

ASSEMBLING ADAPTOR; END SEAL TO RG85/U CABLE

OPERATION:

1. (a) PLACE ARMOR GLAND NUT OVER RG85/U CABLE.
- (b) PLACE ARMOR RING OVER RG85/U CABLE, TO A DISTANCE OF APPROXIMATELY 11 INCHES FROM THE END OF CABLE.
2. (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 7 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 1/32 OF AN INCH LESS THAN 2-5/8 INCHES IN DIAMETER.
- (f) REMOVE CLAMPS.
3. (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 INTO THE GROOVES PROVIDED FOR THIS PURPOSE.
- (f) PLACE SEAL WASHER OVER THREADS OF COUPLING GLAND.
- (g) PLACE CONNECTOR NUT OVER CONNECTOR.
4. (a) MEASURE OFF POLYETHYLENE AND TRIM OFF SUFFICIENTLY TO ALLOW GASKET TO PROJECT 1/16" FROM END OF CONNECTOR.
- (b) PLACE WASHER # 2 .
- (c) ASSEMBLE ADAPTOR.
- (d) ASSEMBLE GASKET AND CONNECTOR RECEPTACLE WITH SIX (6) SCREWS AND WASHERS.

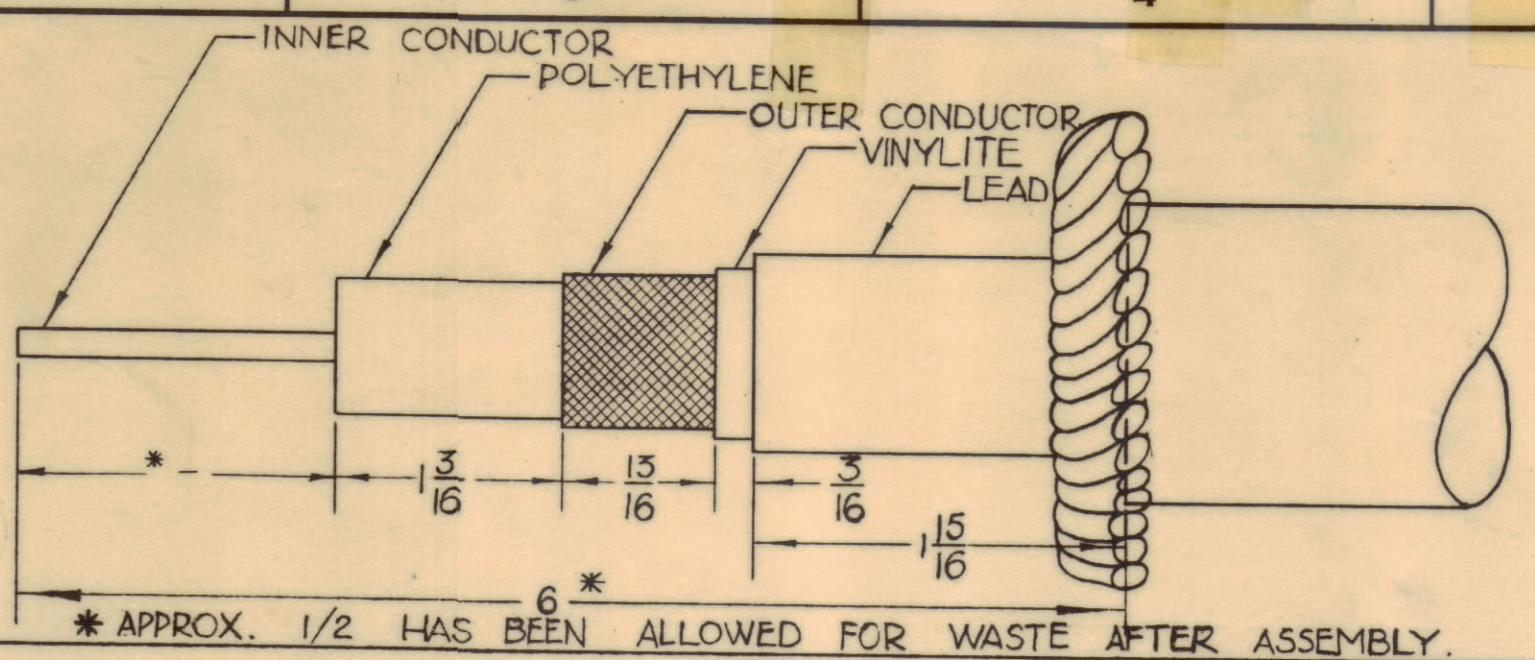
NOTE 1 FOR END SEALS USE INSTRUCTIONS THREW 4a ONLY.

NOTE 2 IT IS RECOMMENDED THAT A SEALING COMPOUND SIMILAR TO DOW CORNING COMPOUND #4 OR GLYPTOL NO. 1202 BE USED FOR COATING THE THREADS IN ASSEMBLING THE FITTINGS AND ADAPTORS OF THE END SEALS.

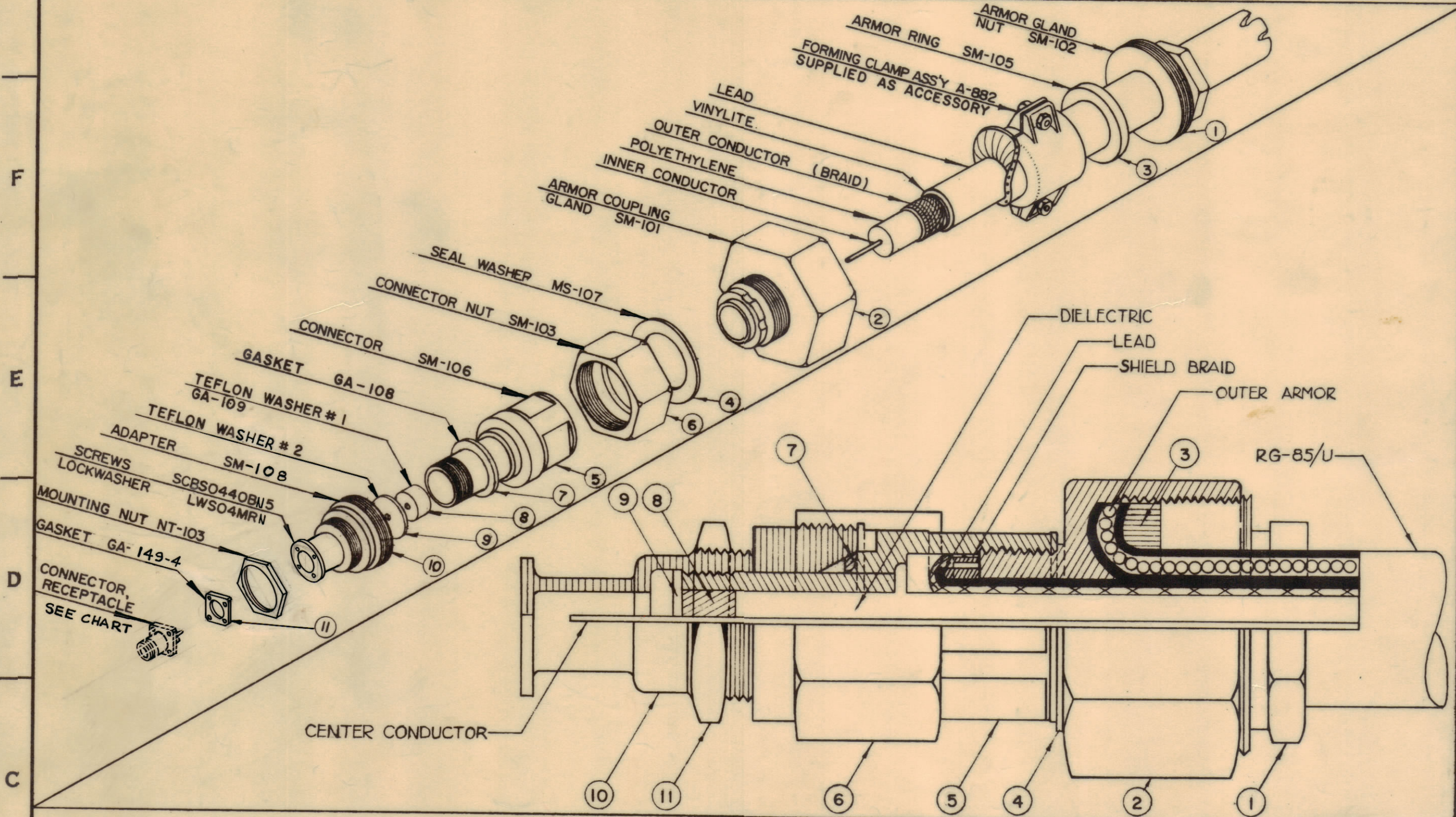
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MAMARONECK, NEW YORK



WIRE STRIPPING DETAIL



MODEL	CONNECTOR RECEPTACLE	IMPEDANCE
TCA-85/QDS	JJ-151	50
TCA-85/UHF	JJ-268	50
TCA-85/N(70)	JJ-190	70
TCA-85/C.	JJ-269	50
TCA-85/N(50)	JJ-282	50
TCA85/BNC(50)	JJ-318	50
TCA85/BNC(70)	JJ-338	70

SYM	ZONE	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B		MODEL CHT. REVISED ADD JJ318&JJ338	8/31/72	20854	GE	CL	CL
A	B4.5	ON MODEL CHART; TCA-85/N(70) WAS TCA-85/N(50) ADDED.	2-17-65	13548	ef.	JCB	NMA

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°
SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS & SHARP EDGES

REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
	#	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	#	ASSEMBLY INSTRUCTIONS, TCA-85/TO RG-85 CABLE FOR QDS, UHF, N, C AND BNC	
	#	M. TANTILLO	
	#	DRAWN	
	#	CHECKED	
	#	FINAL APPROVAL	
	#	TYPE & TEMPER	
	#	HEAT TREAT. SPEC.	
	#	FINISH & SPEC. NO.	
	#	ELEC. DES. APP.	
	#	MECH. DES. APP.	
	#	SHEET OF	