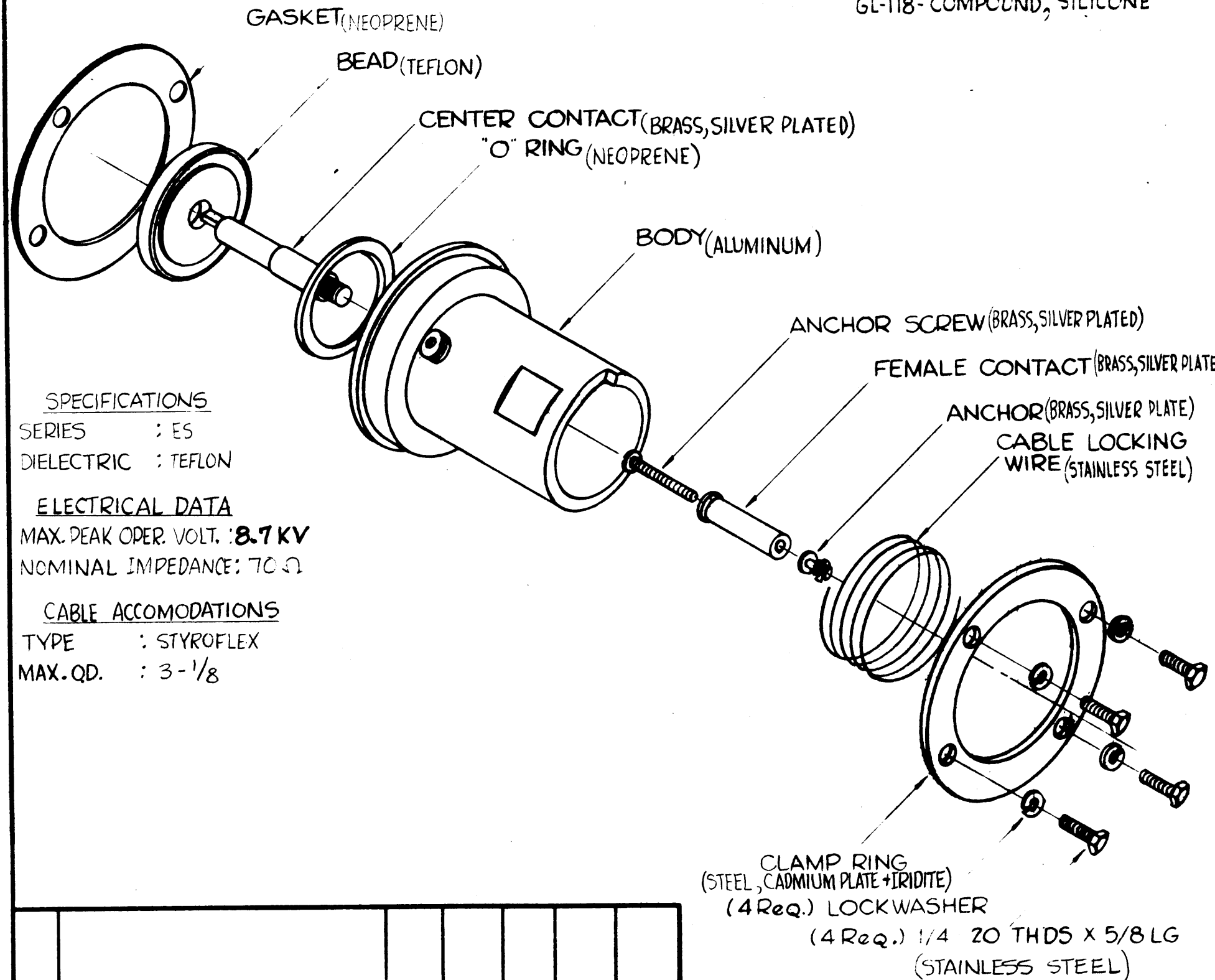


SUPPLIED BY TMC  
 GL-117-LUBRICANT, THREAD  
 GL-118-COMPOUND, SILICONE



SPECIFICATIONS

SERIES : ES  
 DIELECTRIC : TEFLON

ELECTRICAL DATA

MAX. PEAK OPER. VOLT. : 8.7KV  
 NOMINAL IMPEDANCE: 70Ω

CABLE ACCOMODATIONS

TYPE : STYROFLEX  
 MAX. QD. : 3-1/8

- 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 shosshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector s ats 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 ~~GL-117~~ compound. 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.

REV	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENGR. APP.
A	PART NO. WAS ESN-73125, SERIES WAS ESM	8-30-62	7169	SG		
UNLESS OTHERWISE SPECIFIED:		SCALE: S-401-70-9038				
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

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

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
STOCK SIZE			BOX, CONNECTOR ASS'Y	
MATERIAL			3-1/8 STYROFLEX, 70Ω, HOLLOW CENTER CONDUCTOR	
		J.C. Biele	W. J. [Signature]	C [Signature]
		TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN
				CHECKER
				FINAL APPROVAL
				ES, ST-73125   A
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	