

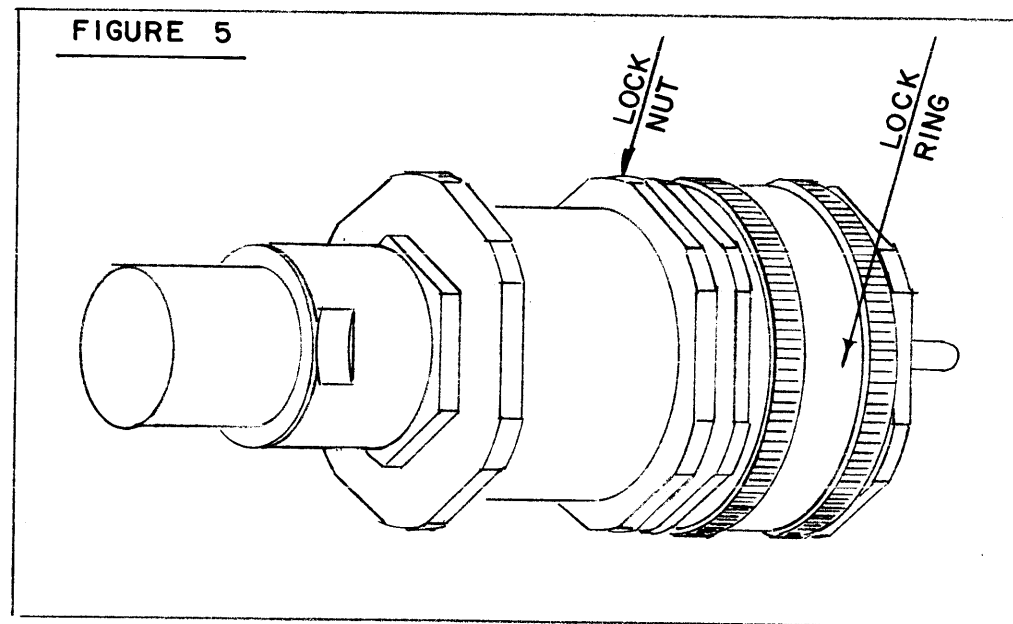
ASSEMBLY PROCEDURE

1. Disassemble plug and layout as shown. (Figure 1)
2. Remove approximately 3" of outer jacket, being careful not to nick braid. (Figure 2)
3. Slide cap, clamp nut, washer, clamp gasket over cable as shown. (Figure 3)

Note: V groove of gasket must face towards braid clamp.
4. Slide clamp over braid so that internal shoulder butts flush against end of outer jacket. (Figure 3)
5. With clamp in place, comb out braid and fold back smoothly over braid clamp. Trim off excess strands. (Figure 3)
6. Slide body carefully over clamp nut as far as it will go and tighten. For this operation, hold body rigid and rotate clamp nut. (Figure 4)
7. Using sharp knife, remove 5/8" of dielectric, exposing 1/2" of conductor. Be careful not to nick conductor. (Figure 4)
8. Use TMC tool (TP-106) to shape dielectric as shown by dotted lines. Tool must butt against contact fingers to obtain proper shape and length. (Figure 4)

Note: When tube (PM-386) is not required, form a full radius on end of conductor. When tube (PM-386) is required, it should butt flush against dielectric and soldered securely. Form a full radius on end of tube, remove all excess solder. Use chart for cable requirements, reference: PM-386.

Caution: All foreign particles must be removed.
9. Tighten cap securely over clamp nut. Hand tighten lock nut and locking ring on body as shown. (Figure 5)



CABLE	TUBE (PM-386)
RG-17/U RG-18/U	Not Required
RG-35/U RG-85/U RG-164/U	Required

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	COMPLETE REVISION	11/5/57	1		AWB	ATJ

TOLERANCES

SCALE:

DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE	FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.	SYMBOL
					THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK GENERAL ASSEMBLY INSTRUCTIONS CABLE TO QDL PLUGS			
					DRAWN: AWB 11/5/57 CHECKED: [Signature]	FINAL APPROVAL: A. J. J. ID-202 A		