

# Field Engineering Bulletin

<b>TITLE</b> Assembly Instructions. Cable to QDS plugs.	<b>BULLETIN NUMBER</b>	1
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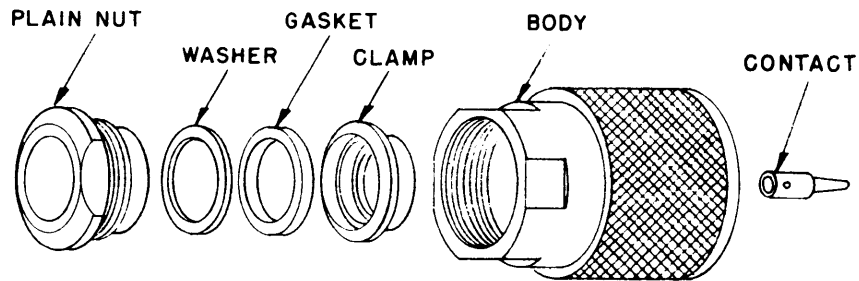


FIGURE 1

1. Disassemble plug. Lay it out as shown in Figure 1.
2. Remove 1/2 inch of cable outer jacket as shown in Figure 2. Be extremely careful not to nick braid.

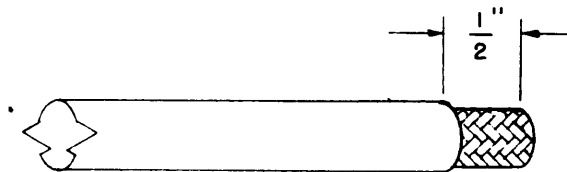


FIGURE 2

3. Slide PLAIN NUT, WASHER, GASKET and BRAID CLAMP over cable as shown in Figure 3. (Note that V groove of GASKET must face toward BRAID CLAMP.)
4. Comb out the braid. Bent it back as shown in Figure 3. Strip all but 3/32 inch of inner dielectric. DO NOT SCRATCH OR NICK the inner conductor.

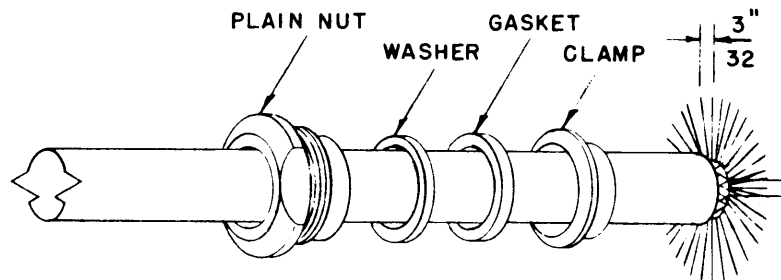


FIGURE 3

5. Slide BRAID CLAMP forward until it is flush with end of outer jacket. Bend braid back smoothly over BRAID CLAMP. Trim off excess braid. See Figure 4.
6. Cut inner conductor to 3/16 inch. Slip CONTACT over conductor until it butts against dielectric. Solder in place. AVOID USE OF EXCESSIVE HEAT.

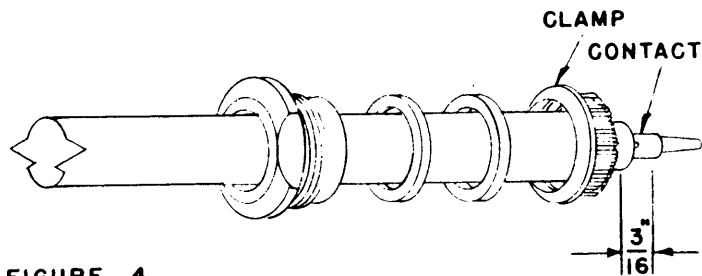


FIGURE 4

7. Push assembly as far as it will go into BODY. Slide GASKET, WASHER, and PLAIN NUT into body.
8. Holding cable and BODY rigid, tighten PLAIN NUT securely with wrench. See Figure 5.

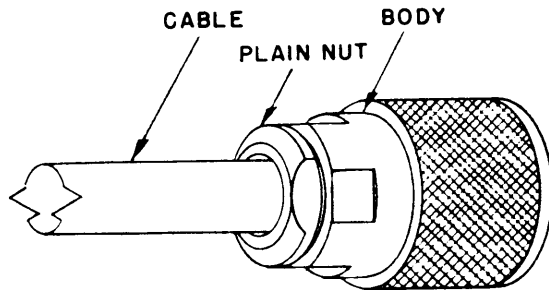


FIGURE 5

FOLLOWING DIRECTIONS ARE FOR USE WITH ARMOR CABLE.

ARMOR NUT replaces PLAIN NUT. ARMOR CAP is added.  
Both must be slipped over cable before WASHER.

Proceed as in steps 2 through 7 above.

8. Bring ARMOR NUT forward to BODY. Slide armor back of ARMOR NUT. Tighten ARMOR NUT to BODY. Comb out and fan armor shield over ARMOR NUT as shown in Figure 6. Cut away excess.
9. Bring ARMOR NUT CAP forward. Holding ARMOR NUT securely with wrench, tighten ARMOR NUT CAP.

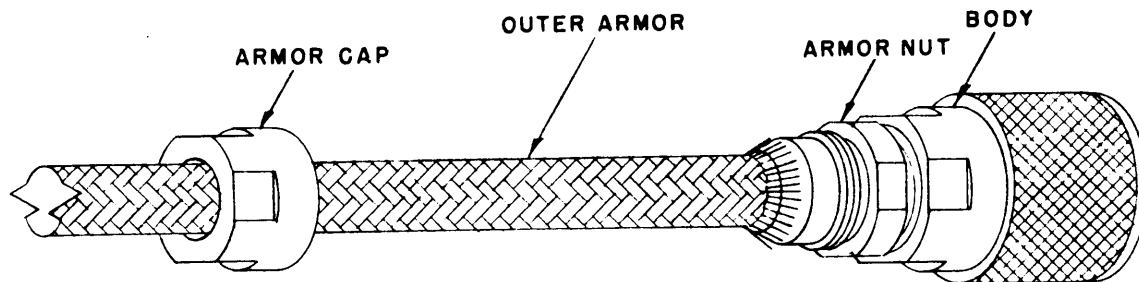


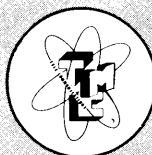
FIGURE 6

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