

DATE 2/24/58
 SH. 1 OF 2
 COMPILED BY
L. W. G.

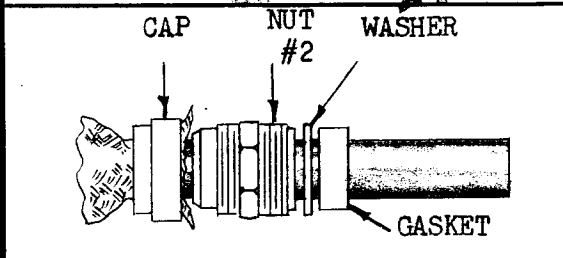
TMC SPECIFICATION NO. S-124

TITLE: HN TYPE CONNECTOR & CABLE ASSEMBLY

JOB

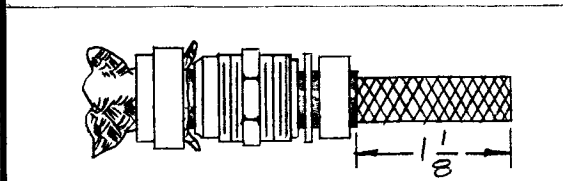
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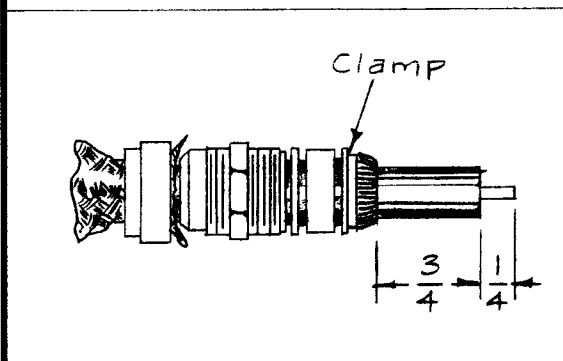
STEP 1.

Cut end of cable even. Insert cap over cable armor. Bulge armor braid by pushing armor back on cable 6". Push nut #2, washer and gasket over cable jacket. (See Note Below)



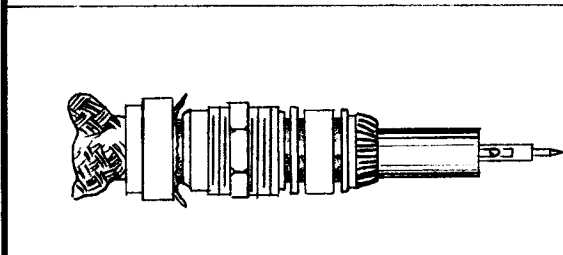
STEP 2.

Remove vinyl jacket $1\frac{1}{8}$ " from end of cable. For double shield cables, remove vinyl jacket $1\frac{3}{16}$ " from end of cable.



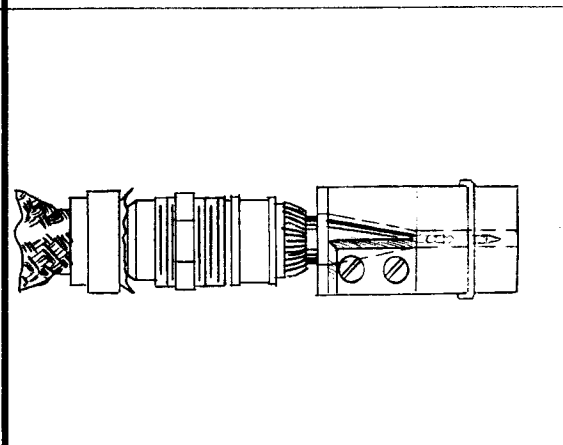
STEP 3.

Push clamp over copper braid, flush against cable jacket. Cut exposed copper braid so that approximately $\frac{1}{4}$ " remains and fan over clamp. Trim braid even with end of taper. Cut cable dielectric $\frac{3}{4}$ " from braid. Tin exposed conductor.



STEP 4.

Solder contact pin to conductor. Do not overheat dielectric. Do not use excess solder. Wipe clean; see that dielectric is free from solder, resin and foreign material.



STEP 5.

Taper dielectric with (MX-103/U) trimming tool. When tapering dielectric of cable for plug assembly, push contact stop of tool to bottom of slot. Tool will stop cutting when shoulder of contact butts against stop. For jack assembly see that stop is at top of slot. Cable will be properly tapered when end of center contact is flush with end of trimmer body.

NOTE:



NUT #1

When cable without armor is used, the cap and Nut #2 are not required. Instead Nut #1 is used and instructions pertaining to armor disregarded.

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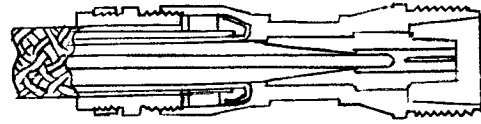
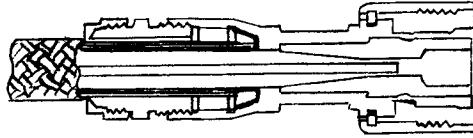
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STEP 6.

Apply small amount of Amphenol 307 Silicone Compound on tapered surface of dielectric. Insert assembly into connector body. Tighten Nut #1 (or Nut #2 if cable is armored) securely with wrench. Straighten bulge in armor. Cut armor so that it can be clamped between Nut #2 and cap. Tighten cap securely on Nut #2 with wrench.