

JJ-198

SPECIFICATIONS

SERIES ~ QDS
 NO. OF CONTACTS ~ ONE(1)
 TYPE OF CONTACT ~ FEMALE
 DIELECTRIC ~ TEFLON
ELECTRICAL DATA
 MAX. PEAK OPER. VOLT. ~
 NOMINAL IMPEDANCE ~ 70Ω

ACCOMODATIONS

TYPE ~ STYROFLEX
 MAX. Q.D. ~ 1 5/8
MATERIAL
 EXTERNAL PARTS ~ BRASS
 CONTACT ~ BERYLLIUM COPPER
 CLAMP ~ STAINLESS STEEL

FINISH

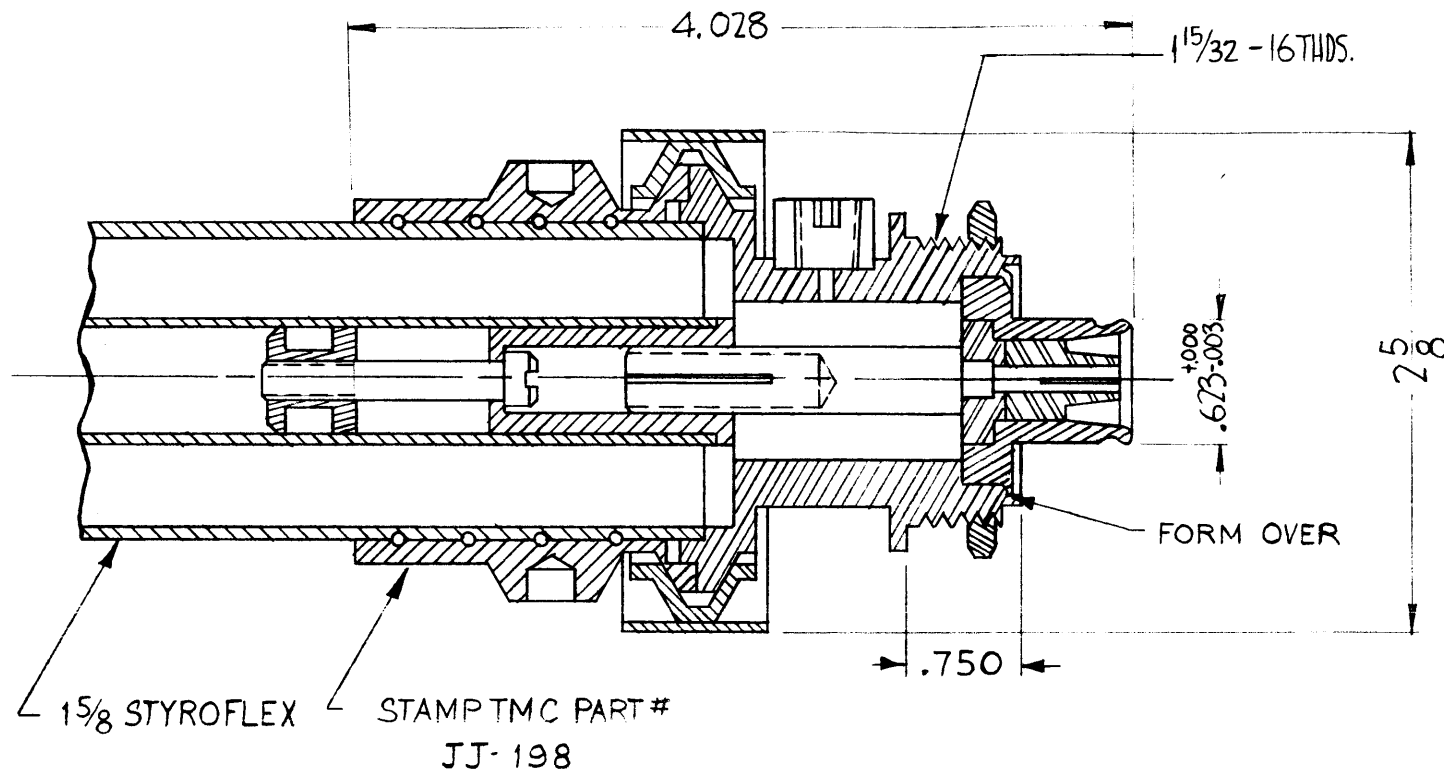
EXTERNAL PARTS ~ SILVER PLATE + RHODIUM FLASH.
 CONTACT ~ SILVER PLATE + GOLD FLASH.

INSTALLATION INSTRUCTIONS

1-5/8" Styroflex to QDS (F) Connector

Refer to Accompanying Assembly Drawing

- Using a sharp tubing cutter, score cable 3" from end. Do not cut through aluminum jacket.
- Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
- Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
- Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
- Saw off center conductor .125 from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor, being careful to keep chips out of cable.
- Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
- Separate sleeve from connector at clamp.
- Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket.
- Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable extends beyond sleeve 1/32".
- Grease sleeve "O" ring with "O" ring grease, Dow Corning No.4 Compound, and install in sleeve.
- Reassemble connector with sleeve by mating center conductor and tightening clamp.



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THE TECHNICAL MATERIEL CORPORATION
 MAMARONECK, NEW YORK

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	SPECIFICATIONS Added	5/8/61	-#	D.P.P.	H.Q.	[Signature]

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

SCALE: S401-70 (9496)

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
	TCA-ST71625/QDS			1-31-61

USED ON

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		CONNECTOR, RECEPTACLE	
		1 5/8, 70Ω STYROFLEX TO QDS.	
		[Signatures]	
		TYPE & TEMPER HEAT TREAT. SPEC. DRAWN CHECKER	FINAL APPROVAL
			JJ-198
		FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP.	A