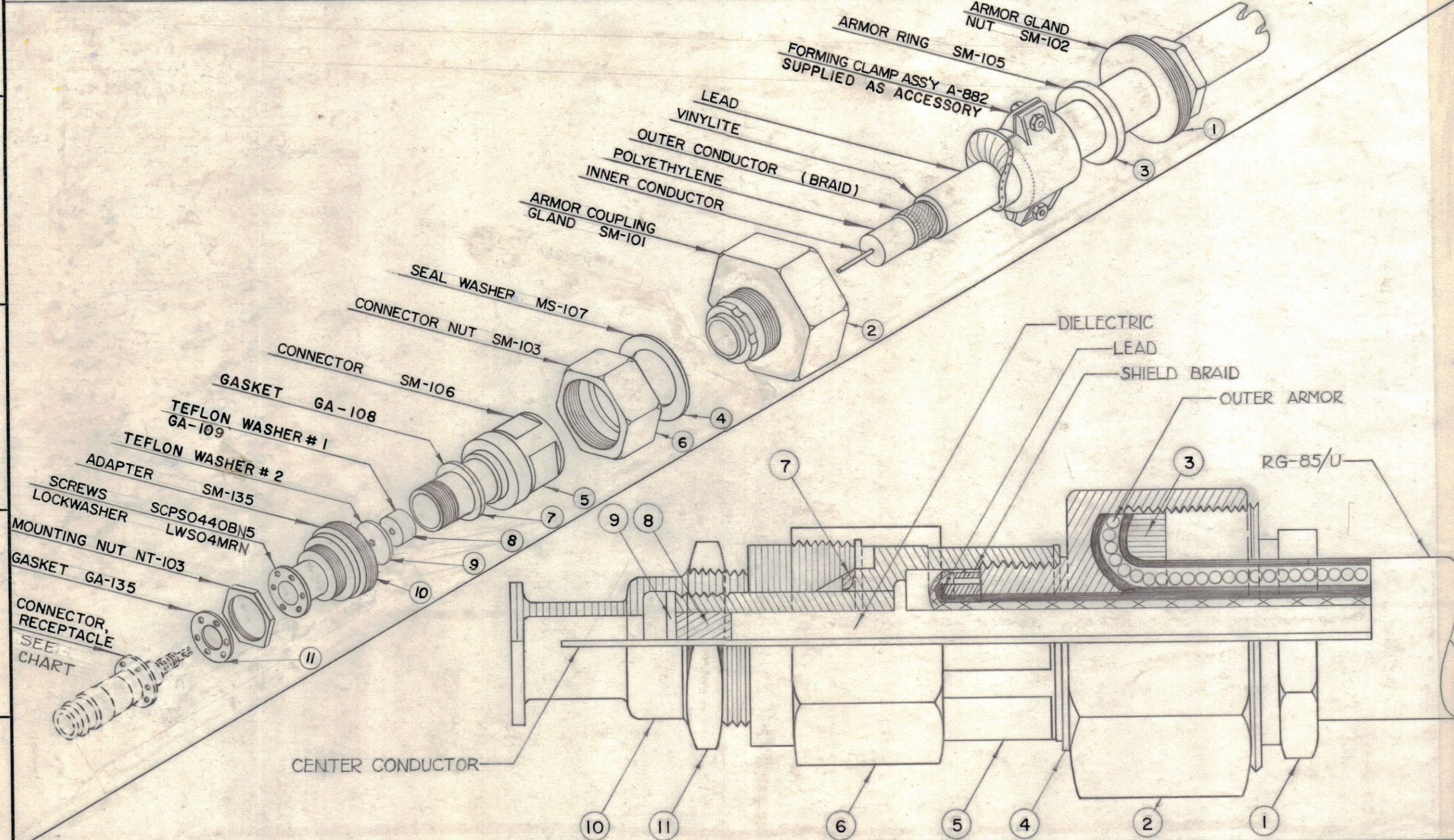
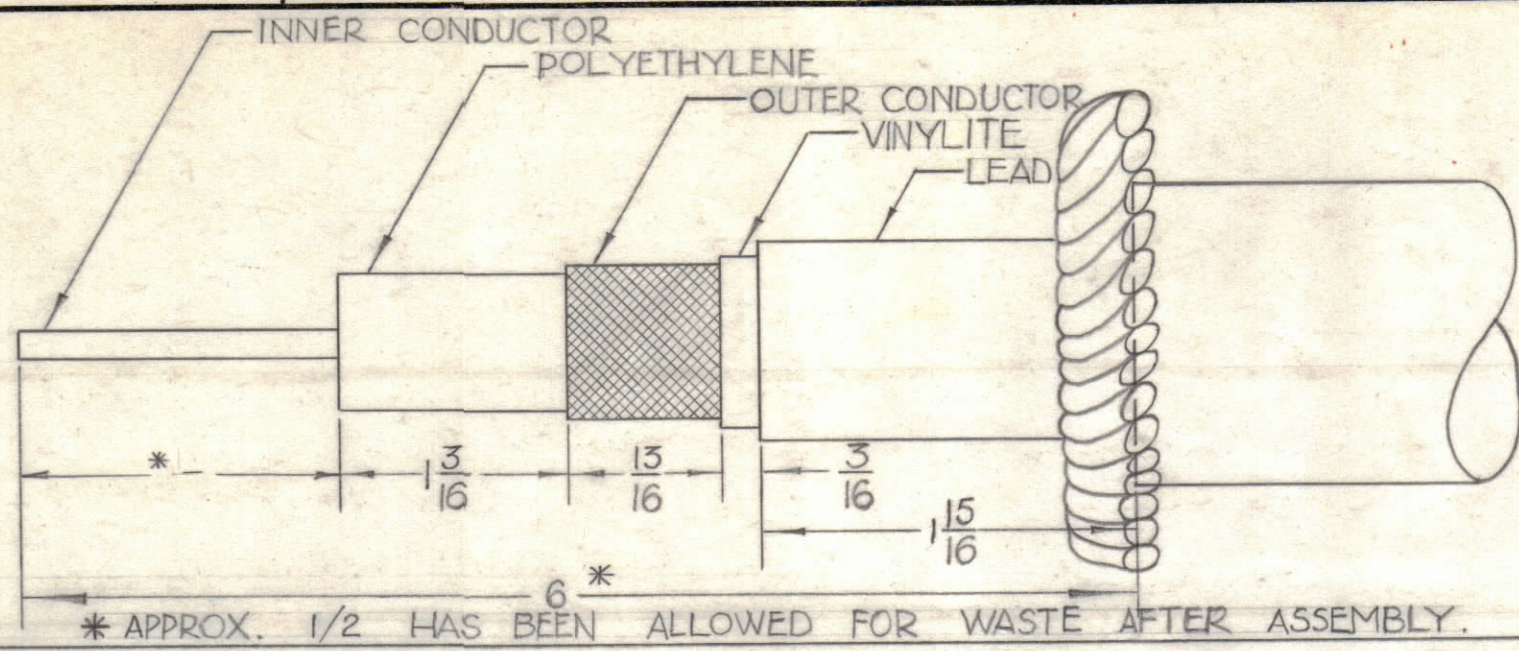


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MAMARONECK, NEW YORK

WIRE STRIPPING DETAIL



ASSEMBLING ADAPTOR; END SEAL TO RG85/U CABLE

OPERATION:

1. (a) PLACE ARMOR GLAND NUT OVER RG85/U CABLE.
- (b) PLACE ARMOR RING OVER RG85/U CABLE, TO A DISTANCE OF APPROXIMATELY 11 INCHES FROM THE END OF CABLE.
2. (a) CUT END OF CABLE SQUARE AND CLEAN.
- (b) CLAMP BOTH HALVES OF FORMING CLAMP, TMC PART A 882, AROUND OUTER ARMOR OF RG 85/U CABLE AT DISTANCE OF 7 INCHES FROM END OF CABLE.
- (c) BEND OUTER ARMOR TO FORM FLARE AS SHOWN ON DETAIL SKETCH.
- (d) AFTER FORMING FLARE INTO TRUE RADIUS OF 5/16" (INSIDE RADIUS) NIP OFF ARMOR WIRES.
- (e) GRIND OFF ALL ROUGH EDGES OF ARMOR WIRE FLARE TO A SMOOTH SURFACE, BEING CAREFUL TO MAINTAIN TRUE OUTSIDE DIAMETER OF APPROXIMATELY 1/32 OF AN INCH LESS THAN 2-5/8 INCHES IN DIAMETER.
- (f) REMOVE CLAMPS.
3. (a) ASSEMBLE ARMOR COUPLING GLAND ARMOR RING AND ARMOR GLAND NUT making sure assembly is tight, CUT OFF LEAD SHEATH 1/16" LONGER THAN ASSEMBLY AND SOLDER TO ARMOR COUPLING GLAND, ON THE FINISHED END SURFACE.
- (b) THE VINYLITE JACKET SHOULD EXTEND 3/16" BEYOND THE ABOVE GLAND AND LEAD SHEATH ASSEMBLY.
- (c) CUT COPPER BRAID 1" LONGER THAN COUPLING GLAND AND LEAD SHEATH.
- (d) DIVIDE COPPER BRAID INTO SIX (6) SECTIONS AFTER UNBRAIDING AND TWIST EACH SECTION INTO A PIG TAIL.
- (e) BEND BACK ALL SIX (6) PIG TAILS AND SOLDER TO COUPLING, GLAND INTO THE GROOVES PROVIDED FOR THIS PURPOSE.
- (f) PLACE SEAL WASHER OVER THREADS OF COUPLING GLAND.
- (g) PLACE CONNECTOR NUT OVER CONNECTOR.
4. (a) MEASURE OFF POLYETHYLENE AND TRIM OFF SUFFICIENTLY TO ALLOW GASKET TO PROJECT 1/16" FROM END OF CONNECTOR.
- (b) PLACE WASHER # 2 .
- (c) ASSEMBLE ADAPTOR.
- (d) ASSEMBLE GASKET AND CONNECTOR RECEPTACLE WITH SIX (6) SCREWS AND WASHERS.

NOTE 1 FOR END SEALS USE INSTRUCTIONS THREW 4a ONLY.

NOTE 2 IT IS RECOMMENDED THAT A SEALING COMPOUND SIMILAR TO DOW CORNING COMPOUND #4 OR GLYPTOL NO. 1202 BE USED FOR COATING THE THREADS IN ASSEMBLING THE FITTINGS AND ADAPTORS OF THE END SEALS.

MODEL	CONNECTOR RECEPTACLE
TCA-85/QDL	JJ-134
TCA-85/HN	JJ-207
TCA-85/LC	JJ-237
TCA-85/LT	JJ-270

SYM	ZONE	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	E7, B4, A1	SCPS0440BNS WAS SCPS0440BSS; ASSY DELETED LWS04MRN WAS LWS04MRS; CHART ADDED TITLE WAS: ASSY ADAPTOR; END SEAL; TO RG85/U CABLE	12-5-62	7767			

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°
SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS & SHARP EDGES

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
				1-24-1962

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
//	//	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
//	//	ASSEMBLY INSTRUCTIONS, TCA-85/TO RG-85 CABLE FOR QDL, HN, LC, & LT	
//	//	MATERIAL	
//	//	TYPE & TEMPER	
//	//	FINISH & SPEC. NO.	

DRAWN: J. Biele/K. Chu
 CHECKED: [Signature]
 FINAL APPROVAL: [Signature]
 ELEC. DES. APP. [Signature]
 MECH. DES. APP. [Signature]
 SHEET OF: ID-273 A
 DEFICIENCY NO. 1020 98892