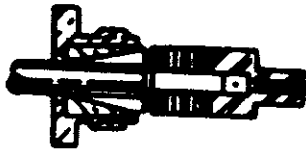
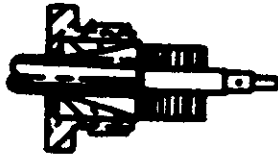
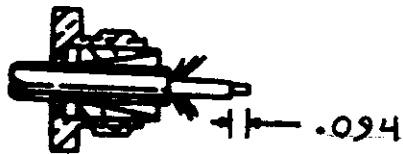
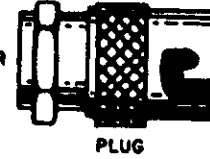
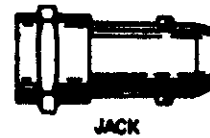
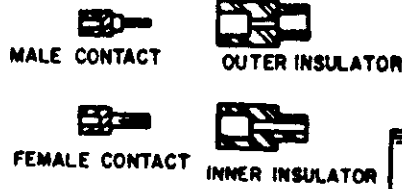
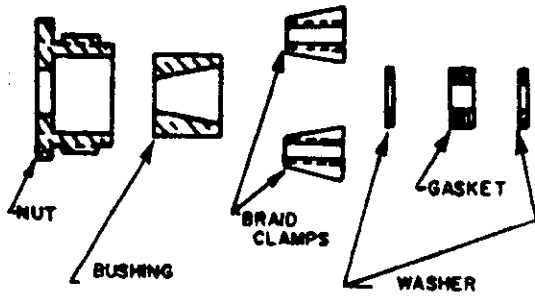


DM SERIES
CABLE ASSEMBLY INSTRUCTIONS

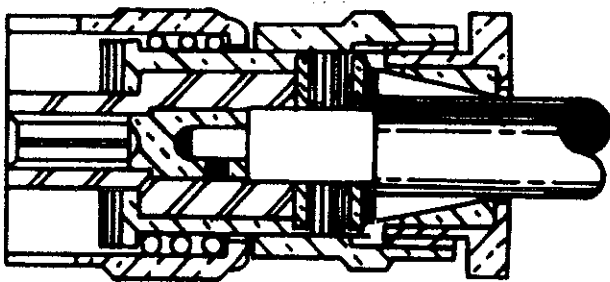


1. CUT CABLE OFF SQUARE ON END. DO NOT DEFORM. SLIDE CABLE NUT AND BUSHING OVER CABLE AND PUSH BACK OUT OF WAY. CUT JACKET TO DIMENSION SHOWN BEING CAREFUL NOT TO NICK BRAID.
2. COMB OUT BRAID AND TRIM INNER DIELECTRIC TO DIMENSION SHOWN, BEING CAREFUL NOT TO NICK INNER CONDUCTOR.
3. WITH BRAID CLAMPS FLUSH WITH END OF JACKET SLIDE BUSHING OVER TAPERED END OF CLAMPS. THIS PROCEDURE CLAMPS CABLE AND BRAID CLAMPS SECURELY. FOLD BACK BRAID, PLACE WASHER, GASKET AND WASHER IN PLACE. TRIM EXCESS BRAID FLUSH WITH WASHER. SOLDER CONTACT ON CENTER CONDUCTOR FLUSH WITH INNER DIELECTRIC. REMOVE EXCESS SOLDER.
4. PLACE INSULATOR IN POSITION.
5. INSERT CABLE ASSEMBLY INTO CONNECTOR EITHER JACK OR PLUG, PUSH FIRMLY IN PLACE AND TIGHTEN NUT UNTIL IT IS FLUSH WITH CONNECTOR.

NOTE IMPORTANT:

TURN NUT ONLY WHEN TIGHTENING. DO NOT ROTATE BODY OR CABLE.

6. AFTER ASSEMBLY PLACE FRONT GASKET IN PLUG TYPE AS SHOWN.



AMPHENOL CORPORATION

DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES;
AND TOLERANCES ARE:

FRACTIONS	DECIMALS	ANGLES
± 1/64	± .005	± 1°

CODE IDENT.

74868

SCALE: NONE

ISSUE

349-50329

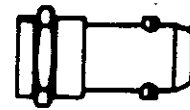
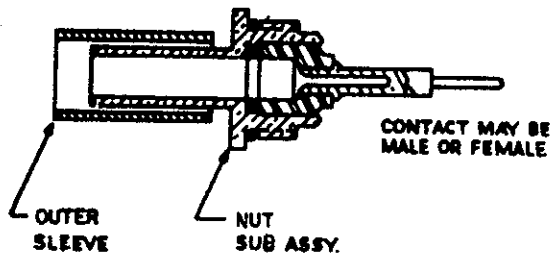
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ISSUE

B

SHEET 2 CONT. ON 3

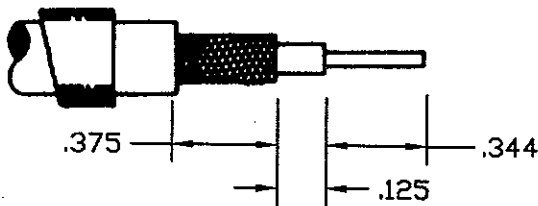
DM EXTERNAL CRIMP-ON SERIES CABLE ASSEMBLY INSTRUCTIONS



JACK



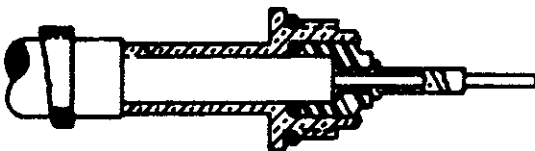
PLUG



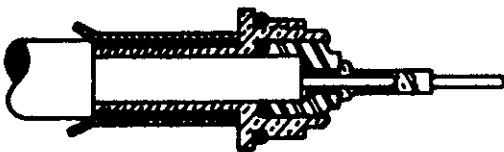
1. CUT CABLE OFF SQUARE ON END. SLIDE OUTER SLEEVE OVER CABLE AND SLIDE BACK OUT OF WAY. TRIM CABLE TO DIMENSION SHOWN BEING CAREFUL NOT TO NICK CENTER CONDUCTOR OR BRAID. TIN DIP CENTER CONDUCTOR. REMOVE ALL EXCESS SOLDER.



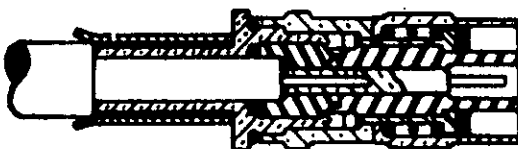
2. ROTATE DIELECTRIC TO SLIGHTLY FLARE BRAID.



3. PUSH CABLE INTO NUT SUB-ASSEMBLY UNTIL THE CENTER CONDUCTOR IS VISIBLE THRU HOLE IN CONTACT. SOFT SOLDER CENTER CONDUCTOR THRU HOLE IN CONTACT. REMOVE EXCESS SOLDER. FOLD BRAID DOWN OVER BACK END TUBE OF NUT. TRIM EXCESS BRAID IF NECESSARY.



4. SLIDE OUTER SLEEVE OVER BRAID UNTIL IT IS FLUSH AGAINST BACK OF NUT. CRIMP AS CLOSE TO NUT AS POSSIBLE USING PROPER CRIMPING TOOL.



5. INSERT FINISHED CABLE ASS'Y. INTO BODY EITHER JACK OR PLUG AND TIGHTEN BY ROTATING BODY. DO NOT ROTATE NUT SUB-ASSEMBLY.

AMPHENOL CORPORATION

DANBURY, CONN.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES;
AND TOLERANCES ARE:

FRACTIONS DECIMALS ANGLES

± 1/64 ± .005 ± 1°

CODE IDENT.

74868

SCALE: NONE

349-50329

F:\DEPT611\SPCS\349\50329SH2

ISSUE

B

SHEET 3 CONT. ON F