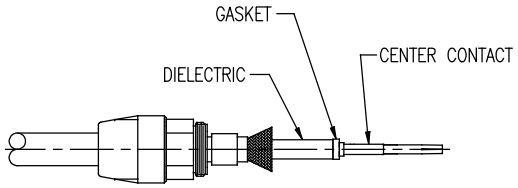
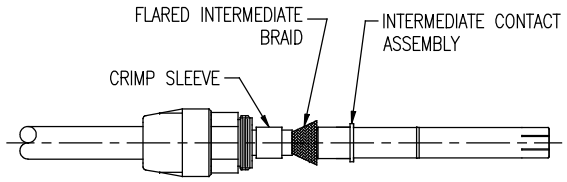
DASH NO.	M CODE	MADE FROM

STEP 6



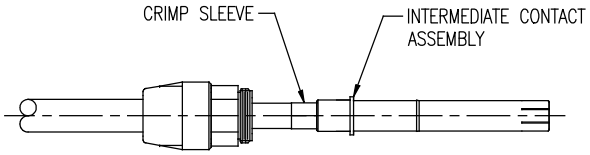
- SLIDE CENTER CONTACT OVER CENTER CONDUCTOR UNTIL FLUSH AGAINST GASKET.
- SOFT SOLDER CENTER CONTACT TO CENTER CONDUCTOR. CENTER CONTACT MUST REMAIN FLUSH WITH GASKET AFTER SOLDERING.

STEP 7



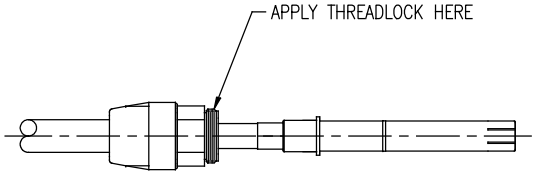
- FLAIR INTERMEDIATE BRAID.
- SLIDE INTERMEDIATE CONTACT ASSEMBLY ONTO CABLE UNTIL IT STOPS, MAKING SURE BRAID LIES OVER K-GRIP BODY.

STEP 8



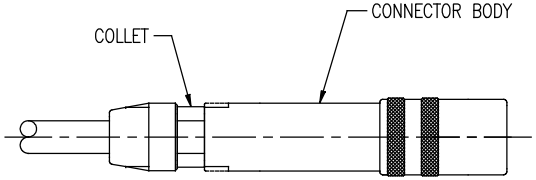
- SLIDE CRIMP SLEEVE OVER BRAID AND CHECK CENTER CONTACT AND INTERMEDIATE CONTACT INTERFACES.
- CRIMP USING KTH-1000 CRIMP TOOL AND KTH-2035 CRIMP DIE.

STEP 9



- APPLY THREADLOCK TO REMAINING EXPOSED COLLET THREADS.

STEP 10



- SLIDE CONNECTOR BODY OVER INTERMEDIATE CONTACT ASSEMBLY AND THREAD THE BODY ONTO THE COLLET UNTIL IT STOPS.

★ 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 2 OF 2)

REVISIONS

ISSUE	CHANGES
1	ER 39265 JPK 05/04/05

3-771S2

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 2 OF 2)