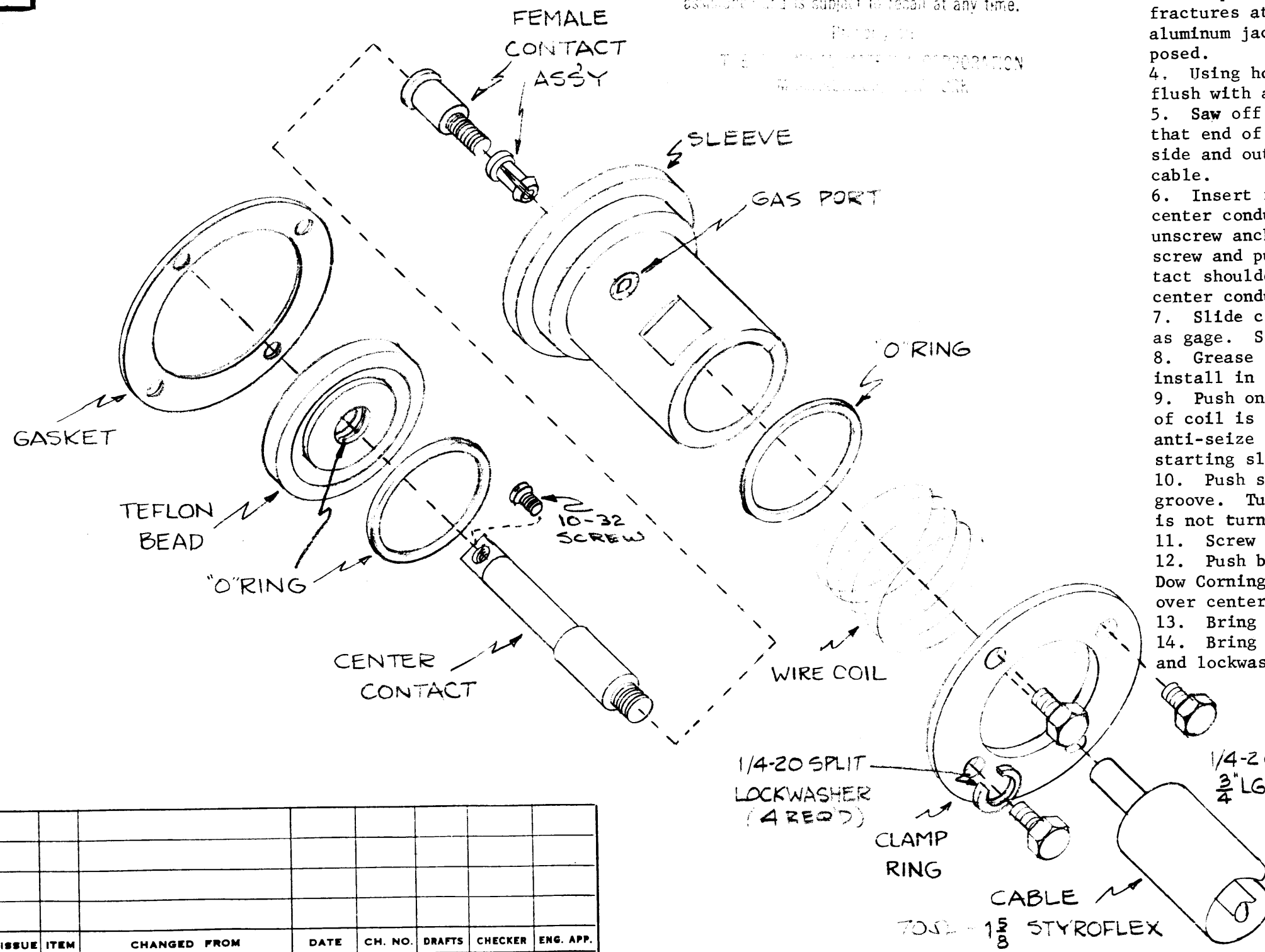


INSTALLATION INSTRUCTIONS

Refer to Accompanying Assembly Drawing.

- 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 .125 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" ring grease, Dow Corning 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. 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.

* SUPPLIED BY TMC
 GL-118 (DOW CORNING #4 COMPOUND)
 1/4-20 HEX HEAD GL-117 (LUBRICANT, THREAD)
 3/4" LG. (4 REQ'D)



TO PERSONS RECEIVING THIS DRAWING

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THE TECHNICAL MATERIEL CORPORATION
 1000 AVENUE OF THE STARS
 FORT LEE, N.J. 07024

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ. PER UNIT	ESW-71625	PROJECT NO.	ASSY. NO.	DATE
	MODEL			6-23-60
	USED ON			

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP.			
MAMARONECK, NEW YORK			
INSTALLATION ASSEMBLY			
ESW-71625			
MATERIAL:			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ID-239