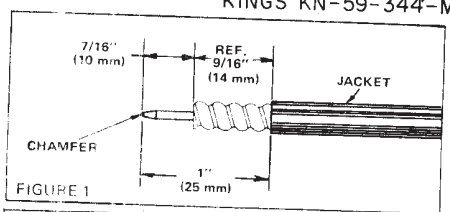


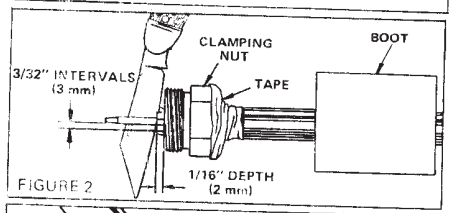
CABLING PROCEDURE FOR
 KINGS KN-59-344-MAF

KINGS ELECTRONICS CO., INC

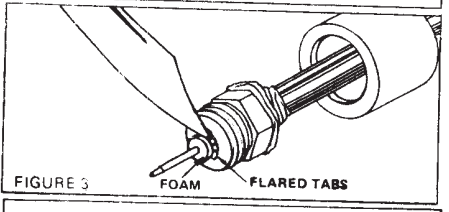
STEP 1. Prepare cable as shown in Figure 1. Cable end must be square. If it is not, use hacksaw to make new cut. Wrap tape around cable to guide jacketing cut. Remove jacket with knife. Cut off outer conductor and foam with hacksaw. Do not damage inner conductor. Use file to remove burrs and chamfer end of inner conductor. Clean exposed inner conductor of foam particles with garnet cloth. Wire brush copper particles from foam.



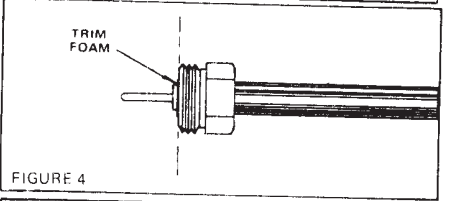
STEP 2. Place boot and clamping nut on cable with opening of boot toward cable end. See Figure 2. Secure clamping nut in place with tape, exposing outer conductor to dimension shown. Cut tabs into outer conductor to depth and intervals shown. Use mallet to tap knife. Use clamping nut as stop for knife.



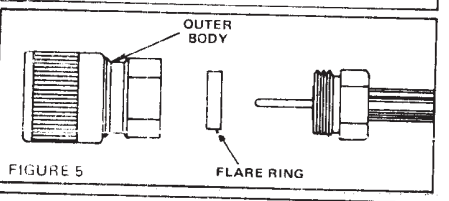
STEP 3. Turn tabs up 90 degrees with point of knife as shown in Figure 3. Remove tape from clamping nut.



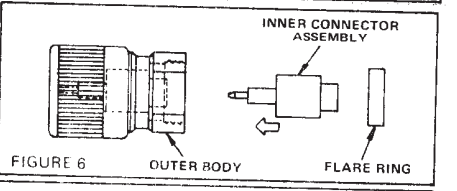
STEP 4. Cut off foam flush with flared outer conductor. Do not cut into inner conductor. See Figure 4. Remove all copper particles from foam.



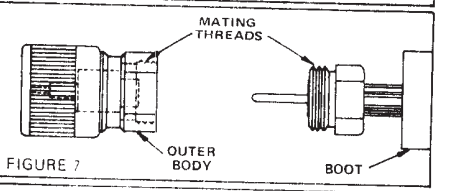
STEP 5. Add flare ring and outer body as shown in Figure 5. Screw outer body to clamping nut and tighten to compress flared tabs against clamping nut. Turn outer body only; do not turn clamping nut. Disassemble connector and inspect flare for regularity and flatness to clamping nut.



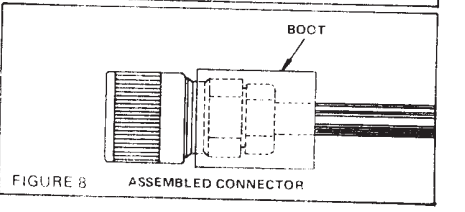
STEP 6. Seat inner connector assembly and flare ring into outer body. Refer to Figure 6. Inner assembly must be fully inserted into outer body as indicated by dotted lines.



STEP 7. Slide outer body onto inner connector and screw it to clamping nut. Tighten connection. Turn outer body only; do not turn clamping nut. See Figure 7.



STEP 8. Place boot over assembly and seat it in groove of outer body. Refer to assembled connector in Figure 8.



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UNLESS OTHERWISE SPECIFIED:
 1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS ± .010
 3 PLACE DECIMALS ± .004
 T, L, R, ANGLES ± 0°30'
 NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.

2. REMOVE ALL BURRS, BREAK SHARP EDGES .005 MAX.
 3. NO FILETS PERMITTED.
 4. SURFACE ROUGHNESS 63 MICRONS RMS MAX.
 5. ALL DIMENSIONS PRIOR TO PLATING.
 6. ALL PLATING IN ACCORDANCE WITH KER 1000A.

NOTES:
 1. INSTRUCTION SHEET TO BE PRINTED
 ON WHITE, SULPHUR FREE PAPER.

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ISSUE REVISIONS
 CHANGES

SCALE	
APPROX SURFACE AREA	
USED ON:	KN-59-344-MAF
REF:	
CABLING INSTRUCTIONS	
DRAWN/PAS	DATE/10 APR 81
APPR. L.S.	DATE/13 APR 81
KINGS ELECTRONICS CO. INC. (INCORPORATED NEW YORK 1970)	
3-171	