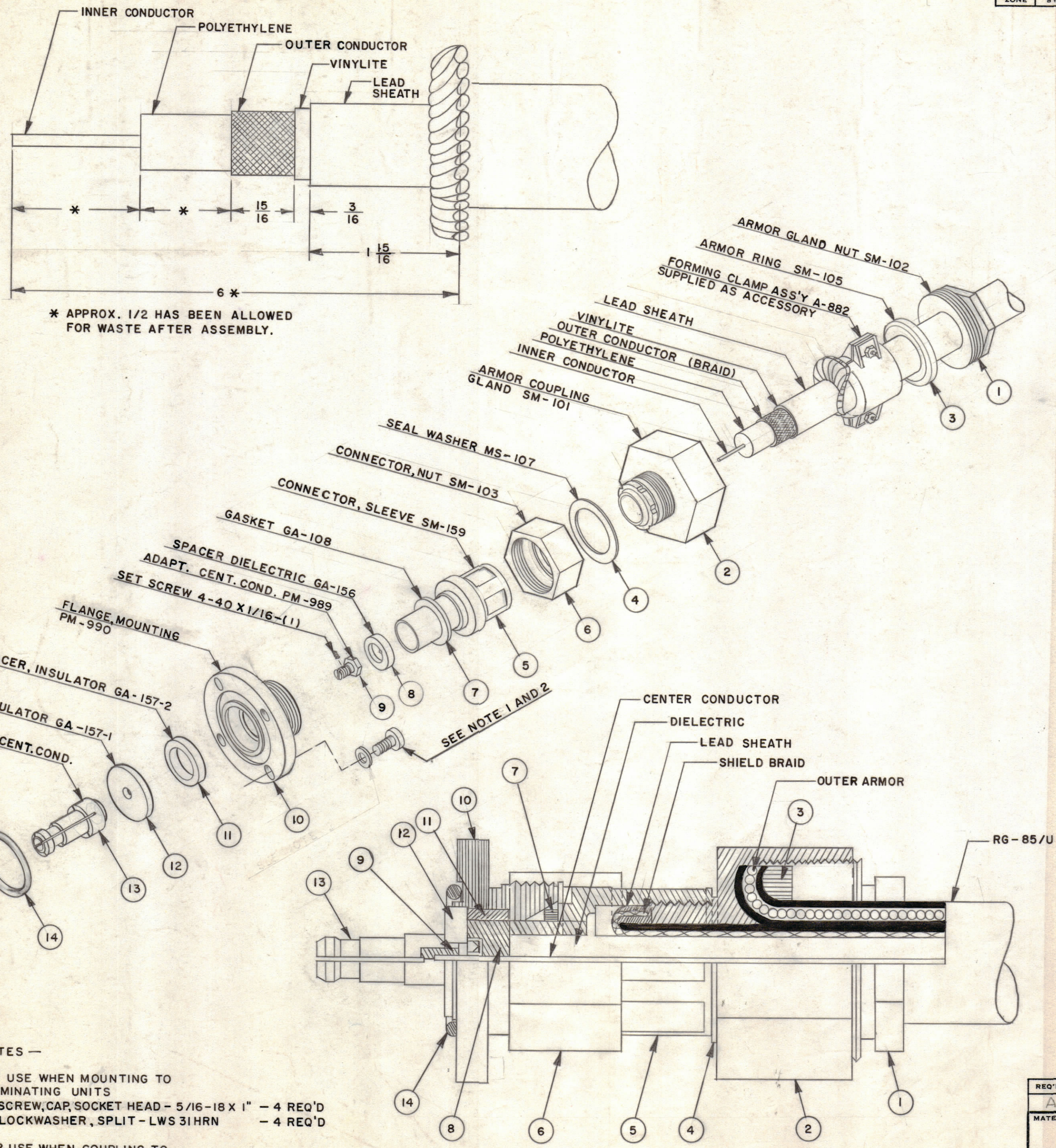


REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD

ASSEMBLING ADAPTOR TO RG-85/U CABLE

OPERATION:

1. (a) PLACE ARMOR GLAND NUT OVER RG-85/U CABLE.  
(b) PLACE ARMOR RING OVER RG-85/U CABLE, TO A DISTANCE OF APPROXIMATELY 11 INCHES FROM THE END OF CABLE.
2. (a) CUT END OF CABLE SQUARE AND CLEAN.  
(b) CLAMP BOTH HALVES OF FORMING CLAMP, TMC PART A-882, AROUND OUTER ARMOR OF RG-85/U CABLE AT DISTANCE OF 7 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  $2\frac{5}{8} \pm \frac{1}{32}$ .  
(f) REMOVE CLAMPS.
3. (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 VINYLITE JACKET SHOULD EXTEND 3/16" BEYOND THE ABOVE GLAND AND LEAD SHEATH ASSEMBLY.  
(c) CUT COPPER BRAID 1" 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 IN THE GROOVES PROVIDED FOR THIS PURPOSE.  
(f) PLACE SEAL WASHER OVER THREADS OF COUPLING GLAND.  
(g) PLACE CONNECTOR NUT OVER CONNECTOR SLEEVE.
4. (a) USING CONNECTOR SLEEVE AS GUIDE, CUT DIELECTRIC FLUSH, EXPOSING CENTER CONDUCTOR.  
(b) CUT CENTER CONDUCTOR 15/16" FROM DIELECTRIC. PLACE TEFLON DIELECTRIC SPACER TO FIT TIGHT AGAINST DIELECTRIC AND CONNECTOR, WITH COUNTER BORE FACING UP.  
(c) ASSEMBLE ADAPTOR MOUNTING FLANGE.  
(d) PLACE TEFLON COLLAR IN PLACE.  
(e) FIT CENTER CONDUCTOR ADAPTOR IN COUNTER BORED TEFLON AND TIGHTEN SET SCREW TO HOLD CENTER CONDUCTOR.  
(f) FIT TEFLON SPACER AND THREAD BULLET INTO ADAPTOR, HAND TIGHT. (SCREW DRIVER SLOT IN ADAPTOR PROVIDED). BULLET SHOULD BE THREADED WITH CARE.
5. (a) ASSEMBLE TO UNIT WITH HARDWARE AND TOOLS PROVIDED.



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

SEE NOTE 1 AND 2

- NOTES —
- 1 - FOR USE WHEN MOUNTING TO TERMINATING UNITS  
SCREW, SOCKET HEAD - 5/16-18 X 1" - 4 REQ'D  
LOCKWASHER, SPLIT - LWS 31HRN - 4 REQ'D
- 2 - FOR USE WHEN COUPLING TO 1 5/8" TRANSMISSION LINE.  
SCREW, HEX HEAD - SCHH3118NR24 - 4 REQ'D  
LOCKWASHER, SPLIT - LWS 31HRN - 4 REQ'D  
NUT, HEX - NTH3118HR16 - 4 REQ'D

NOTES

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.

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
A MARTINENGO LIST OF MATERIAL				
MATERIAL THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
FINISH TITLE ASSEMBLY INSTRUCTIONS, TCA-85/EIA-51625 TO RG-85/U				
QTY./UNIT		MODEL USED ON	ASS'Y. NO.	
SCALE		CODE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES				
DECIMALS	TOLERANCES		FRACTIONS	
.X ± .05	± 1/64		ANGLES	
.XX ± .01	± 0° 30'			
.XXX ± .005				
DRAWN	DATE	CHECKED	DATE	FINAL APPROVAL
M TANTILLO	8-3-63	Jude	8/20/63	BP
ELECT. DES.	DATE	MECH. DES.	DATE	
			8/30/63	
ID-290				REV. LTR.

ID-290