

JJ-204

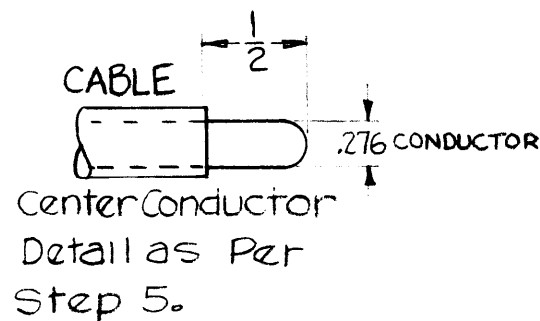
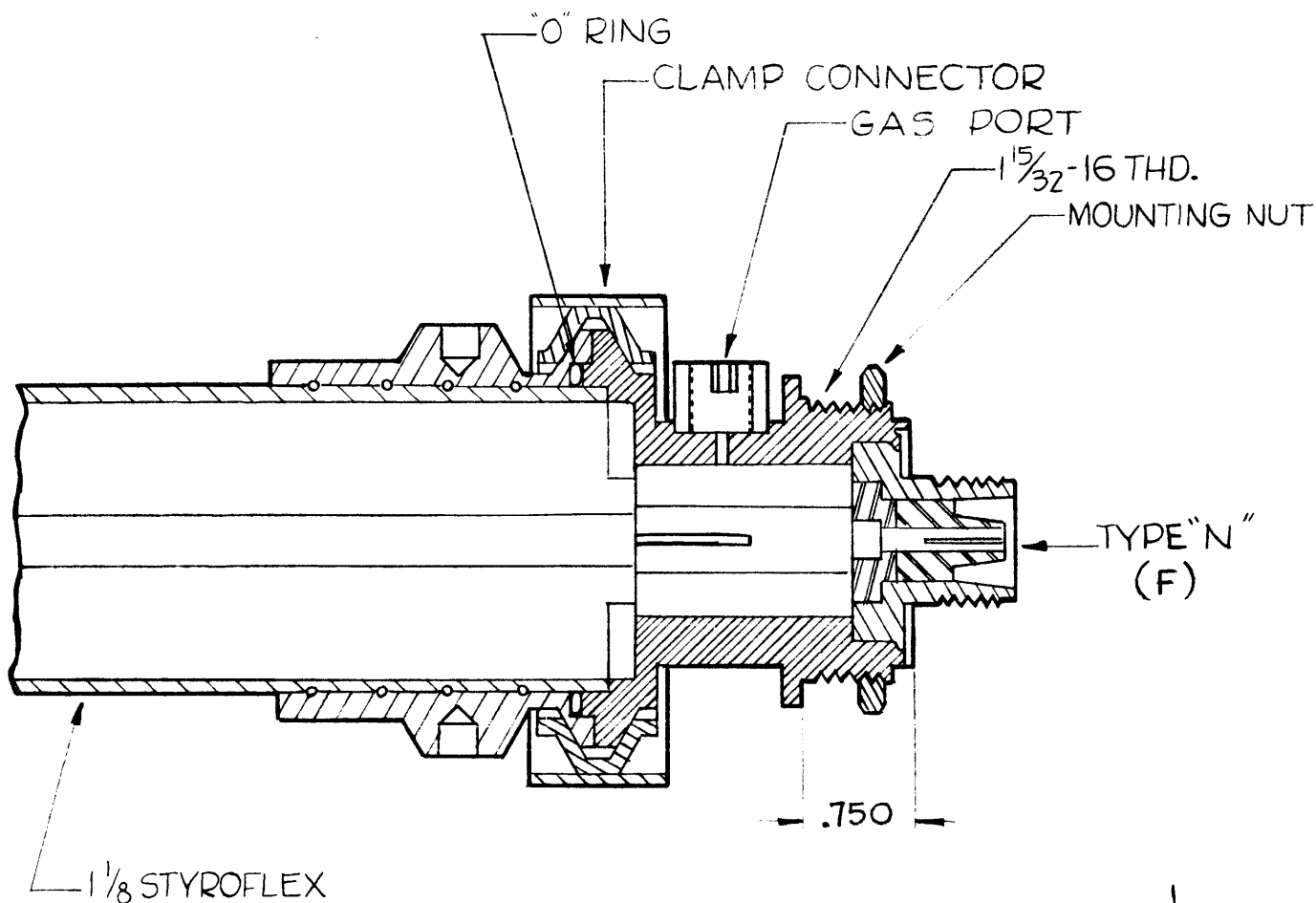
SPECIFICATIONS

BODY-BRASS - SILVER PLATE; RHODIUM FLASH.
 CONTACT-BERYLLIUM-SILVER PLATE; GOLD FLASH.
 DIELECTRIC - TEFLON
 CLAMP-STAINLESS STEEL
 MTG. PROVISION - 1/2 HOLE

INSTALLATION INSTRUCTIONS STANDARD DRAWING
 1-1/8 Styroflex to N 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.
- Cut off all but 1/2" of center conductor. Round off end; being careful to keep chips out of cable.
- Separate sleeve from connector at clamp.
- Coat inside of sleeve with GL-117 anti-sieze compound. Use compound sparingly and wipe off any excess before starting sleeve on cable.
- 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, GL-118 (No. 4 compound), and install in sleeve.
- Reassemble connector with sleeve by mating center conductor and tightening clamp.



THE TECHNICAL MATERIAL CORPORATION

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THE TECHNICAL MATERIAL CORPORATION
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ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: S-401-70-(2200)				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
	TCA-ST71125/N			3-29-61
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		CONNECTOR, ADAPTER	
		70 ohm 1/8" STYROFLEX TO N	
		DRAWN	CHECKED
		DATE	INITIALS
		FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.
			JJ-204