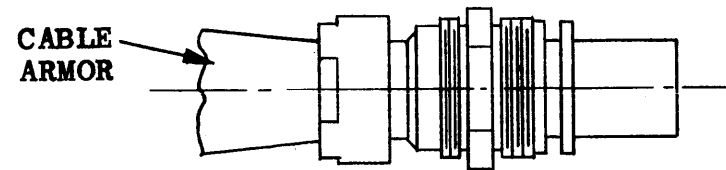
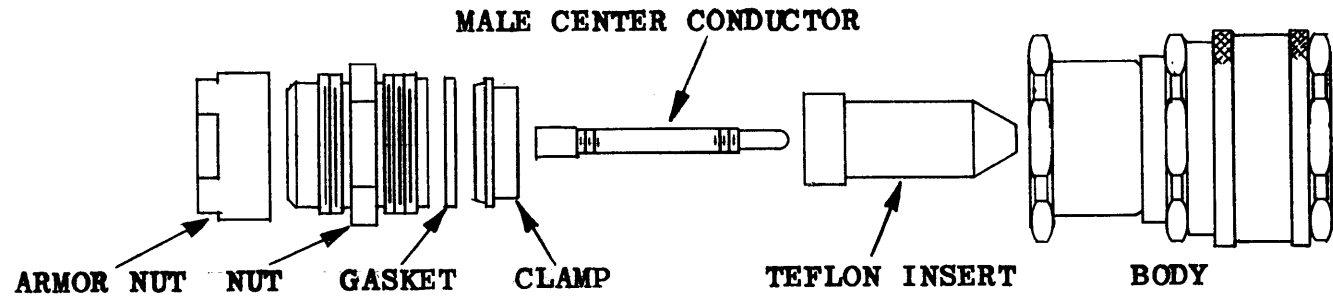


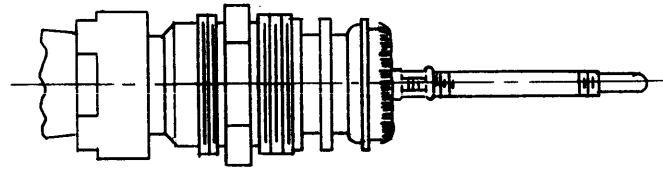
REVISIONS

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
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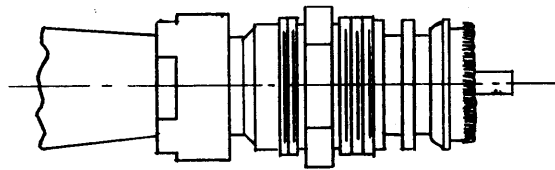
ID-291



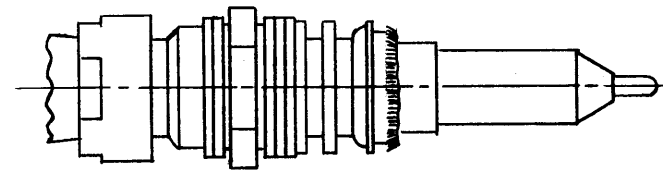
1. Cut end of cable even. Slide armor nut over cable armor. Bulge armor braid by pushing armor back on cable 6". Push nut and gasket over cable jacket. Make sure V groove on gasket is toward clamp.



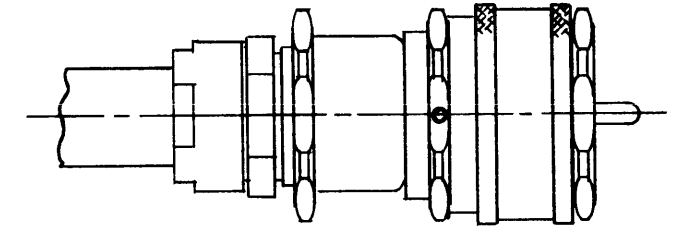
2. Remove cable jacket 9/16". (Make sure edge of jacket is evenly cut.) Push clamp over braid and seat clamp on edge of cable jacket. Cut exposed braid so that approx. 1/4" remains to form over clamp. Comb out braid and fan back over shoulder of clamp. Cut off excess braid just short of exterior flange of clamp. Cut off cable dielectric, smooth and even, to the point where braid bends over clamp. (A cable dielectric facing tool is recommended for this purpose.) Cut exposed cable center conductor to 11/32" maximum.



3. Slip center conductor pin over exposed cable center conductor flush against cable dielectric face and crimp the pin. For crimping use either Thomas & Betts #21 disc on 12 ton power head T2B#13642, or #21 disc on T & B hand tool WT-117 or UT5-E. Crimp can also be performed with T & B's TBM-2 hand tool, (use red disc) by making two crimps 1/8" apart, the first crimp being as close to cable dielectric face as possible.



4. Screw teflon insert over center conductor pin and jam it tight against the face of the cable dielectric.



5. Slip plug body assembly over teflon insert as far back as possible. Holding body stationary screw and tighten nut securely with wrench. Straighten bulge in armor. Cut armor so that it can be clamped between nut and armor nut. Tighten armor nut securely on nut with wrench.

Note: When using non-armored cable, disregard all instructions pertaining to armor.

NOTES

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REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
MARTINENGO LIST OF MATERIAL				
MATERIAL			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH			TITLE ASSEMBLY INSTRUCTIONS FOR QDL PLUG	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES			DRAWN M TANTILLO DATE 10-5-63	FINAL APPROVAL <i>BP</i> DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005			TOLERANCES ± 1/64 ANGLES ± 0° 30'	DATE 10-11-63
			ELECT. DES. <i>[Signature]</i>	DATE
			MECH. DES. <i>[Signature]</i>	DATE 10-7-63
			ID-291	
			SHEET	REV. LTR.