

LTR	ISSUE NO.	CH'D	DATE	APP'D
I				
A	58212-4	A.K.	10-23-64	
B	58535-530	J.M.	6-22-71	(S)
C	ADD ALTERNATE ASSY. REC 035794	R.M.	8-24-88	DR

SPECIFICATION

9-9950-174

CHANGE

✓

ASSEMBLY

CODE IDENT. NO. 77820

(DES 174)

SHEET 1 OF 4

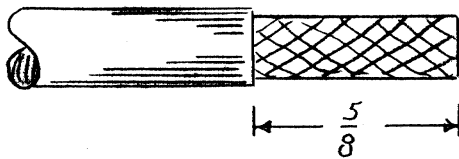
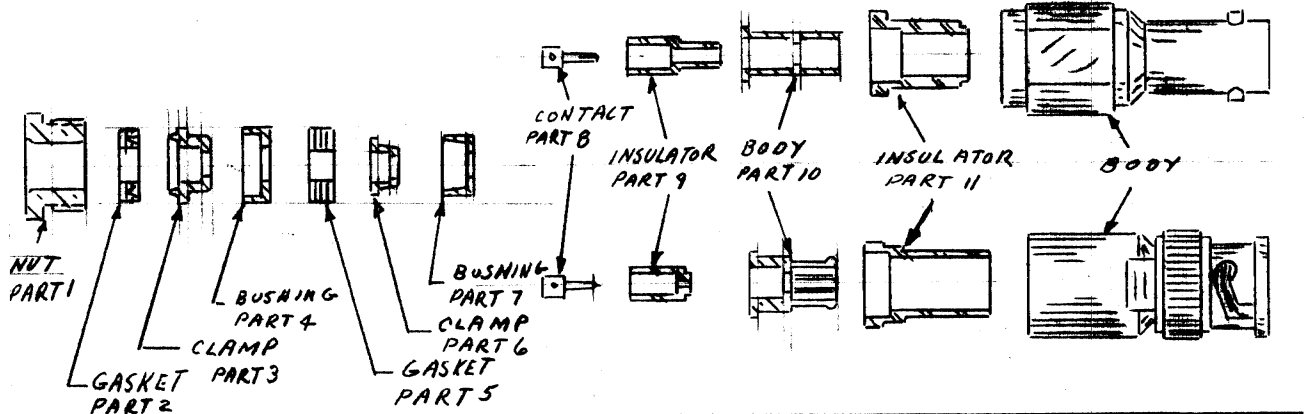
Electrical Components Division

The Bendix Corporation

Sidney, New York

ASSEMBLY INSTRUCTIONS FOR TRIAX CABLE

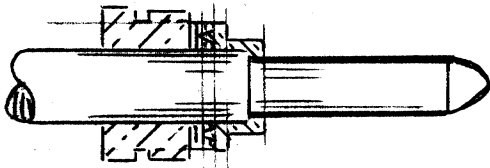
NOTE: FOR ALTERNATE ASSY. INST. SEE SHT # 4



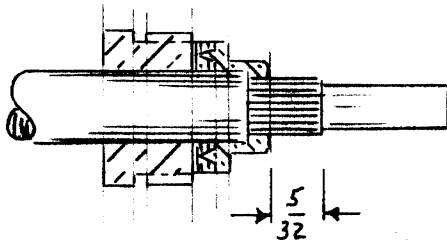
1. Cut off end of cable square and remove jacket to dim. shown. Do not nick braid.



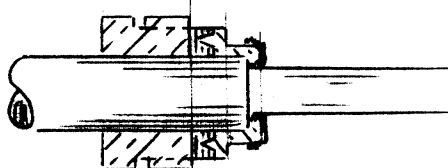
2. Comb out braid.



3. Taper braid, slide nut, gasket, and clamp over tapered braid making sure inner shoulder of clamp is positioned tightly against end of jacket.



4. Trim braid to dim. shown.



5. Flare back braid over clamp.

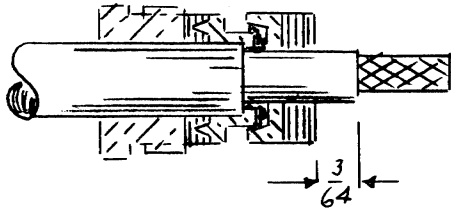
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COMP'D C.A. Loney

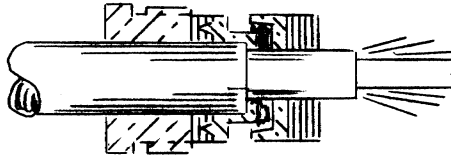
CK'D

APP'D

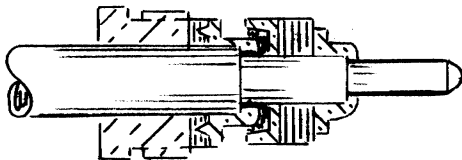
APP'D



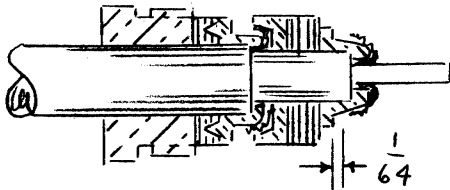
6. Place part (4) and part (5) in position shown. Remove inner jacket to dim. shown.



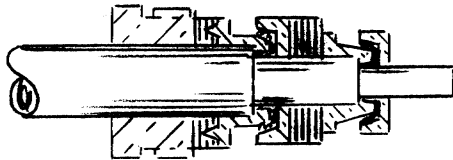
7. Comb out inner braid.



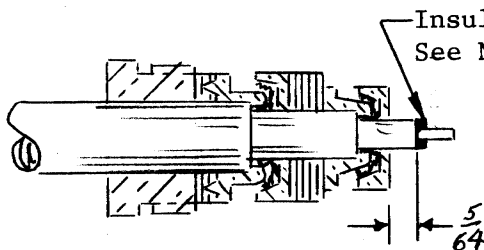
8. Taper braid, slide clamp part (6) over tapered inner braid making sure inner shoulder of clamp is positioned tightly against end of inner jacket.



9. Fold back inner braid over clamp and trim inner braid to dim. shown.

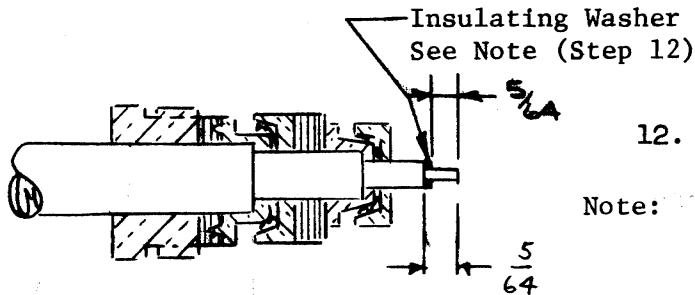


10. Place small bushing part (7) in position shown. Push firmly against braid.



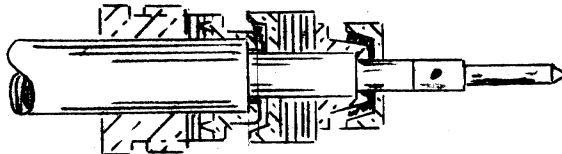
11. Trim dielectric to dim. shown. Do not nick inner conductor.

NOTE: For assemblies 00-8354-4, 00-8354-5, 00-8470-2 and 00-8470-3 only, trim to 1/16 in lieu of 5/64, then assemble insulating washer.

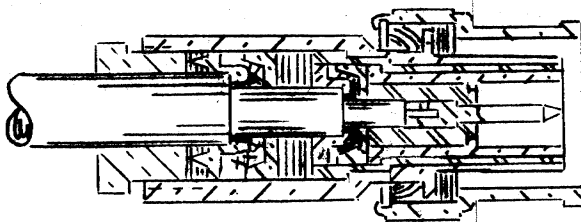


12. Trim inner conductor to dim. shown.

Note: For assemblies 00-8354-4, 00-8354-5, 00-8470-2 and 00-8470-3 only, trim inner conductor to $\frac{5}{64}$ with insulating washer assembled.



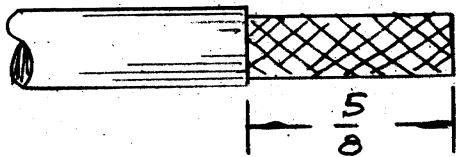
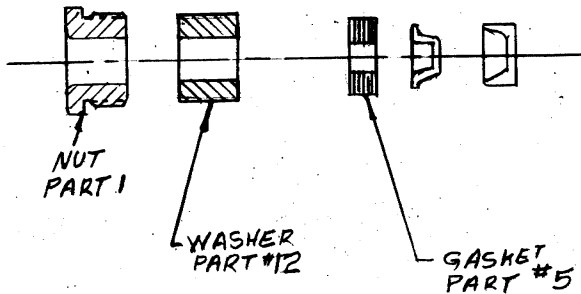
13. Solder contact on inner conductor. Remove excess solder. Do not overheat dielectric as it will distort and will not enter insulator properly.



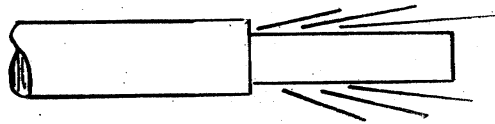
14. Insert completed cable hardware assy. into either Jack or Plug body.. Make sure part (2) is properly seated on sharp edge of part (3). After nut is started, tighten with torque wrench to 13 to 15 in. lbs.

NOTE: Sharp edge of clamp part (3) must split gasket part (2).

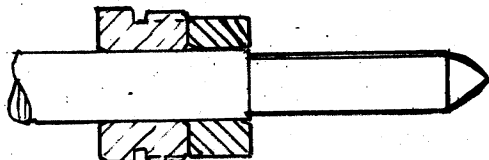
ALTERNATE ASSY. INSTRUCTIONS
 GASKET (PART #2), CLAMP (PART #3) & BUSHING (PART #4)
 IS REPLACED BY WASHER (PART #12).



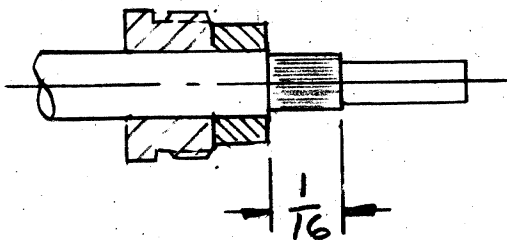
1A. CUT OFF END OF CABLE SQUARE AND REMOVE JACKET TO DIM'S SHOWN. DO NOT NICK BRAID.



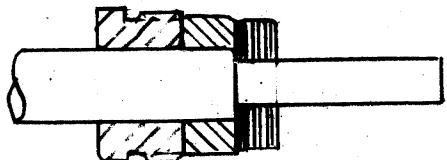
2A. COMB OUT BRAID



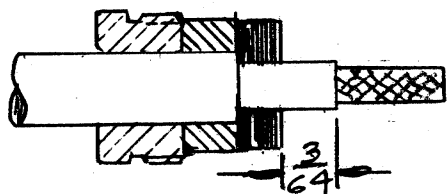
3A. TAPER BRAID, SLIDE WASHER OVER BRAID AND JACKET.



4A. TRIM BRAID TO DIM SHOWN.



5A. FLARE BACK BRAID TO FACE OF WASHER. AND PLACE GASKET IN POSITION SHOWN.



6A. REMOVE INNER JACKET TO DIM. SHOWN.

CONTINUE AS PER
 INST. #7 OF SHT. #2