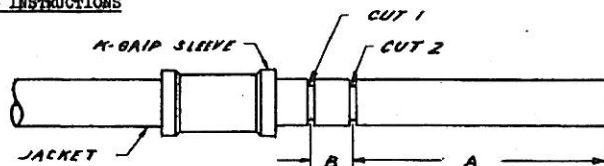


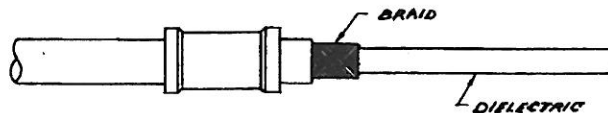
CABLING INSTRUCTIONS



1. CUT CABLE END SQUARE. SLIDE K-GRIP SLEEVE OVER JACKET AND WITH JACKET TRIM JIG MAKE CUTS 1 AND 2 IN JACKET.



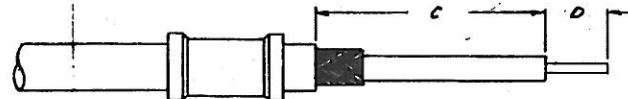
2. REMOVE JACKET TO A DIMENSION. FLARE OVER OR BULGE BACK BRAID AND TRIM WITH SCISSORS AT EDGE OF JACKET.



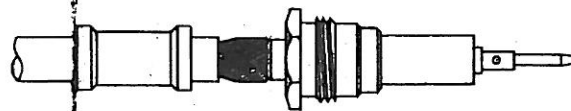
3. REMOVE JACKET TO B DIMENSION.

UNLESS OTHERWISE SPECIFIED:

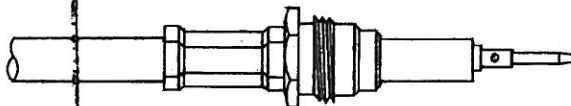
1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS $\pm .010$
3 PLACE DECIMALS $\pm .004$
T. I. R. CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.
2. REMOVE ALL BURRS, BREAK SHARP EDGES .005 MAX.
3. NO FILLETS PERMITTED.
4. SURFACE ROUGHNESS 63 MICROINCHES RMS MAX.
5. ALL DIMENSIONS PRIOR TO PLATING.



4. USING DIELECTRIC TRIM JIG, TRIM C DIM. EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO D DIMENSION.



5. PUSH K-GRIP ... OVER DIELECTRIC AND UNDER BRAID UNTIL DIELECTRIC BOTTOMS IN K-GRIP ASSEMBLY.



6. SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON K-GRIP BODY AND FORM HEX. CRIMP CONTACT IS READY TO BE CRIMPED OR SOLDERED TO CENTER CONDUCTOR. CRIMP OR SOLDER THE CONTACT AND THREAD K-GRIP ASSEMBLY INTO BODY ASSEMBLY.

REVISIONS

ISSUE	CHANGES
1	CN 15275A MJB 6 JAN 78

V-59-39-12

REP:	
FINISH	
SPEC.	
MATL.	
SPEC.	

CABLING INSTRUCTIONS

DRAWN P.C.	DATE 13 MAY 70
APPR. MS	DATE 13 NOV 70

KINGS ELECTRONICS
40 MARLBOROUGH ROAD
TUCKAHOE, N. Y. 10707

ITEM	REQ'D	DESCRIPTION	DRAWING NO.
			V-59-39-12

SHEET 1 OF 2

V-59-59-12