

Instruction Sheet

Termination Procedure

2-Wire or 6-Wire Vented Cable, Universal Connector

Materials

Supplied in kit:

- Compression nut
- Coupling ring
- Plug shell
- Plug insert
- O-rings (3)
- Pins (7)
- Jumper wire (2 pieces)
- Cable tie
- Dust cap with chain

You will also need:

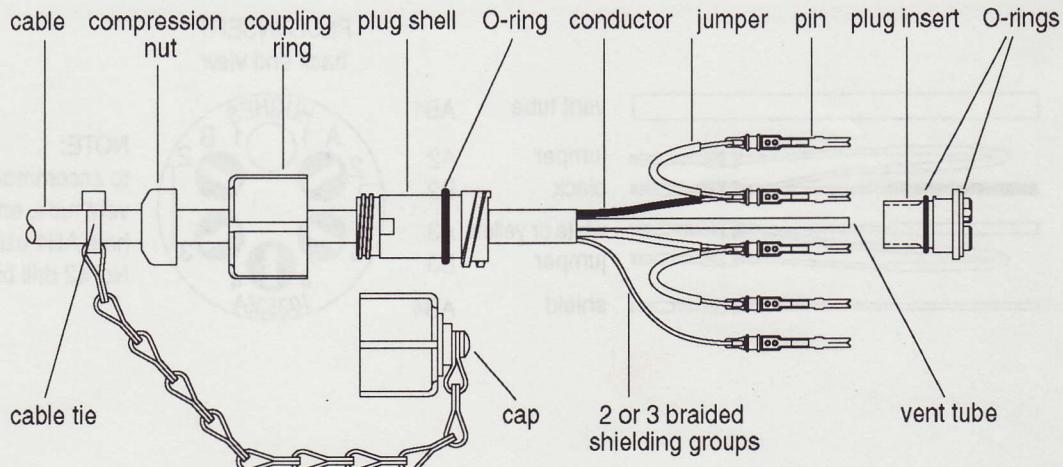
- Wire stripper
- Wire cutter
- 60/40 RA or RMA core solder (or equivalent)
- Dow Corning 3140 or 3145 RTV adhesive/sealant (or equivalent)
- Drill with No. 42 bit
- Superglue
- Swabs

Procedure

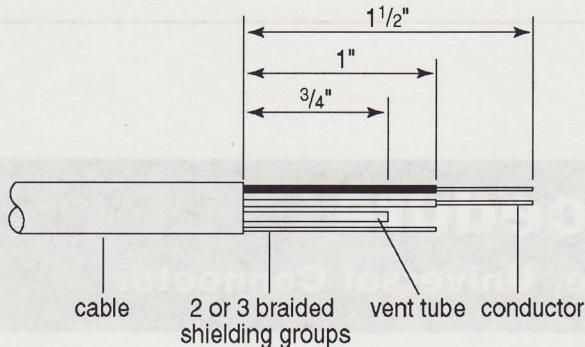
Refer to the illustration below for position and identification of parts.

1. Install large o-ring on plug shell.
2. Slide compression nut, coupling ring, and plug shell onto cable.
3. Terminate cable as follows:
 - a. Strip outer cable jacket approximately 2" from end. Be careful not to cut the braided shielding. Separate the braided shielding, vent tube, Kevlar strands, and the black and white or black and yellow conductors. Trim other cable components flush with jacket.
 - b. Separate 2 or 3 groups of braided shielding, and twist together. Remove and discard remaining shielding.

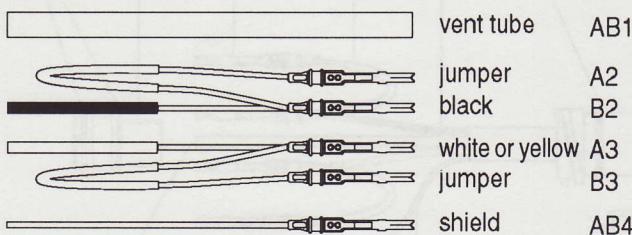
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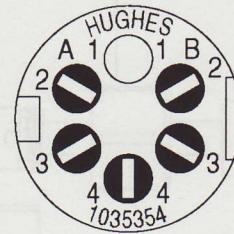
- c. Cut cable components to lengths shown:



- c. Cut cable components to lengths shown:
- d. Tin conductor ends and braided shielding with 60/40 RA or RMA core solder or equivalent. Leave approximately 1" of Kevlar free for encapsulation (step 12).
 - 2-wire cable: Tin black and white conductors
 - 6-wire cable: Tin black and yellow conductors
- e. Solder a pin and jumper to each conductor and a pin to the other end of each jumper.
- f. Solder a pin to the tinned shielding.
4. Enlarge hole AB1 on plug insert using No. 42 drill bit.
5. Install small o-ring on plug insert (refer to the illustration on the opposite side of the sheet).
6. Using superglue, install flat o-ring in groove at front end of plug insert.
7. Radially insert pins into back end of plug insert. See the illustration below for proper pin position. Gently pull each pin and wire backward to insure pin is seated.
8. Put a dot of superglue on the side of the vent tube 1/8" from the end. Insert vent tube into plug insert. Do not allow it to protrude from the other side.
9. Align keyways on insert with keys inside plug shell.
10. Install wired insert into plug shell. Push firmly on insert, making sure latch on shell is firmly seated against the shoulder of the insert.
11. Align keyways of coupling ring on plug shell keys. Slide coupling ring forward.
12. Fill back side of plug shell with Dow Corning No. 3140 or 3145 RTV adhesive/sealant or equivalent.
13. Thread compression nut onto back of connector assembly. Tighten compression nut completely by hand.
14. Let set *at room temperature* until cured. Insure the vent tube remains in hole AB1 while curing.
15. Attach dust cap with plastic tie 1" from connector, as shown in the illustration on the opposite side.



PLUG INSERT
back end view



NOTE:
to accommodate
vent tube, enlarge
hole AB1 using
No. 42 drill bit