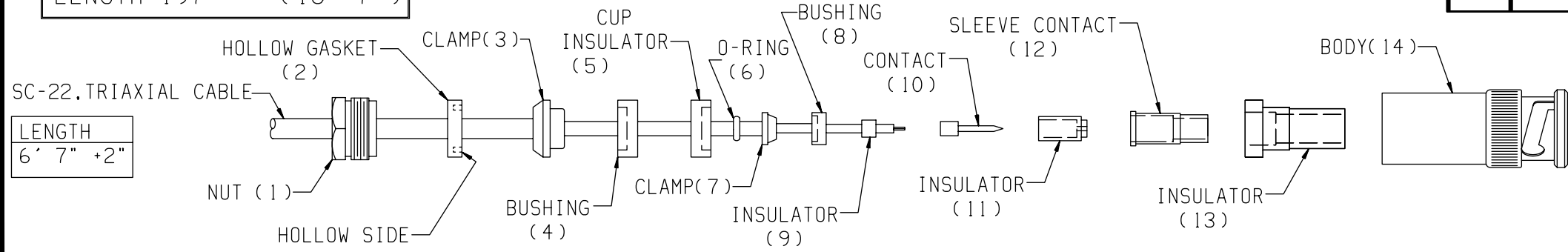


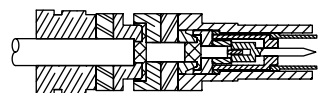
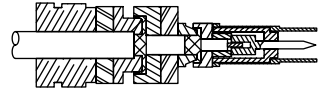
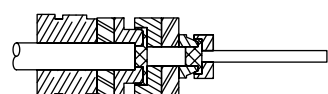
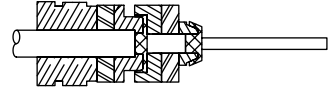
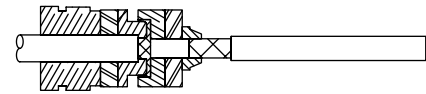
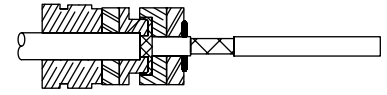
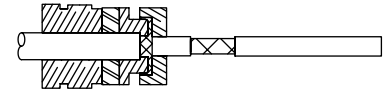
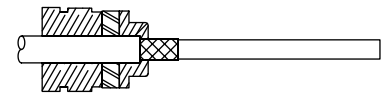
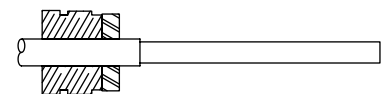
E  
FOR MODEL 237-ALG-5  
LENGTH 197" -- (16' 7")

CABLE PREP FOR SPECIALTY TRIAX CONNECTOR - CS-631

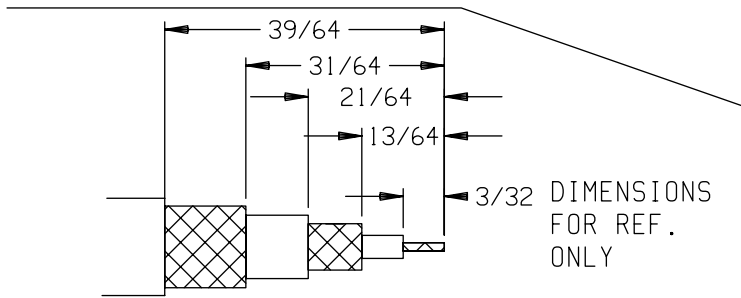
LTR	ECA NO.	REVISION	Approval	DATE
E	46752	See ECA For Change Information	Matt B	5/5/2010



- CUT OFF END OF CABLE SQUARE.
- STRIP CABLE ON AUTOMATIC STRIPPING MACHINE.
- USING BARE FINGERS (IN STEPS 1-9). SLIDE NUT(1), AND HOLLOW GASKET (2) ONTO OUTER JACKET.
- REMOVE PARTIAL JACKET STRIP FROM OUTER BRAID. SLIDE CLAMP(3) ON CABLE UNTIL IT STOPS AGAINST OUTER JACKET INSULATION.
- FLAIR BACK OUTER BRAID OVER CLAMP.
- REMOVE PARTIAL INSULATION STRIP FROM INNER COPPER BRAID.
- CLEAN CABLE END BELOW LARGE CLAMP USING A BRUSH AND APPROVED SOLVENT FOLLOWED BY A RINSE OF CLEAN SOLVENT. BRUSH TOWARD CABLE END ONLY TO AVOID DISTURBING BRAID.
- ALLOW SOLVENT TO EVAPORATE FOR ABOUT A MINUTE.
- IN THE FOLLOWING STEPS USE ONLY CLEAN PLIERS TO HANDLE AND ASSEMBLE PARTS. SLIDE BUSHING(4) ON. HOLDING THE CABLE. PRESS FIRMLY INTO PLACE.
- PLACE O-RING (6) INTO CUP INSULATOR (5) SLIDE ON CABLE.



- SLIDE CLAMP (7) ON UNTIL IT STOPS.
- FLAIR INNER BRAID AND FOLD BACK OVER CLAMP.
- PLACE SMALL BUSHING(8) ON CABLE. PRESS FIRMLY INTO PLACE.
- SLIDE INSULATOR (9) OVER CENTER CONDUCTOR INSULATION REMOVE PARTIAL STRIP FROM CENTER CONDUCTOR. SOLDER CONTACT (10) TO CONDUCTOR WITH RMA SOLDER. CLEAN WITH APPROVED SOLVENT.
- SLIDE INSULATOR (11) OVER THE CONTACT (10).
- INSTALL SLEEVE CONTACT(12) AND INSULATOR(13) AS SHOWN. INSERT ASS'Y INTO BODY(14). TIGHTEN NUT(1) TO BODY(14) APPLYING TORQUE OF 30 IN LBS ±2 IN LBS.
- ALLOW ASSEMBLED CONNECTORS TO DRY IN AGING CHAMBER FOR A MINIMUM OF 12 HOURS.
- RE-TORQUE NUT TO 30 IN LBS.



Part Images May Differ From Actual Part Appearance

<p>DO NOT SCALE THIS DRAWING</p> <p><b>KEITHLEY</b> Keithley Instruments Inc. Cleveland, Ohio 44139</p> <p>CONFIDENTIAL PROPRIETARY</p>	<p>DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED</p> <p>XX - ±.015 ANG - ±1°</p>	<p>DATE 12/6/93</p> <p>DRN <i>Mat</i></p>	<p>SCALE <math>\times</math></p> <p>Approval SCM</p>	<p>TITLE</p> <p>TRIAx CONNECTOR ASS'Y</p>
	<p>XXX - ±.005 FRAC - ±1/64</p>	<p>MATERIAL</p>	<p><math>\times</math></p>	<p>NO. 237-ALG-070</p>
	<p>SURFACE MAX <math>\checkmark</math></p>	<p>FINISH</p>	<p><math>\times</math></p>	

237-ALG
MODEL