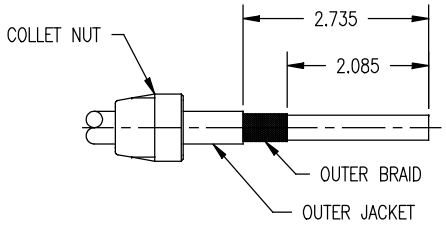
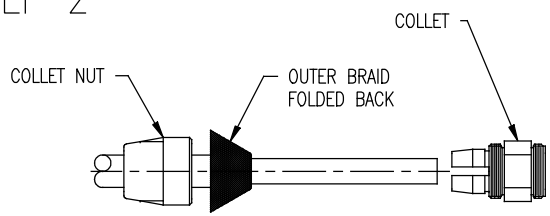
DASH NO.	M CODE	MADE FROM

STEP 1



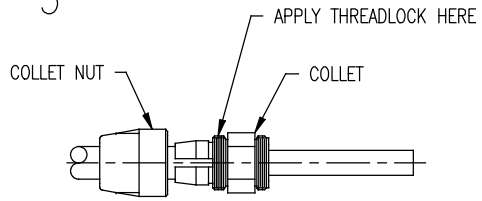
- SLIDE COLLET NUT ON TO THE CABLE.
- STRIP OUTER JACKET BACK 2.735 INCHES.
- TRIM OUTER BRAID BACK 2.085 INCHES.

STEP 2



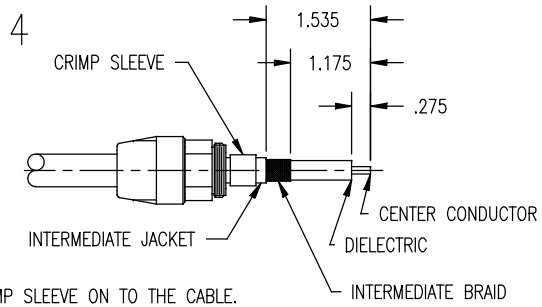
- FOLD OUTER BRAID BACK AGAINST OUTER JACKET.
- SLIDE COLLET DOWN CABLE UNTIL IT STOPS.

STEP 3



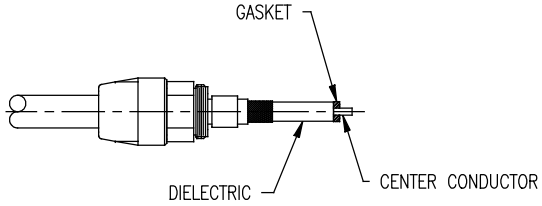
- APPLY THREADLOCKER TO COLLET THREAD (FINGER END).
- THREAD COLLET NUT ONTO COLLET USING WRENCHES, UNTIL IT STOPS.

STEP 4



- SLIDE CRIMP SLEEVE ON TO THE CABLE.
- STRIP INTERMEDIATE JACKET BACK 1.535 INCHES.
- TRIM INTERMEDIATE BRAID BACK 1.175 INCHES.
- TRIM DIELECTRIC BACK .275 INCHES.

STEP 5



- SLIDE GASKET ON TO CENTER CONDUCTOR UNTIL FLUSH WITH DIELECTRIC.

★ CRITICAL DIMENSIONS

UNLESS OTHERWISE SPECIFIED

1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS ± .010
   3 PLACE DECIMALS ± .004 ANGLES ± 1°
   CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.
2. REMOVE ALL BURRS, BREAK SHARP EDGES .005 MAX.
3. NO FILLETS PERMITTED.
4. SURFACE ROUGHNESS 63 MICRO-INCHES RMS MAX.
5. ALL DIMENSIONS PRIOR TO PLATING.
6. ALL PLATING IN ACCORDANCE WITH KER 10004.
7. ALL LEAD THREADS TO BE CHAMFERED 45° TO ROOT DIAMETER.

3-771 (SHEET 1 OF 2)

REVISIONS

ISSUE	CHANGES
1	ER 39265 JPK 05/04/05

3-771S1

SCALE 3 : 1

APPROX SURFACE AREA N/A

USED ON

REF: EQR 905

CABLE INSTRUCTIONS

DRAWN	J. KENNEDY	DATE	04/26/05
DESIGN	J. KENNEDY	DATE	04/26/05
APPR.		DATE	

KINGS ELECTRONICS CO., INC.
ROCK HILL, SOUTH CAROLINA 29730

3-771
(SHEET 1 OF 2)