

DATE 5/28/53

SH. 1 OF 1

COMPILED BY

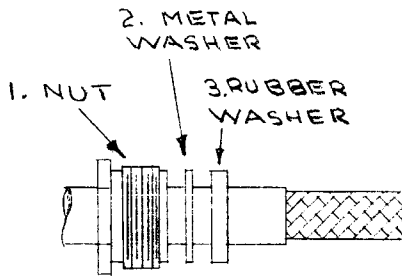
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TMC SPECIFICATION NO. S-166

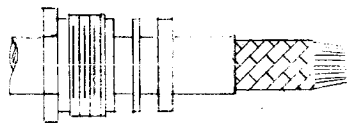
TITLE: CABLE ASSEMBLY - TYPE BNC CONNECTOR

JOB

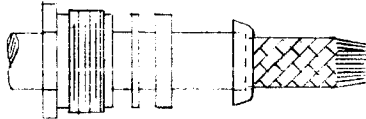
APPROVED



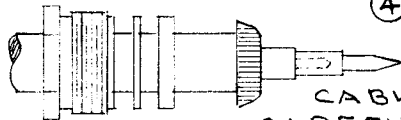
- ① PLACE PARTS 1-2-3 OVER CABLE AND CUT OFF JACKET $\frac{1}{4}$ INCH FROM END. DO NOT NICK BRAID.



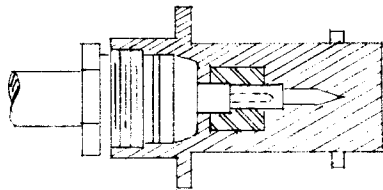
- ② CUT OFF INNER INSULATION AND CENTER CONDUCTOR UNDER BRAID $\frac{3}{8}$ INCH FROM END OF JACKET. TAPER BRAID.



- ③ SLIDE CLAMP OVER TAPERED BRAID TO FIT TIGHT AGAINST JACKET. BE SURE INNER SHOULDER OF CLAMP IS SNUG AGAINST END OF JACKET.



- ④ WITH CLAMP IN PLACE, COMB OUT BRAID, FOLD BACK SMOOTHLY AS SHOWN, AND TRIM $\frac{3}{32}$ INCH FROM END. CUT INNER CABLE DIELECTRIC $\frac{1}{8}$ INCH FROM BRAID, BEING CAREFUL NOT TO NICK INNER CABLE CONDUCTOR. SLIP MALE CONTACT IN PLACE AND SOLDER; REMOVE EXCESS SOLDER. MAKE CERTAIN CABLE DIELECTRIC HAS NOT BEEN DEFORMED BY HEAT FROM PREVIOUS SOLDERING OPERATIONS.



- ⑤ SLIP CABLE INTO CONNECTOR BODY AS FAR AS POSSIBLE, THEN SLIDE NUT INTO BODY AND SCREW INTO PLACE WITH WRENCH UNTIL MODERATELY TIGHT BY HOLDING CABLE AND SHELL RIGIDLY AND ROTATING NUT.