

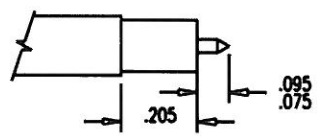
DASH NO.	M CODE	MADE FROM
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3-652

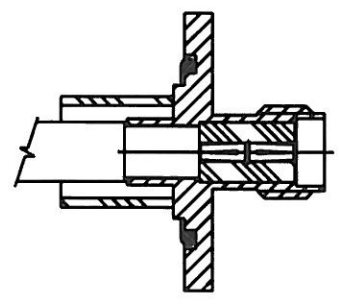
REVISIONS	
ISSUE	CHANGES
0	ER 37320 BP 08/21/97
1	CN 37531 E KH 01/20/98

CABLING PROCEDURE FOR M17/130-00004

- CUT CABLE END SQUARE
- WHEN USING T-FLEX402HF CABLE SOLDER DIP CABLE PER SHEET 2 OF 3-648.
- TRIM CABLE TO DIMENSIONS SHOWN.
- INSERT TRIMMED CABLE INTO CONNECTOR.
- SOLDER CABLE IN BODY



- INSERT TRIMMED CABLE INTO CONNECTOR.
BOTTOM CABLE AGAINST INSULATOR (ASSEMBLE MATING CONNECTOR TO PREVENT INSULATOR MOVEMENT).



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SCALE	4:1
APPROX SURFACE AREA	
USED ON	
REF:	
CABLE INSTRUCTIONS	
DRAWN P. BRENZEL	DATE 12 JUN 97
DESIGN P. BRENZEL	DATE 12 JUN 97
APPR. FDH	DATE 21 AUG 97

UNLESS OTHERWISE SPECIFIED

1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS ± .010	2. REMOVE ALL BURRS, BREAK SHARP EDGES .005 MAX.	7. ALL LEAD THREADS TO BE CHAMFERED 45° TO ROOT DIAMETER.
3 PLACE DECIMALS ± .004 ANGLES ± 0° 30'	3. NO FILLETS PERMITTED.	* CRITICAL DIMENSIONS
CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.	4. SURFACE ROUGHNESS 63 MICRONS RMS MAX.	
	5. ALL DIMENSIONS PRIOR TO PLATING.	
	6. ALL PLATING IN ACCORDANCE WITH KER 10004.	

KINGS
ELECTRONICS CO., INC.
TUCKAHOE, NEW YORK 10707

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