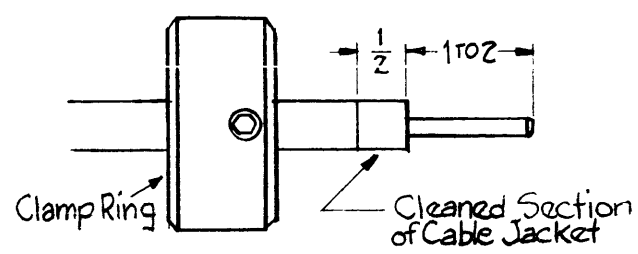
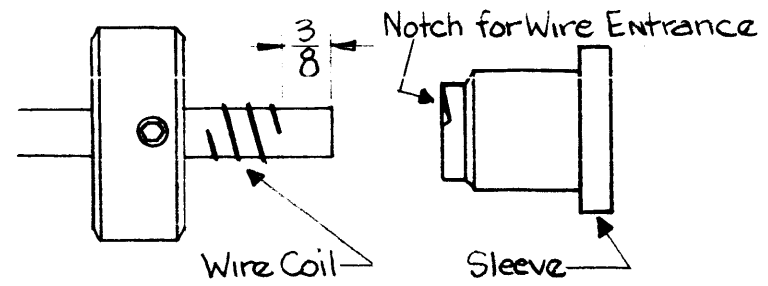


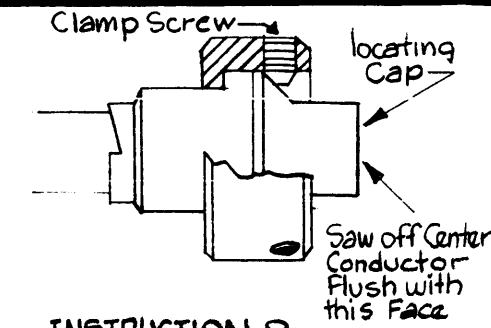
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INSTRUCTIONS 1 THRU 5



INSTRUCTIONS 6 THRU 8



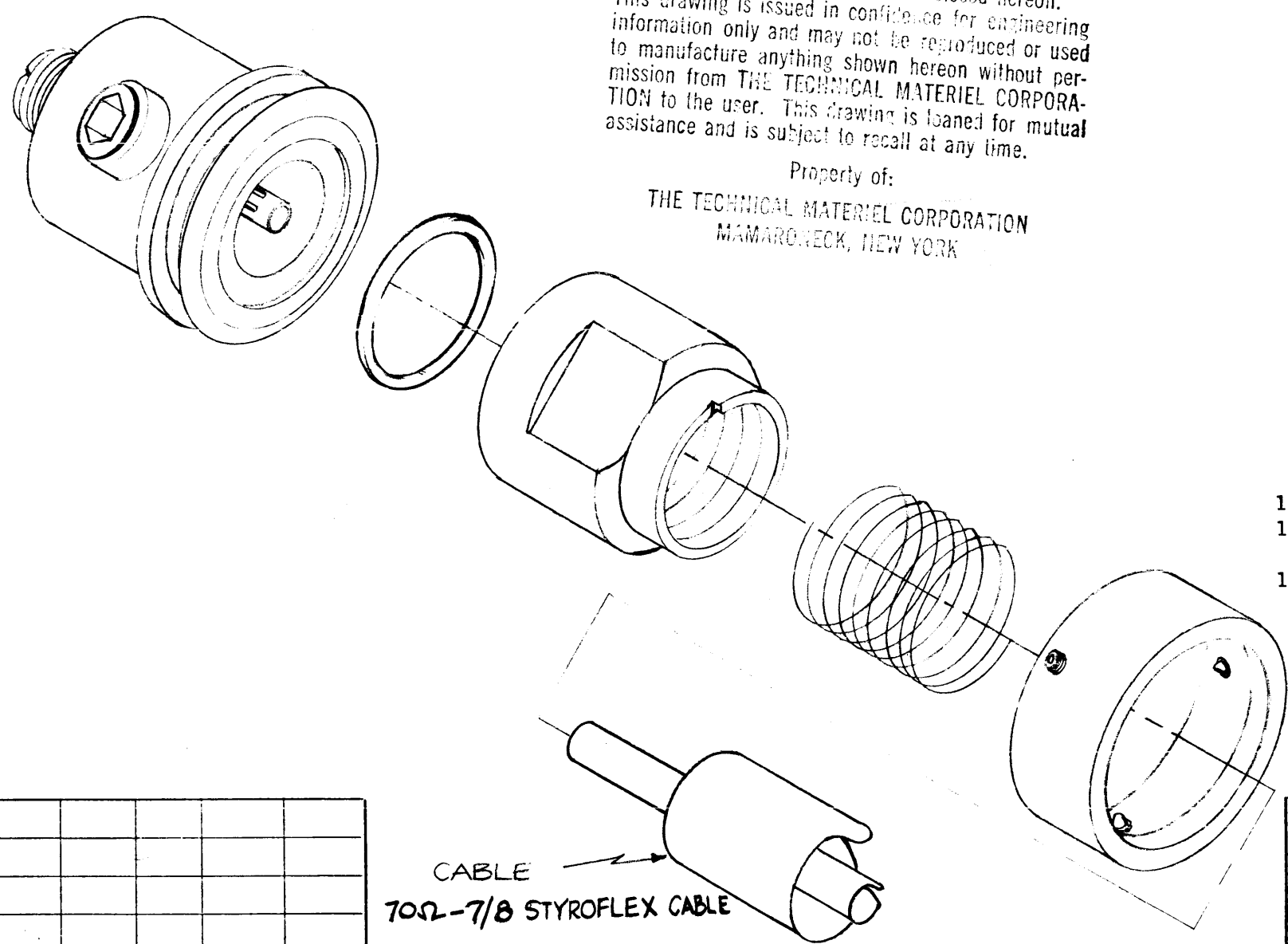
INSTRUCTION 9

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 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.
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. Remove burr from center conductor.
5. Slide clamp ring over cable with counterbore facing end of cable.
6. Check roundness and size of cable using sleeve as gage. The sleeve should slide freely over cable.
7. 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.
8. 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 it is completely on cable and cable end projects approximately 1/16" from flange end of sleeve.
9. Bring up locating cap over center conductor and clamp to sleeve with clamp ring. This is used as an installation jig to assure correct placement of sleeve on cable and to cut center conductor to proper length. Put wrench on sleeve and turn entire assembly approximately 1 turn until end of cable jacket bottoms in locating cap counterbore. Saw off center conductor flush with end of locating cap.
10. Remove locating cap and remove burr from center conductor.
11. Grease O ring with O ring grease (Dow Corning 4 Compound) and mount over cable end in sleeve counterbore.
12. Bring up connector body, making certain that center conductor enters center contact. Complete assembly by tightening the three clamp screws.

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MAMARONECK, NEW YORK



CABLE
702-7/8 STYROFLEX CABLE

* SUPPLIED BY TMC
GL-118 - (DOW CORNING #4 COMPOUND)
GL-117 - (LUBRICANT, THREAD)

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.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
	BSA-ESW 787/UHF			5-24-60
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
MATERIAL			
INSTALLATION ASSEMBLY MODEL BSA-ESW 787/UHF			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		FINAL APPROVAL	
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

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