

| REVISIONS | | | | | |
|-----------|-----|-------------|------|------------|------|
| ZONE | SYM | DESCRIPTION | DATE | E.M.N. NO. | APPD |
| | | | | | |

ASSEMBLING ADAPTOR TO RG-85/U CABLE

OPERATION:

- (a) PLACE ARMOR GLAND NUT OVER RG-85/U CABLE.

(b) PLACE ARMOR RING OVER RG-85/U CABLE, TO A DISTANCE OF APPROXIMATELY 11 INCHES FROM THE END OF CABLE.
- (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 9 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 $2-5/8 \pm 0^{+1/32}$.

(f) REMOVE CLAMPS.
- (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.

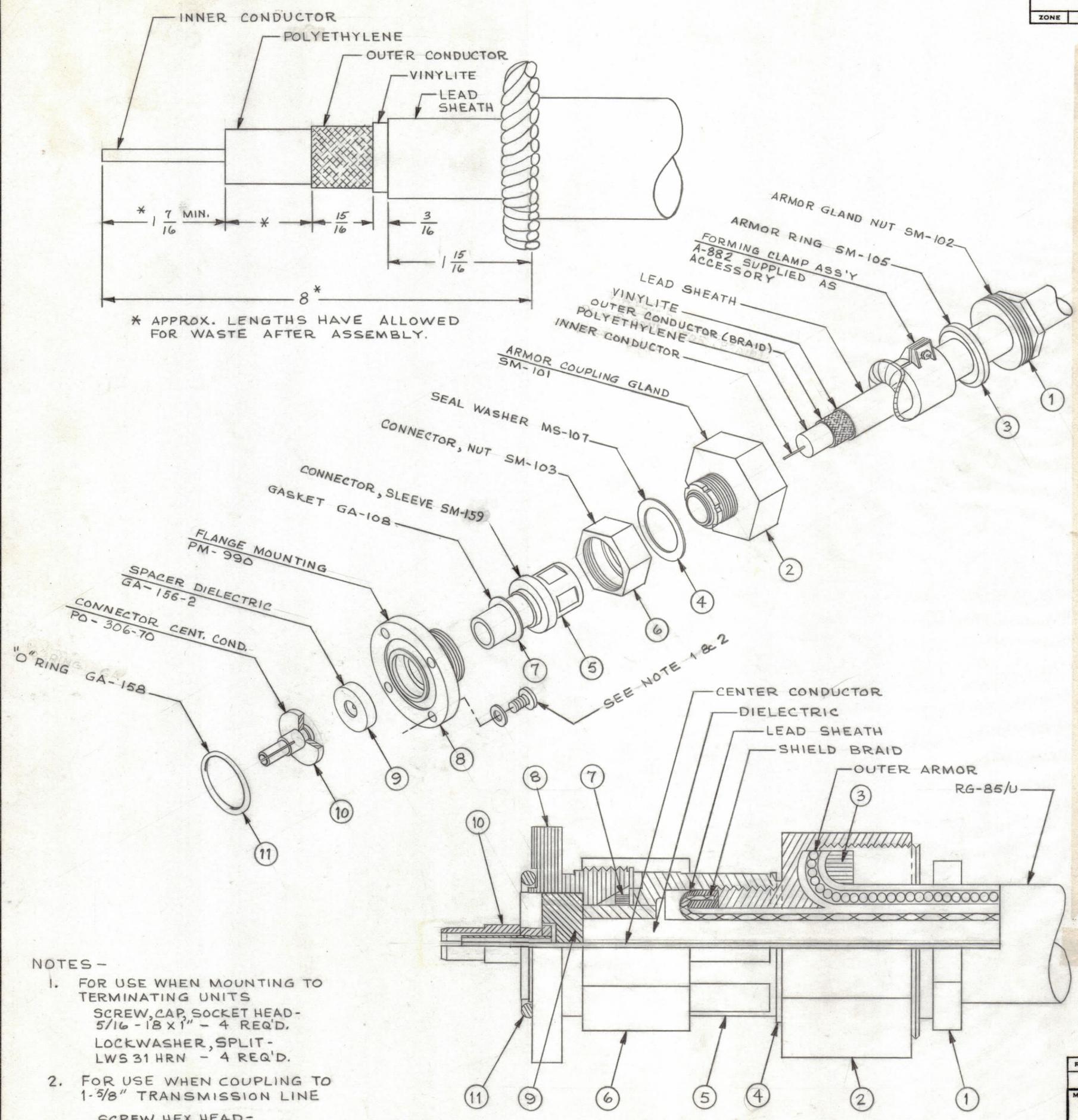
(e) BEND BACK ALL SIX (6) PIG TAILS AND SOLDER TO COUPLING GLAND IN THE GROOVES PROVIDED FOR THIS PURPOSE.

(f) PLACE SEAL WASHER OVER THREADS OF COUPLING GLAND.

(g) PLACE CONNECTOR NUT OVER CONNECTOR SLEEVE.
- (a) USING CONNECTOR SLEEVE AS GUIDE, CUT DIELECTRIC FLUSH, EXPOSING CENTER CONDUCTOR.

(b) CUT CENTER CONDUCTOR 1-7/16 FROM DIELECTRIC. USING FILE, ROUND OFF END OF CENTER CONDUCTOR.

(c) ASSEMBLE: FLANGE MOUNTING ADAPTER, DIELECTRIC SPACER, CENTER CONDUCTOR ADAPTER AND "O" RING WITH HARDWARE PROVIDED TO MATING UNIT.
- (a) MATING OF BOTH ASSEMBLIES MAY NOW BE ACCOMPLISHED BY SLIDING CENTER CONDUCTOR INTO HOLE OF DIELECTRIC AND TIGHTENING CONDUCTOR NUT.



- NOTES -
- FOR USE WHEN MOUNTING TO TERMINATING UNITS
SCREW, CAP, SOCKET HEAD - 5/16 - 18 x 1" - 4 REQ'D.
LOCKWASHER, SPLIT - LWS 31 HRN - 4 REQ'D.
 - FOR USE WHEN COUPLING TO 1-5/8" TRANSMISSION LINE
SCREW, HEX HEAD - SCHH 3118NR24 - 4 REQ'D
LOCKWASHER, SPLIT - LWS 31 HRN - 4 REQ'D
NUT, HEX - NTH 3118 HR 16 - 4 REQ'D

NOTES

| Q'TY./UNIT | MODEL USED ON | ASS'Y. NO. |
|------------|---------------|------------|
| SCALE # | CODE A | |

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| REQ'D. | ITEM | PART NUMBER | DESCRIPTION | SYMBOL |
|---|---|-----------------------------------|--|-----------|
| MARTINENGO LIST OF MATERIAL | | | | |
| MATERIAL | | | THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
| FINISH | | | TITLE ASSEMBLY INSTRUCTIONS, TCA-85/EIA - 71625 TO RG-85/U CABLE | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES | DRAWN M. TANTILLO | DATE 2-11-64 | FINAL APPROVAL <i>[Signature]</i> | DATE |
| DECIMALS .X ± .05 .XX ± .01 .XXX ± .005 | FRACTIONS ± 1/64 ANGLES ± 0° 30' | ELECT. DES. <i>[Signature]</i> | DATE 2-11-64 | REV. LTR. |
| TOLERANCES | | | ID-296 | |
| | | | SHEET | |

ID-296