

NOTES:

1. PERFORM CONTINUITY AND SHORT TESTS.
2. SEE PROCESS DETAIL FOR ASSEMBLY INSTRUCTIONS AND STRIP LENGTHS.

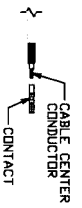
3. LABEL WITH PART NUMBER AND CURRENT REVISION (155145-0001.)

4. ASSEMBLY INSTRUCTIONS FOR RINC PLUG (7758302-210).

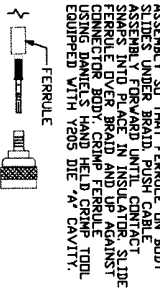
(A) CUT CABLE (422274-0175) AS SHOWN.



(B) SLIP W/S TUBING AND FERRULE DNTD CABLE. PLACE CONTACT ON CABLE CENTER CONDUCTOR SO THAT IT BUTTS AGAINST CABLE DIELECTRIC. CRIMP CONTACT IN PLACE USING DANIELS HAND EQUIPPED WITH Y205 DIE. SLIDE INSULATOR OVER CENTER CONDUCTOR. DIE P CAVITY FLARE SLIGHTLY END OF CABLE BRAID TO FACILITATE INSERTION OF INNER FERRULE.



(C) INSTALL CABLE ASSEMBLY INTO BODY ASSEMBLY SO THAT FERRULE ON BODY SLIDES UNDER BRAID. PUSH CABLE ASSEMBLY FORWARD UNTIL CONTACTS MEET. CRIMP CONTACT IN PLACE USING DANIELS HAND EQUIPPED WITH Y205 DIE. SLIDE FERRULE OVER BRAID AND UP AGAINST USING DANIELS HAND HELD CRIMP TOOL. EQUIPPED WITH Y205 DIE. P CAVITY.



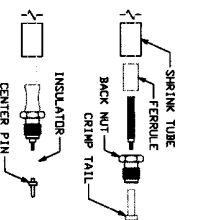
5. ASSEMBLY INSTRUCTIONS FOR TYPE 'N' BLKHEAD (758438-210).

(HACHON TNC CONNECTOR)

(A) CUT CABLE (422274-0175) AS SHOWN.



(B) SLIP CENTER CONTACT OVER BRAIDED CENTER CONDUCTOR AND SOLDER IN PLACE.

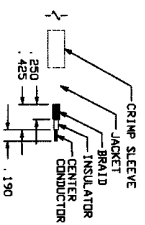


(C) PUSH CRIMP SLEEVE INTO CONNECTOR. CRIMP SLEEVE INTO CONNECTOR BETWEEN BRAID AND FOIL COVERED DIELECTRIC. PUSH CRIMP SLEEVE OVER EXPOSED SIMONS CRIMP TOOL.



(JOHNSON TNC CONNECTOR)

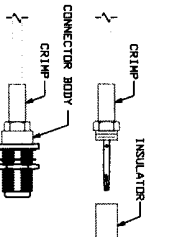
(A) CUT CABLE (422274-0175) AS SHOWN.



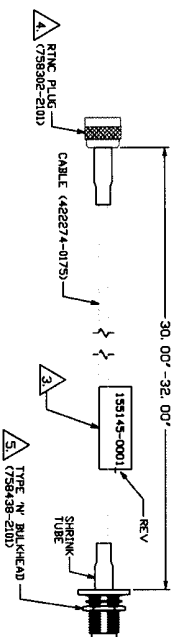
(B) FLARE BRAID AND SLIDE CABLE INTO CRIMP SLEEVE OF REAR BODY SUBASSEMBLY. CRIMP SLEEVE INTO CABLE DIELECTRIC BOTTOMS OUT ON CENTER CONTACT. SOLDER CENTER CONDUCTOR TO CONTACT THROUGH INSULATOR. INSULATOR SHOULD NOT BE ALLOWED TO GATHER AND RUN OUTSIDE OF CONTACT.



(C) CRIMP SLEEVE SLIDE CRIMP SLEEVE INTO CRIMP SLEEVE OF REAR BODY SUBASSEMBLY. CRIMP SLEEVE INTO CABLE DIELECTRIC BOTTOMS OUT ON CENTER CONTACT. SOLDER CENTER CONDUCTOR TO CONTACT THROUGH INSULATOR. INSULATOR SHOULD NOT BE ALLOWED TO GATHER AND RUN OUTSIDE OF CONTACT.



TURBO REAR BODY SUBASSEMBLY INTO BODY AND TIGHTEN SECURELY (30 INCH POUNDS).



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11		155145-0001		1	1

LXE

CABLE ASSEMBLY
RINC TO TYPE 'N'

155145

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