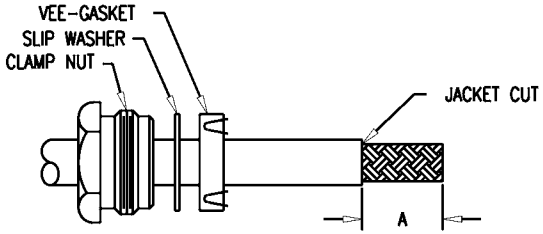
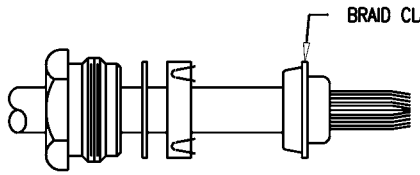
DASH NO.	M CODE	MADE FROM
SEE TABLE	M88	INDIVIDUAL CUT SHEETS

60D-5

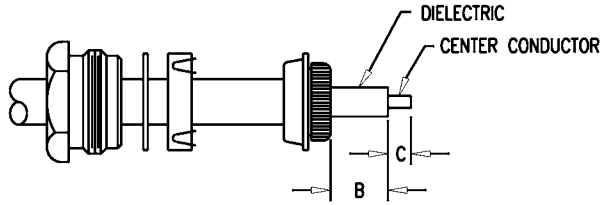
KINGS ELECTRONICS CO., INC., TUCKAHOE, N.Y.



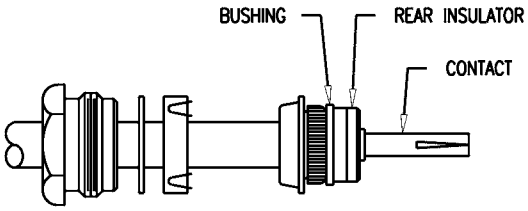
1. CUT CABLE END SQUARE, PLACE CLAMP NUT, SLIP WASHER (WHEN SUPPLIED) AND VEE-GASKET OVER JACKET. REMOVE JACKET TO DIMENSION "A".



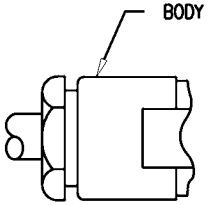
2. COMB OUT BRAID AND TAPER FORWARD. PLACE BRAID CLAMP OVER BRAID AGAINST JACKET CUT.



3. FOLD OUTER BRAID BACK OVER BRAID CLAMP AND TRIM AS SHOWN. REMOVE INNER JACKET TO EDGE OF OUTER BRAID. COMB OUT INNER BRAID AND FOLD BACK OVER OUTER BRAID AND BRAID CLAMP. TRIM INNER BRAID AS SHOWN. REMOVE DIELECTRIC TO DIMENSION "B". CUT CENTER CONDUCTOR TO DIMENSION "C".



4. PLACE BUSHING AND REAR INSULATOR OVER DIELECTRIC AND AGAINST BRAID CLAMP AS SHOWN. SOLDER OR CRIMP (WHEN APPLICABLE) CONTACT TO CENTER CONDUCTOR.



5. PLACE FRONT INSULATOR OVER CONTACT. THREAD ASSEMBLY INTO CONNECTOR BODY AND LOCK SECURELY. VEE-GASKET MUST BE SPLIT BY BRAID CLAMP. (35-40 IN-LBS RECOMMENDED TORQUE).

TRIM CODE CHART			
DASH NO.	A	B	C
-1	.625	.288	.218

REDUCE TO 2 1/2 IN. X 3 IN.

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

UNLESS OTHERWISE SPECIFIED:
1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS ± .010
3 PLACE DECIMALS ± .004 ANGLES ± 0° 30'
T.I.R. 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 MICROINCHES 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.

REVISIONS

ISSUE	CHANGES
	JCAX1576

SCALE NONE(P4:1)

APPROX SURFACE AREA

USED ON

REF:

CABLING INSTRUCTIONS

DRAWN	VLS	DATE	10/19/95
DESIGN	VLS	DATE	10/19/95
APPR.	VLS	DATE	10/19/95

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

60D-5

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