

A
ES,ST-5875

SPECIFICATIONS

SERIES : ES,ST-5875
 NO OF CONTACT :
 TYPE OF CONTACT :
 DIELECTRIC : TEFLON

ELECTRICAL DATA

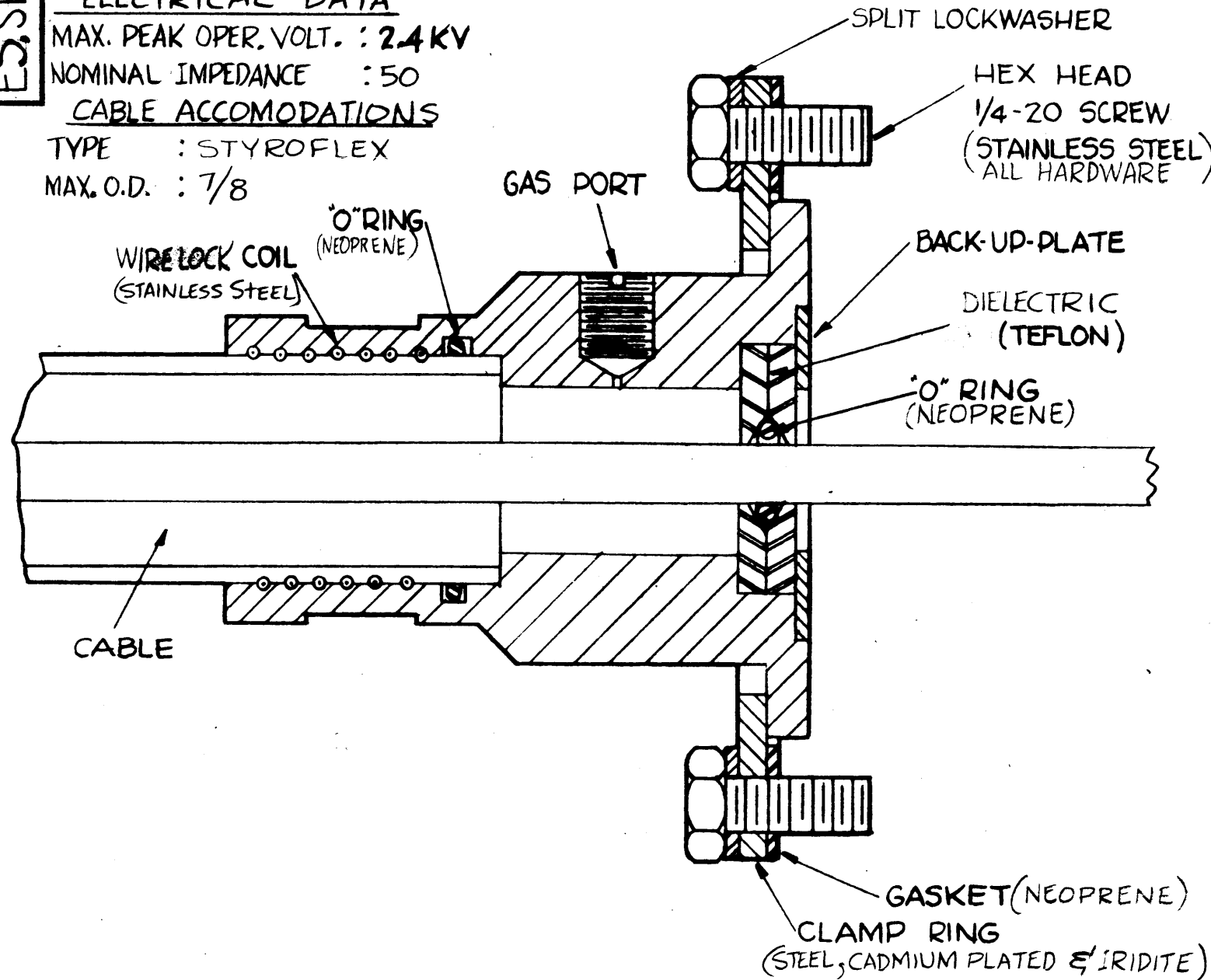
MAX. PEAK OPER. VOLT. : 2.4KV
 NOMINAL IMPEDANCE : 50

CABLE ACCOMODATIONS

TYPE : STYROFLEX
 MAX. O.D. : 7/8

INSTALLATION INSTRUCTIONS

1. Using a sharp tubing cutter, score cable 1" to 2" from end. Do not cut through aluminum jacket.
2. Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshin fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
3. Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
4. Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
5. Cut off center conductor 2-1/2 inches from end of cable. Remove cut-off burr from center conductor. Take care not to allow chips to enter cable.
6. Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. The sleeve should slide freely over cable.
7. Grease sleeve "O" ring with "O" ring grease, GL-118, (No. 4 compound), and install in sleeve.
8. Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound, (GL-117). Use the compound sparingly and wipe off any excess before starting sleeve on cable.
9. Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
10. Push bead over center conductor with countersink facing outward. Apply "O" ring grease, GL-118, (No. 4 compound), to small "O" ring and push it on center conductor. Push second bead on center conductor with countersink facing inward.
11. Place back-up plate over center conductor and push toward sleeve so that beads and back-up plate seat in sleeve counterbores.
12. Bring up sleeve assembly to box and place gasket over tapped holes in box.
13. Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.



NOTE: GL-118 (#4 compound) Supplied By TMC
 GL-117 (Lubricant, Thread)

| | | | | | | | | | | | |
|---|-------------|---|---------|---------------|---------|----------------------------------|--------|------------|----|------|--|
| A PART NO. WBS ESN-587, SERIES WAS ESW. | | | | | | | 830-62 | 7169 | SC | | |
| SYM | DESCRIPTION | DATE | CH. NO. | DRAFTS | CHECKER | ENG. APP. | | | | | |
| UNLESS OTHERWISE SPECIFIED: | | SCALE: S-401-70-9006 | | | | | | | | | |
| DIMENSIONS ARE IN INCHES | | MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. | | | | | | | | | |
| TOLERANCES ON FRACTIONS ± 1/64 | | DECIMALS ± .005 | | ANGLES ± 1/2° | | REMOVE ALL BURRS AND SHARP EDGES | | | | | |
| | | RAC SERIES | | MODEL | | SECTION | | ASS'Y. NO. | | DATE | |
| | | REQ. PER UNIT | | USED ON | | | | | | | |

| REQ. | ITEM | PART NO. | DESCRIPTION | SYMBOL |
|--|------|-------------------|-------------|-----------------|
| THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | | | | |
| STOCK SIZE | | | | |
| CONNECTOR, BOX, 7/8 STYROFLEX | | | | |
| MATERIAL | | | | |
| 50 OHM. | | | | |
| TYPE & TEMPER | | HEAT TREAT. SPEC. | | DRAWN |
| | | | | CHECKER |
| | | | | FINAL APPROVAL |
| | | | | ELEC. DES. APP. |
| | | | | MECH. DES. APP. |
| | | | | ES,ST-5875 |
| | | | | A |

INSTALLATION INSTRUCTIONS:

- Using a sharp tubing cutter, score cable 3" to 4" from end. Do not cut through aluminum jacket.
- Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoe-shine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector starts against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
- Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Pull back on the cable until about 1/8" of Polyethylene Foam is exposed.
- Using hot knife tool, cut polyethylene foam down to center conductor flush with aluminum jacket. Pull off short end of jacket and polyethylene foam. Cut off center conductor 2-1/2 inches from end of cable. Remove cut-off burr from center conductor. Take care not to allow chips to enter cable.
- Slide clamp ring over cable. Check roundness and size of cable using sleeve as gauge. The sleeve should slide freely over cable.
- Grease sleeve "O" ring with "O" ring grease, GL-118, (No. 4 compound), and install in sleeve.
- Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound, (GL-117). Use the compound sparingly and wipe off any excess before starting sleeve on cable.
- Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
- Push bead over center conductor with countersink facing outward. Apply "O" ring grease, GL-118, (No. 4 compound), to small "O" ring and push it on center conductor. Push second bead on center conductor with countersink facing inward.
- Place back-up plate over center conductor and push toward sleeve so that beads and back-up plate seat in sleeve counterbores.
- Bring up sleeve assembly to box and place gasket over tapped holes in box.
- Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

NOTE: GL-118 (#4 compound) Supplied
 GL-117 (Lubricant, Thread) By T M C

SPECIFICATIONS:

Series - "ES"- "F"
 No. of Contacts - One (1)
 Type of Contact - Dielectric - Teflon

ELECTRICAL DATA:

Max. Peak Opr. Volt - 2.4 KV.
 Nominal Impedance - 70 Ohms

CABLE ACCOMMODATIONS:

Type - Foamflex - 7/8
 Max. O. D. - 7/8

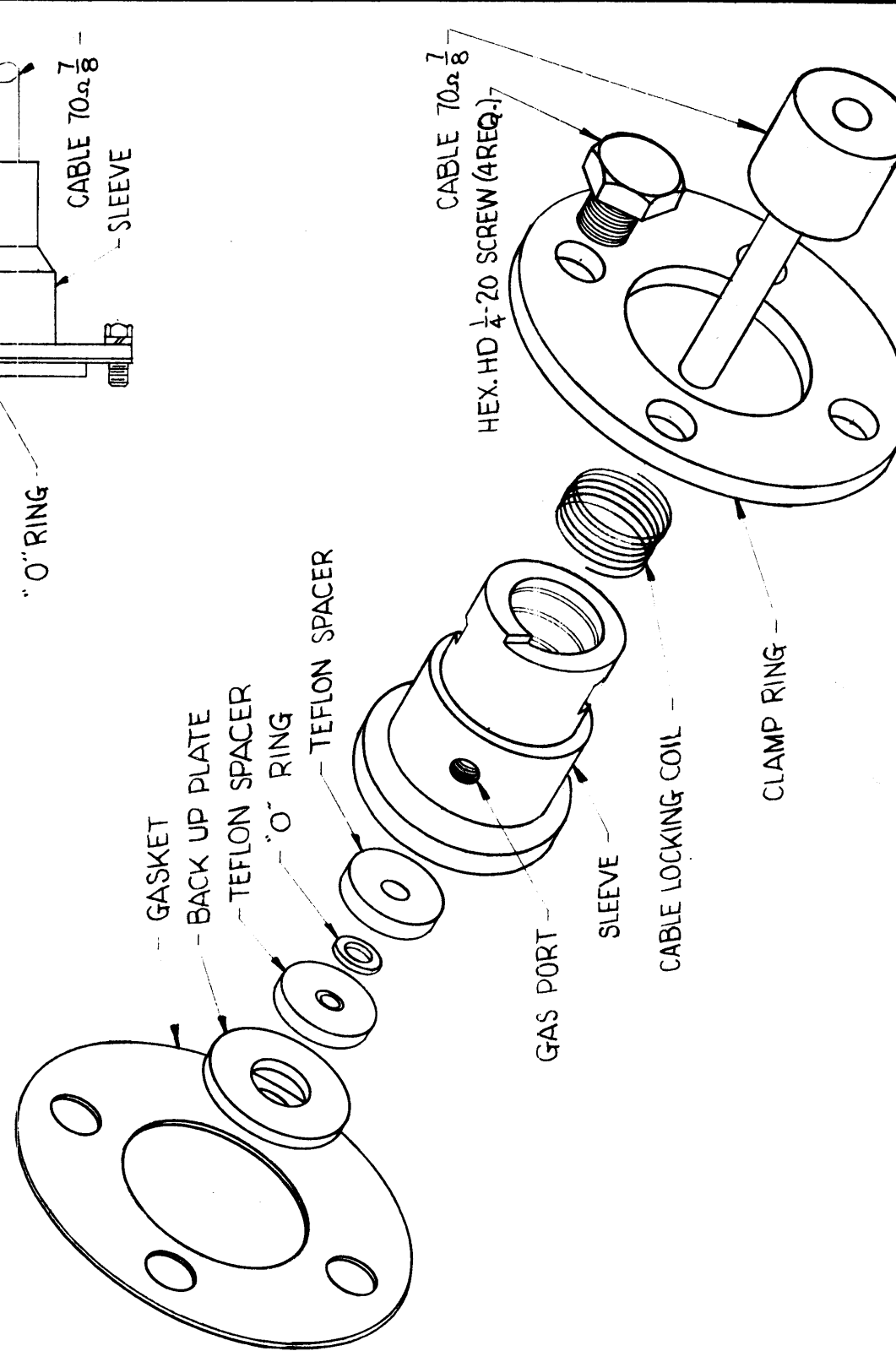
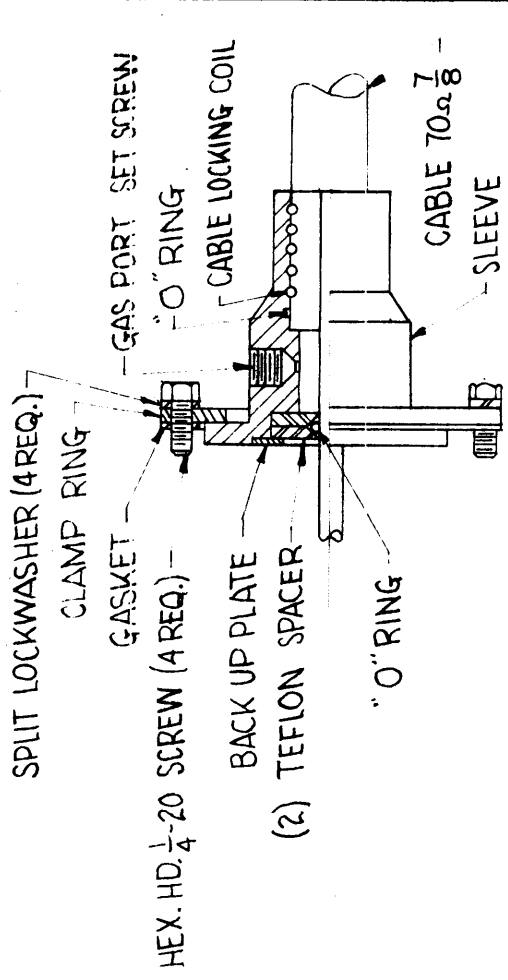
NOTES

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

| SYM | DESCRIPTION | DATE | E.M.N. NO. | DRAFT | CHKD | APPD |
|-----|-------------|------|------------|-------|------|------|
|-----|-------------|------|------------|-------|------|------|

ES-FX-7875

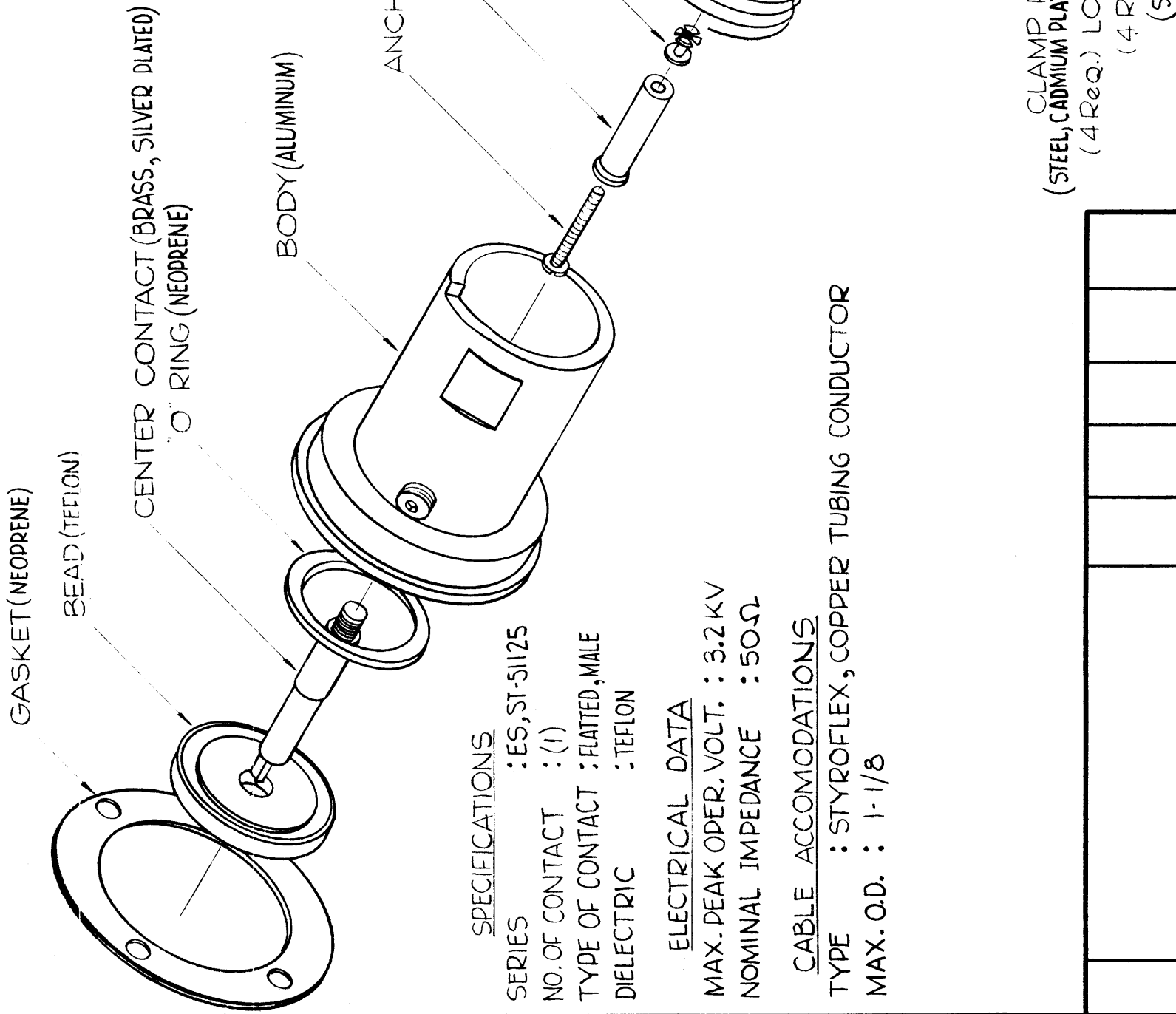
| REVISIONS |
|-----------|
|-----------|



| REQ'D. | ITEM | PART NUMBER | DESCRIPTION | SYMBOL |
|---|------|--------------|-----------------------------------|--------------|
| LIST OF MATERIAL | | | | |
| MATERIAL | | | | |
| FINISH | | | | |
| THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | | | | |
| CONNECTOR BOX 7/8 FOAMFLEX - 70Ω | | | | |
| DRAWN <i>R. Juchin</i> | | DATE 6-7-62 | FINAL APPROVAL <i>[Signature]</i> | DATE 6-11-62 |
| CHECKED <i>[Signature]</i> | | DATE 6-9-62 | | |
| ELECT. DES. <i>[Signature]</i> | | DATE | | |
| MECH. DES. <i>[Signature]</i> | | DATE 6/11/62 | | |
| TOLERANCES | | | ES-FX-7875 | |
| DECIMALS ± .05 | | | SHEET | |
| .XX ± .01 | | | REV. LTR. | |
| .XXX ± .005 | | | | |

| | | | |
|---|--|-------------------------|--|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES | | ASSY. NO. S-401-70-2689 | |
| SCALE DO NOT SCALE | | MODEL USED ON CODE | |
| QTY./UNIT 1 | | ES-FX-7875 | |

SUPPLIED BY TMC
 GL-117 - LUBRICANT, THREAD
 GL-118 - COMPOUND, SILICONE



SPECIFICATIONS

SERIES : ES, ST-51125
 NO. OF CONTACT : (1)
 TYPE OF CONTACT : FLATTED, MALE
 DIELECTRIC : TEFLON

ELECTRICAL DATA

MAX. PEAK OPER. VOLT. : 3.2 KV
 NOMINAL IMPEDANCE : 50Ω

CABLE ACCOMODATIONS

TYPE : STYROFLEX, COPPER TUBING CONDUCTOR
 MAX. O.D. : 1-1/8

- Using a sharp tubing cutter, score cable 3" from end. Do not cut through aluminum jacket.
- Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeing fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
- Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
- Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
- Saw off center conductor 1/8" from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor being careful to keep chips out of cable.
- Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
- Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. Sleeve should slide freely over cable.
- Grease sleeve "O" ring with "O" grease, TMC GL-118 No. 4 Compound, and install in sleeve.
- Push on wire coil over jacket until coil is entirely in jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize GL-117 COMPOUND. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
- Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve.
- Turn on sleeve until cable butts internal shoulder.
- Screw center contact into female contact.
- Push bead over center contact with countersink facing outward. Grease with Dow Corning No. 4 Compound and mount "O" rings in place, and mount second bead over center contact. Push entire bead assembly down into sleeve counterbore.
- Bring up sleeve assembly to box and place gasket over tapped holes in box.
- Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

| | | | |
|--------------------|-------------------|--|----------------|
| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
| | | THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
| | | BOX CONNECTOR ASS'Y | |
| | | 1-1/8 STYROFLEX, 50Ω, COPPER TUBING CONDUCTOR | |
| | | J.C. Biele | |
| | | DRAWN | CHECKER |
| | | 5 | FINAL APPROVAL |
| | | ES, ST-51125 A | |
| | | ELEC. DES. APP. MECH. DES. APP. | |
| TYPE & TEMPER | HEAT TREAT. SPEC. | | |
| FINISH & SPEC. NO. | | | |

| | | | | |
|---------------|-------|---------|-----------|---------|
| REQ. PER UNIT | MODEL | SECTION | ASSY. NO. | DATE |
| | | | | 3-30-61 |
| USED ON | | | | |

| | | | | |
|--|---------|--------|---------|-----------|
| DATE | CH. NO. | DRAFTS | CHECKER | ENG. APP. |
| 8-30-61 | 7169 | 56 | | |
| SCALE: S-401-70-9008 | | | | |
| MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES | | | | |

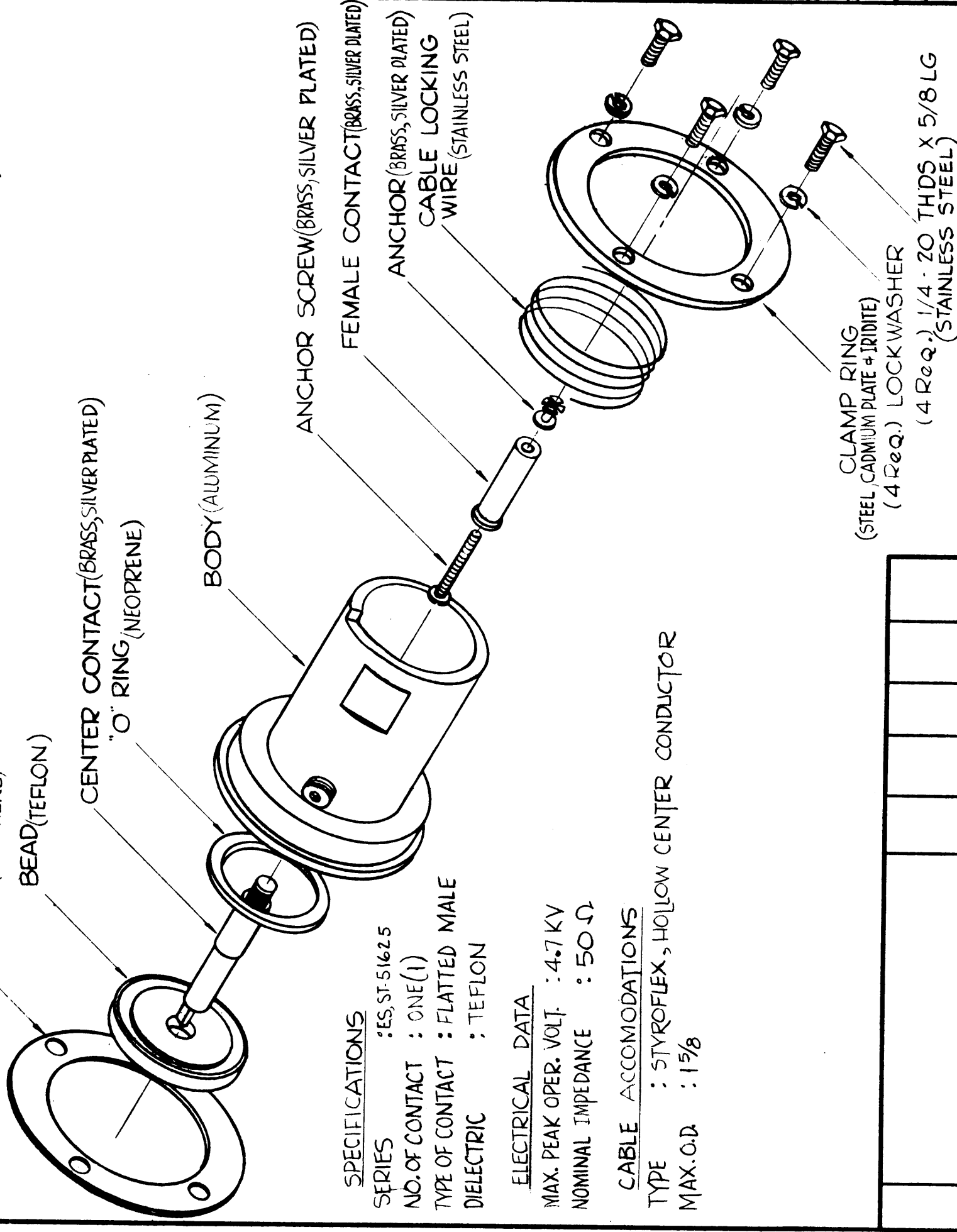
| |
|--|
| UNLESS OTHERWISE SPECIFIED: |
| DIMENSIONS ARE IN INCHES |
| TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/20 |

INSTALLATION INSTRUCTIONS BOX CONNECTOR

1. Using a sharp tubing cutter, cut cable 3" from end. Do not cut through aluminum jacket.
2. Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on the groove. The emery cloth should be used in a shoe shine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
3. Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
4. Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
5. Saw off center conductor 1/8" from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor being careful to keep chips out of cable.
6. Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
7. Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. Sleeve should slide freely over cable.
8. Grease sleeve "O" ring with "0" grease, TMC GL-118 No. 4 Compound, and install in sleeve.
9. Push on wire coil over jacket until coil is entirely in jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize GL-117 Compound. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
10. Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
11. Screw center contact into female contact.
12. Push bead over center contact with countersink facing outward. Grease with Dow Corning No. 4 Compound and mount "O" rings in place, and mount second bead over center contact. Push entire bead assembly down into sleeve counterbore.
13. Bring up sleeve assembly to box and place gasket over tapped holes in box.
14. Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
|-----------|----------|--|--------|
| | | THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
| | | BOX, CONNECTOR ASS'Y | |
| | | 1-5/8 STYROFLEX, 50%, HOLLOW CENTER CONDUCTOR | |
| | | J.C. Biele | |
| | | DRAWN | |
| | | CHECKER | |
| | | FINAL APPROVAL | |
| | | ES-ST-51625 | A |
| | | ELEC. DES. APP. MECH. DES. APP. | |

SUPPLIED BY TMC
GL-117 - LUBRICANT, THREAD
GL-118 - COMPOUND, SILICONE



SPECIFICATIONS
 SERIES : ES-ST-51625
 NO. OF CONTACT : ONE (1)
 TYPE OF CONTACT : FLATTED MALE
 DIELECTRIC : TEFLON

ELECTRICAL DATA
 MAX. PEAK OPER. VOLT. : 4.7 KV
 NOMINAL IMPEDANCE : 50 Ω

CABLE ACCOMODATIONS
 TYPE : STYROFLEX, HOLLOW CENTER CONDUCTOR
 MAX. O.D. : 1 5/8

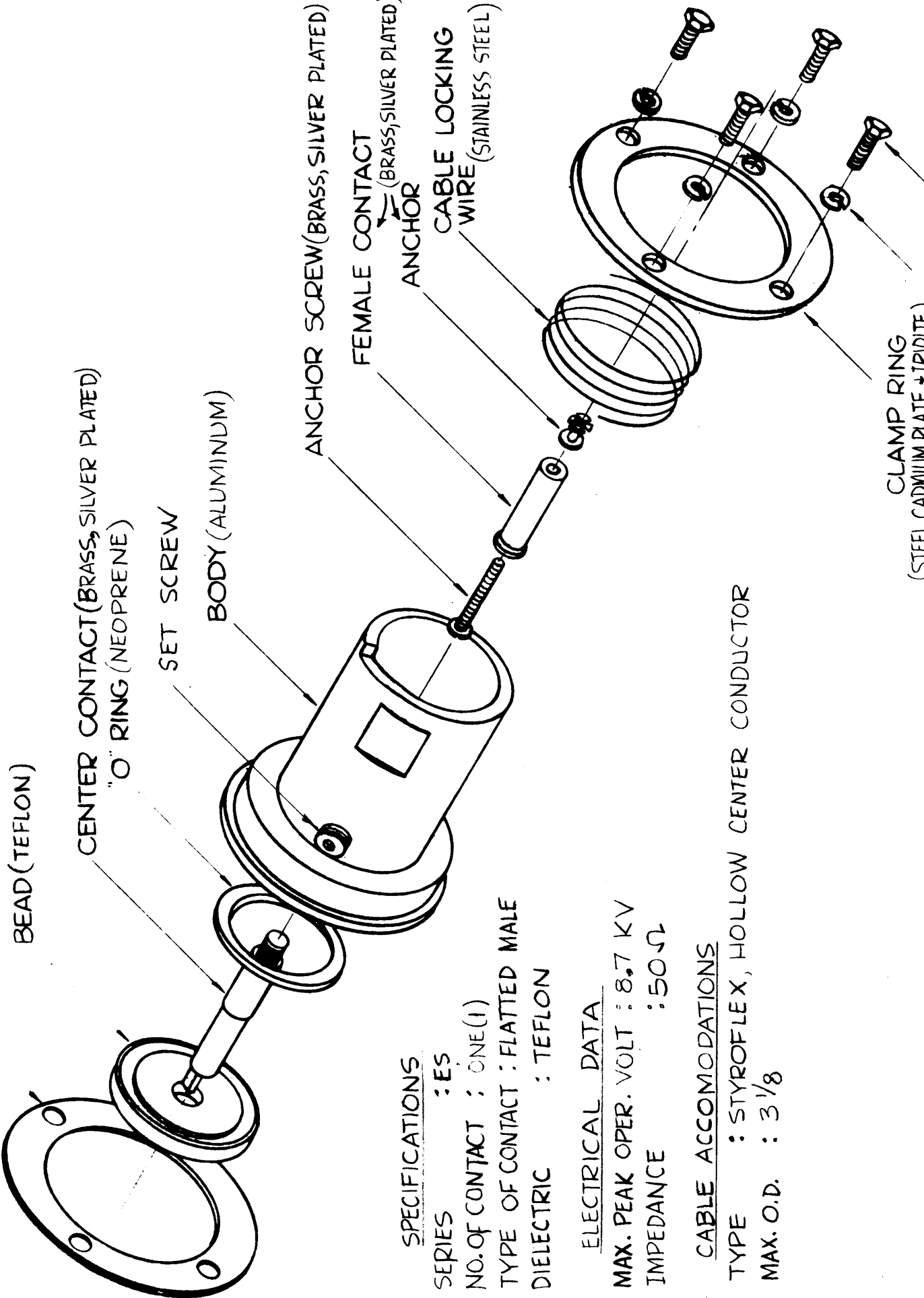
| | | | | | | |
|--|--|---------|-----------|---------|---------|-----------|
| SYM | DESCRIPTION | DATE | CH. NO. | DRAFTS | CHECKER | ENG. APP. |
| A | PART NO. WAS ES-W-51625, SERIES WAS ES-W | 9-5-62 | 7174 | 24 | JCB | JCB |
| UNLESS OTHERWISE SPECIFIED: | | | | | | |
| DIMENSIONS ARE IN INCHES | | | | | | |
| TOLERANCES ON | | | | | | |
| FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/8° | | | | | | |
| SCALE S-401-70 ± 9010 | | | | | | |
| MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REM VE ALL BURRS AND SHARP EDGES | | | | | | |
| REQ. PER UNIT | MODEL | SECTION | ABSY. NO. | DATE | | |
| | | | | 3-30-61 | | |

INSTALLATION INSTRUCTIONS BOX CONNECTOR

- Using a sharp tubing cutter, score cable 3" from end. Do not cut through aluminum jacket.
- Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
- Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
- Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
- Saw off center conductor 1/8" from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor being careful to keep chips out of cable.
- Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
- Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. Sleeve should slide freely over cable.
- Grease sleeve "O" ring with "O" grease, TMC GL-118 No. 4 Compound, and install in sleeve.
- Push on wire coil over jacket until coil is entirely in jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
- Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
- Screw center contact into female contact.
- Push bead over center contact with countersink facing outward. Grease with Dow Corning No. 4 Compound and mount "O" rings in place, and mount second bead over center contact. Push entire bead assembly down into sleeve counterbore.
- Bring up sleeve assembly to box and place gasket over tapped holes in box.
- Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

| | | | |
|-----------|----------|--|----------------|
| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
| | | THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
| | | BOX, CONNECTOR ASS'Y | |
| | | 3-1/8 STYROFLEX, 50.0, HOLLOW CENTER CONDUCTOR | |
| | | J.C. Biele | |
| | | DRAWN | FINAL APPROVAL |
| | | HECKER | |
| | | ES, ST-53125 | A |
| | | ELEC. DES. APP. MECH. DES. APP. | |

SUPPLIED BY TMC
GL-117 - LUBRICANT, THREAD
GL-118 - COMPOUND, SILICONE



SPECIFICATIONS

SERIES : ES
NO. OF CONTACT : ONE (1)
TYPE OF CONTACT : FLATTED MALE
DIELECTRIC : TEFLON

ELECTRICAL DATA

MAX. PEAK OPER. VOLT : 8.7 KV
IMPEDANCE : 50Ω

CABLE ACCOMMODATIONS

TYPE : STYROFLEX, HOLLOW CENTER CONDUCTOR
MAX. O.D. : 3 1/8

| | | | | | |
|------------|---------|---------|------|--|---------------|
| DATE | 8-30-62 | CH. NO. | 7169 | SCALE | S-401-70-9012 |
| DRAFTS | SC | CHECKER | YDe | MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES | |
| ENGR. APP. | | | | | |

| | | | | |
|--------------|-------|---------|------------|---------|
| RE. PER UNIT | MODEL | SECTION | ABSTY. NO. | DATE |
| | | | | 3-30-61 |

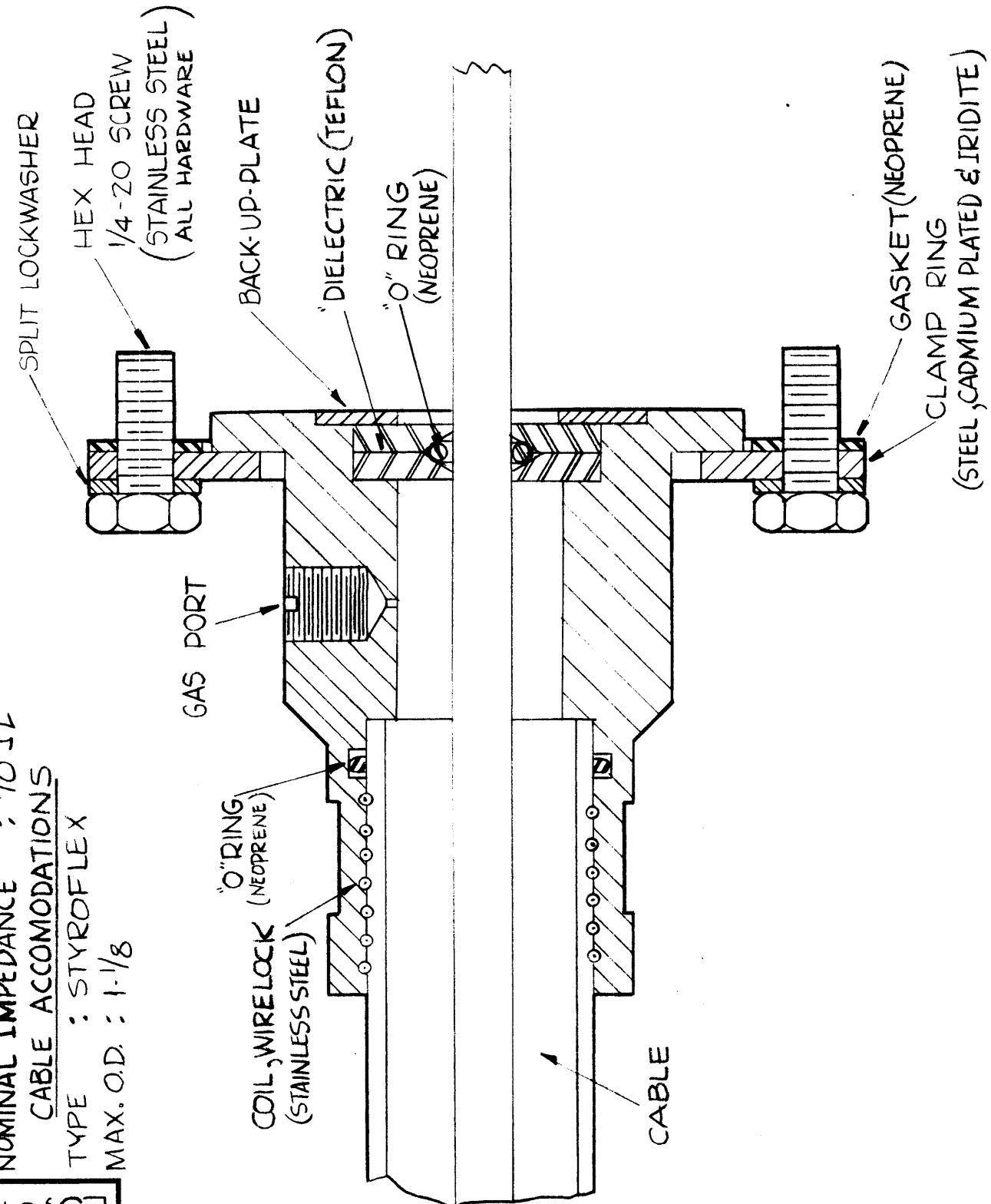
SPECIFICATIONS

SERIES : ES
 DIELECTRIC : TEFLON
 ELECTRICAL DATA
 MAX. PEAK OPER. VOLT. : 3.1 KV
 NOMINAL IMPEDANCE : 70 Ω
 CABLE ACCOMODATIONS
 TYPE : STYROFLEX
 MAX. O.D. : 1-1/8

INSTALLATION INSTRUCTIONS

- Using a sharp tubing cutter, score cable 1" to 2" from end. Do not cut through aluminum jacket.
- Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "0" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
- Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
- Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
- Cut off center conductor 2-1/2 inches from end of cable. Remove cut-off burr from center conductor. Take care not to allow chips to enter cable.
- Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. The sleeve should slide freely over cable.
- Grease sleeve "0" ring with "0" ring grease, GL-118, (No. 4 compound), and install in sleeve.
- Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound, (GL-117). Use the compound sparingly and wipe off any excess before starting sleeve on cable.
- Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
- Push bead over center conductor with countersink facing outward. Apply "0" ring grease, GL-118, (No. 4 compound), to small "0" ring and push it on center conductor. Push second bead on center conductor with countersink facing inward.
- Place back-up plate over center conductor and push toward sleeve so that beads and back-up plate seat in sleeve counterbores.
- Bring up sleeve assembly to box and place gasket over tapped holes in box.
- Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

NOTE: GL-118 (#4 compound) Supplied
 By
 GL-117 (Lubricant, Thread) TMC



| | | | |
|-----------|--------------------|--|-----------------------------------|
| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
| | | THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
| | STOCK SIZE | CONNECTOR, BOX, 1 1/8 STYROFLEX | |
| | MATERIAL | 70 OHM. | |
| | TYPE & TEMPER | DRAWN <i>J.P.S.</i> | CHECKER <i>[Signature]</i> |
| | HEAT TREAT. SPEC. | DATE <i>4-1-61</i> | FINAL APPROVAL <i>[Signature]</i> |
| | FINISH & SPEC. NO. | | ES, ST-71125 |
| | | | A |

| | | | |
|---------------|---------|-----------|------|
| REG. PER UNIT | SECTION | ABSY. NO. | DATE |
| | | | |
| USED ON | | | |

| | | | | | | |
|-----|---|--------|---------|--------|--------------------|--------------------|
| SYM | DESCRIPTION | DATE | CH. NO. | DRAFTS | CHECKER | ENG. APP. |
| A | PART NO. WAS ESW-71125, SERIES WAS ESIV | B30-67 | 7169 | 26 | <i>[Signature]</i> | <i>[Signature]</i> |

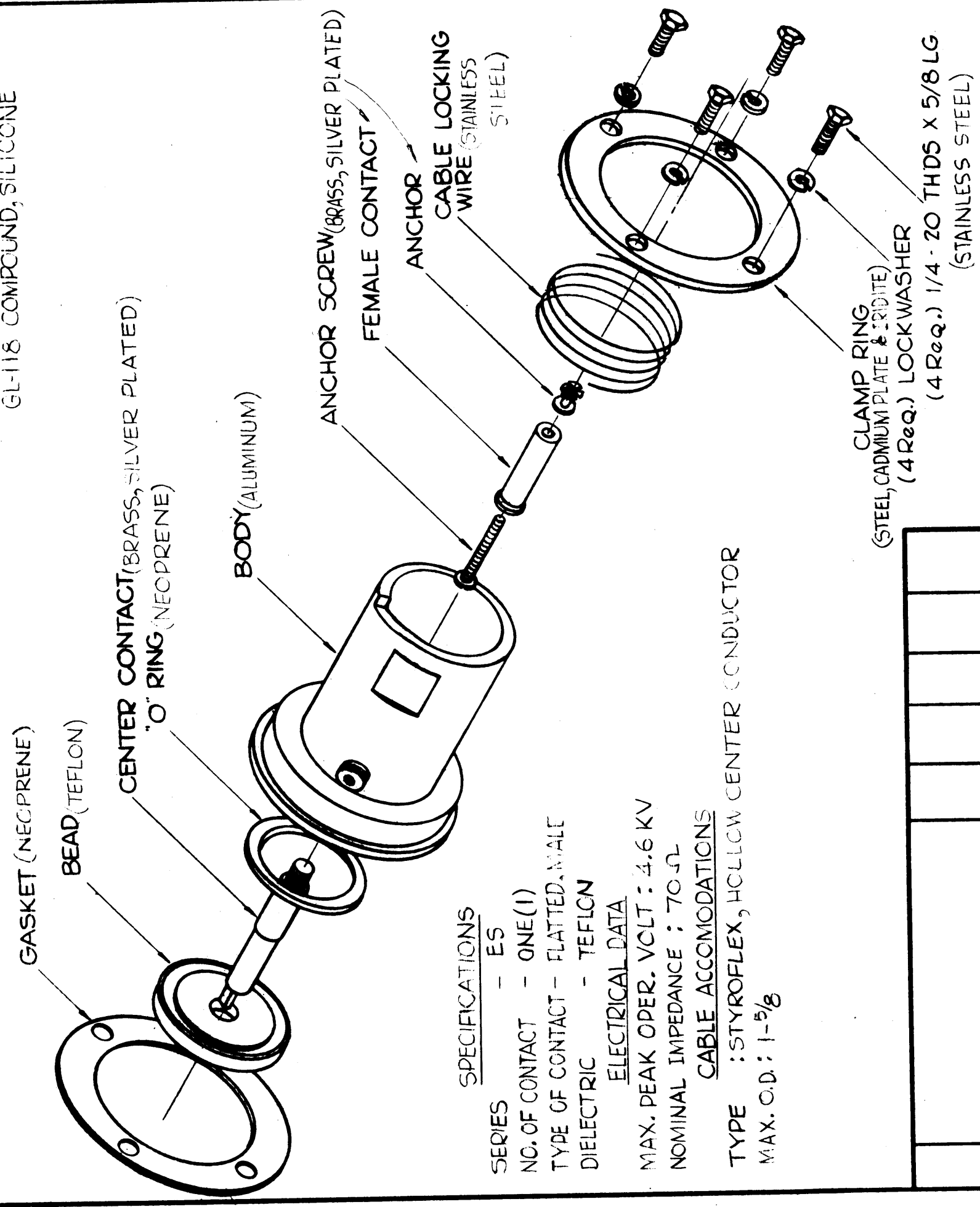
SCALE: S-401-70-9009
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .008 ANGLES ± 1/2°

INSTALLATION INSTRUCTIONS BOX CONNECTOR

1. Using a sharp tubing cutter, secure cable 3" from end. Do not cut through aluminum jacket.
2. Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in a shoe shine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
3. Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
4. Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
5. Saw off center conductor 1/8" from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor being careful to keep chips out of cable.
6. Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
7. Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. Sleeve should slide freely over cable.
8. Grease sleeve "O" ring with "O" grease, TMC-GL-118 No. 4 Compound, and install in sleeve.
9. Push on wire coil over jacket until coil is entirely in jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound TMC-GL-117. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
10. Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
11. Screw center contact into female contact.
12. Push bead over center contact with countersink facing outward. Grease with Dow Corning No. 4 Compound and mount "O" rings in place, and mount second bead over center contact. Push entire bead assembly down into sleeve counterbore.
13. Bring up sleeve assembly to box and place gasket over tapped holes in box.
14. Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

SUPPLIED BY TMC
GL-117 LUBRICANT THREAD
GL-118 COMPOUND, SILICONE



SPECIFICATIONS

SERIES - ES
 NO. OF CONTACT - ONE (1)
 TYPE OF CONTACT - FLATTED, MALE DIELECTRIC - TEFLON
 ELECTRICAL DATA
 MAX. PEAK OPER. VOLT : 4.6 KV
 NOMINAL IMPEDANCE : 70 Ω
 CABLE ACCOMMODATIONS
 TYPE : STYROFLEX, HOLLOW CENTER CONDUCTOR
 MAX. O.D. : 1-5/8

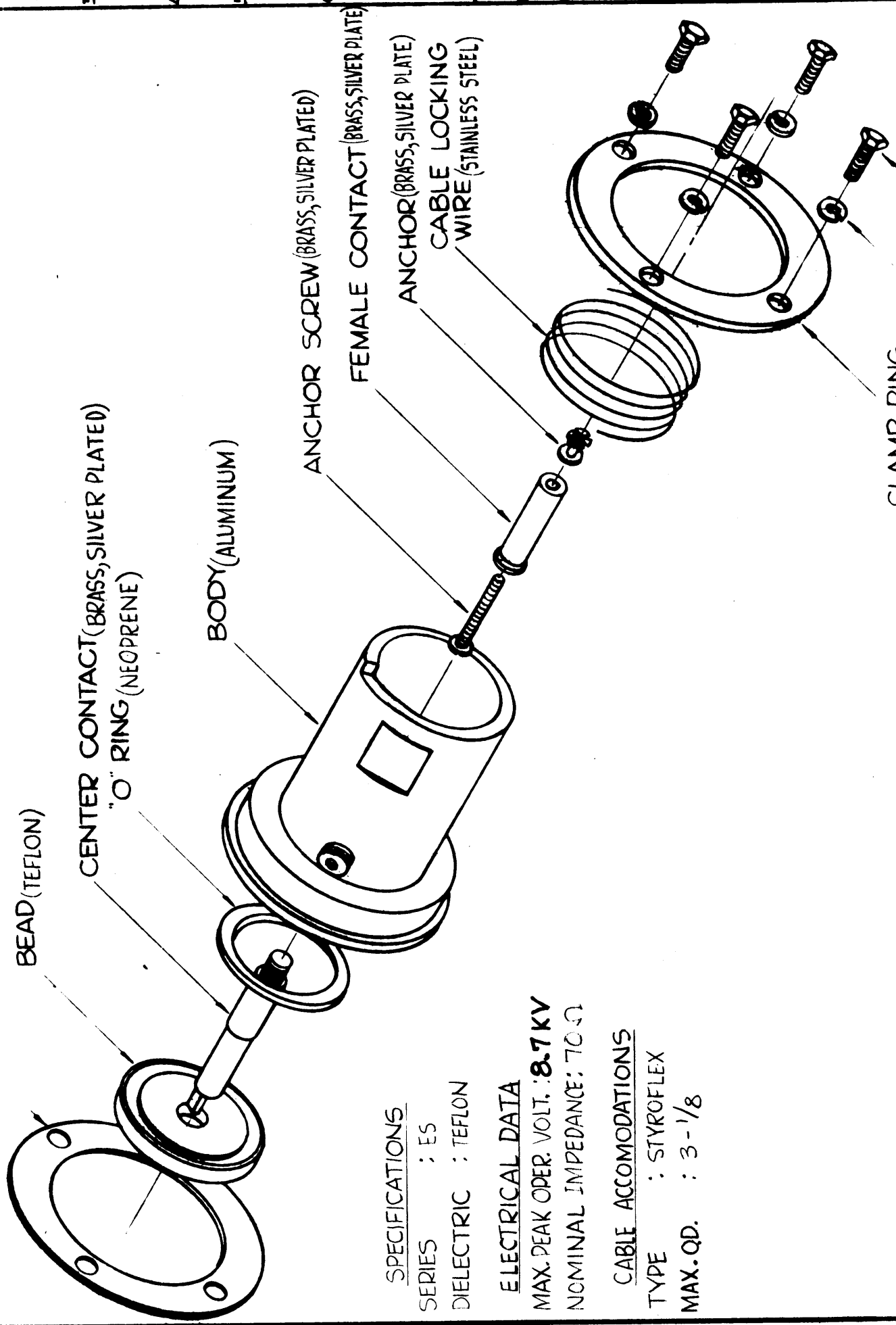
| | | | | | | |
|---|--|---------|---------|-------|---------|-----------|
| SYM | DESCRIPTION | DATE | CH. NO. | DRAWN | CHECKER | ENG. APP. |
| A | PART NO. WAS ESW-71625, SERIES WAS ESN | 8-30-61 | 58 | W.D. | W.D. | W.D. |
| SCALE: S-401-70-9011 | | | | | | |
| UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS 1/64 DECIMALS ±.008 ANGLES ± 1/2° MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES | | | | | | |

| | | | |
|--------------------|------|----------|--------|
| REQ. | ITEM | PART NO. | SYMBOL |
| | | | |
| STOCK SIZE | | | |
| MATERIAL | | | |
| TYPE & TEMPER | | | |
| HEAT TREAT. SPEC. | | | |
| FINISH & SPEC. NO. | | | |
| DRAWN | | | |
| CHECKER | | | |
| FINAL APPROVAL | | | |

| | | |
|--|--|---------------|
| DESCRIPTION | | SYMBOL |
| THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | | |
| BOX CONNECTOR ASS'Y | | |
| 1-5/8 STYROFLEX, 70Ω, HOLLOW CENTER CONDUCTOR | | |
| DRAWN | | J.C. Biele |
| CHECKER | | W.D. |
| FINAL APPROVAL | | W.D. |
| ELC. DES. APP. MECH. DES. APP. | | ES, J-71625 A |

INSTALLATION INSTRUCTIONS BOX CONNECTOR

SUPPLIED BY TMC
GL-117-LUBRICANT, THREAD
GL-118-COMPOUND, SILICONE



SPECIFICATIONS

SERIES : ES
DIELECTRIC : TEFLON

ELECTRICAL DATA

MAX. PEAK OPER. VOLT. : 8.7 KV
NOMINAL IMPEDANCE: 70 Ω

CABLE ACCOMMODATIONS

TYPE : STYROFLEX
MAX. QD. : 3 - 1/8

1. Using a sharp tubing cutter, score cable 3" from end. Do not cut through aluminum jacket.
2. Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connectors sets against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
3. Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
4. Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
5. Saw off center conductor 1/8" from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor being careful to keep chips out of cable.
6. Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
7. Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. Sleeve should slide freely over cable.
8. Grease sleeve "O" ring with "O" grease, TMC GL-118 No. 4 Compound, and install in sleeve.
9. Push on wire coil over jacket until coil is entirely in jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
10. Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
11. Screw center contact into female contact.
12. Push bead over center contact with countersink facing outward. Grease with Dow Corning No. 4 Compound and mount "O" rings in place, and mount second bead over center contact. Push entire bead assembly down into sleeve counterbore.
13. Bring up sleeve assembly to box and place gasket over tapped holes in box.
14. Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

| | | | |
|------------------|-------------------------------|--|---------------|
| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
| | | THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
| | STOCK SIZE | BOX, CONNECTOR ASS'Y | |
| | MATERIAL | 3 1/8 STYROFLEX, 70Ω, HOLLOW CENTER CONDUCTOR | |
| | TYPE & TEMPER. | J.C. Biele | |
| | HEAT TREAT. SPEC. | DRAWN | |
| | FINISH & SPEC. NO. | ESJ-73125 A | |

| | | | | |
|----------------------|--------------|----------------|------------------|-------------|
| REQ. PER UNIT | MODEL | SECTION | ASSY. NO. | DATE |
| | | | | 3-30-61 |

| | | | | |
|-------------|----------------|---------------|----------------|-------------------|
| DATE | CH. NO. | DRAFTS | CHECKER | ENCL. APP. |
| 8-30-62 | 7169 | SG | | |

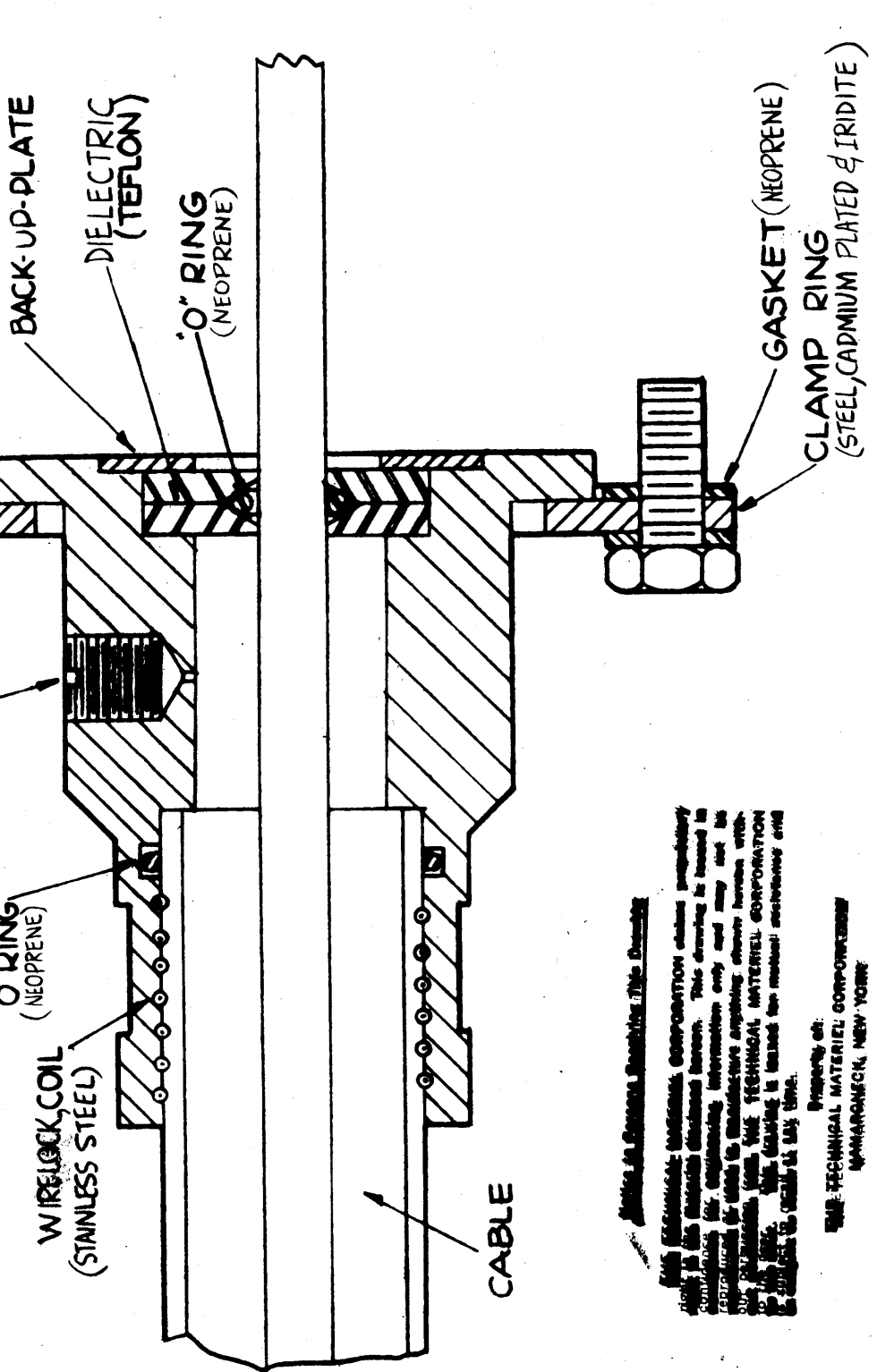
SCALE: S-401-70-9038

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
REMOVE ALL BURRS AND SHARP EDGES

SPECIFICATIONS

SERIES : ES,ST-7875
 No OF CONTACT : ONE (1)
 TYPE OF CONTACT : TEFLON
 DIELECTRIC : TEFLON
 ELECTRICAL DATA
 MAX. PEAK OPER. VOLT : 2.4 KV
 NOMINAL IMPEDANCE : 70Ω
 CABLE ACCOMODATIONS
 TYPE : STYROFLEX
 MAX. O.D. : 7/8



PLEASE READ THESE INSTRUCTIONS CAREFULLY
 THIS DRAWING IS THE PROPERTY OF THE TECHNICAL MATERIAL CORPORATION AND IS LOANED TO YOU FOR YOUR INFORMATION ONLY. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE TECHNICAL MATERIAL CORPORATION. THE DRAWING IS LOANED TO YOU FOR YOUR INFORMATION ONLY AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE TECHNICAL MATERIAL CORPORATION.

PROPERTY OF:
 THE TECHNICAL MATERIAL CORPORATION
 MAMARONECK, NEW YORK

INSTALLATION INSTRUCTIONS

- Using a sharp tubing cutter, score cable 1" to 2" from end. Do not cut through aluminum jacket.
- Using heavy cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The heavy cloth should be used in shoe shine fashion and all scratches and marks must be removed from jacket. The "0" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
- Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styroflex just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
- Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
- Cut off center conductor 2-1/4 inches from end of cable. Remove cut-off burr from center conductor. Take care not to allow chips to enter cable.
- Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. The sleeve should slide freely over cable.
- Grease sleeve "0" ring with "0" ring grease, GL-118, (No. 4 compound), and install in sleeve.
- Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound, (GL-117). Use the compound sparingly and wipe off any excess before starting sleeve on cable.
- Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
- Push bead over center conductor with countersink facing outward. Apply "0" ring grease, GL-118, (No. 4 compound), to small "0" ring and push it on center conductor. Push second bead on center conductor with countersink facing inward.
- Place back-up plate over center conductor and push toward sleeve so that beads and back-up plate seat in sleeve counterbores.
- Bring up sleeve assembly to box and place gasket over tapped holes in box.
- Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

NOTE: GL-118 (#4 compound) Supplied
 GL-117 (Lubricant, Thread) By TMC

| | | | |
|-----------|--------------------|--|-----------------------------|
| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
| | | THE TECHNICAL MATERIAL CORP. MAMARONECK, NEW YORK | |
| | STOCK SIZE | CONNECTOR, BOX, 7/8 STYROFLEX | |
| | MATERIAL | 70 OHM. | |
| | TYPE & TEMPER | DRAWN BY: [Signature] | FINAL APPROVAL: [Signature] |
| | HEAT TREAT. SPEC. | ES,ST-7875 | |
| | FINISH & SPEC. NO. | ELC. DES. APPROV. DES. APP. | |

| | | |
|---------------|------------|---------|
| REQ. UNIT | ABST. NO. | DATE |
| | | 4-1-61 |
| REQ. PER UNIT | SECTION | USED ON |
| | MODEL | |
| | RAC SERIES | |

| | | | | | | |
|-----|-------------------------------------|---------|----------|--------|-------------|-------------|
| SYM | DESCRIPTION | DATE | C.H. NO. | DRAFTS | CHECKER | ENG. APP. |
| A | PART NO. WAS ESN-787, SERIES HDSENS | 8-30-56 | 7169 | 56 | [Signature] | [Signature] |

SCALE: S-401-70 - 90.07
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .00 ANGLES ± 1/2°