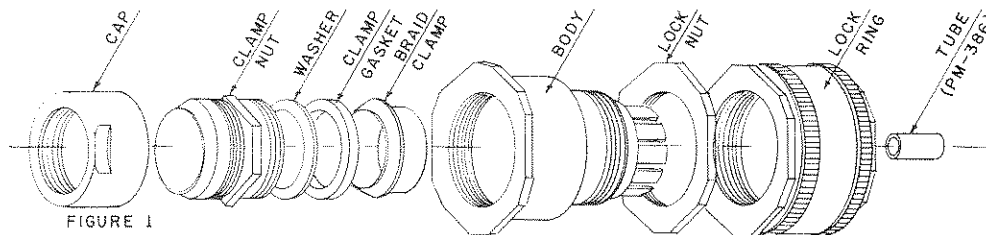


SALES SERVICE INFORMATION

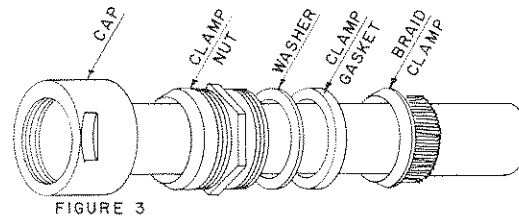
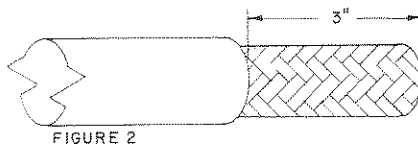
The Technical Materiel Corporation
Mamaroneck New York

BULLETIN NUMBER 24

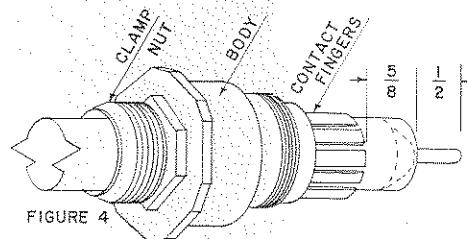
Assembly Instructions. Cable to QDL plugs.



1. Disassemble plug. Lay it out as shown in Figure 1.



2. Remove approximately 3 inches of cable outer jacket as shown in Figure 2. Be extremely careful not to nick braid.
3. Slide CAP, CLAMP NUT, WASHER and CLAMP GASKET over cable as shown in Figure 3. Note that V groove of CLAMP GASKET must face toward BRAID CLAMP.
4. Slide BRAID CLAMP over braid so that internal shoulder of BRAID CLAMP butts against end of cable outer jacket. (See Figure 3)
5. With BRAID CLAMP held in place, comb out braid. Fold braid back smoothly over BRAID CLAMP. Trim off excess braid. (See Figure 3)
6. Slide BODY carefully over CLAMP NUT. Tighten CLAMP NUT. (Hold BODY rigid, rotate CLAMP NUT).



7. Measuring from CONTACT FINGERS, leave $\frac{5}{8}$ inches of dielectric. Remove balance of dielectric with sharp, heated knife so that conductor is exposed. Cut conductor, if necessary, to $\frac{1}{2}$ inch as shown in Figure 4. DO NOT SCRATCH OR NICK CONDUCTOR.

8. Using TMC tool TP-106, taper dielectric as shown by dotted lines. At finish of operation tool must butt against CONTACT FINGERS to assure proper shape and length of taper. (See Figure 4)

NOTE:

When TUBE PM-386 is not required, round off end of conductor to smooth, full radius. (See Figure 4)

When TUBE PM-386 is required, slide it over conductor so that it butts against dielectric. Solder it securely in place. Round off end of TUBE and conductor to smooth, full radius.

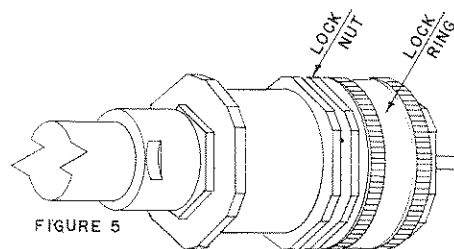
REMOVE ALL EXCESS SOLDER AND OTHER FOREIGN PARTICLES FROM CONDUCTOR AND PLUG

RG-17/U, RG-18/U

TUBE PM-386 not required.

RG-35/U, RG-85/U, RG-164/U

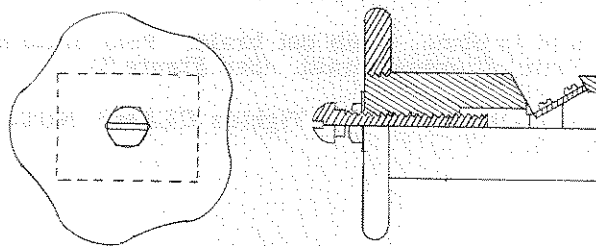
TUBE PM-386 required.



9. Tighten CAP securely to CLAMP NUT. Hand tighten LOCK NUT and LOCKING RING on BODY as shown in Figure 5.

ACCESSORY EQUIPMENT

TAPERING TOOL (TMC No. TP-106) Use to taper cable.



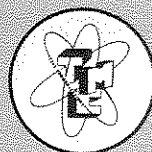
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