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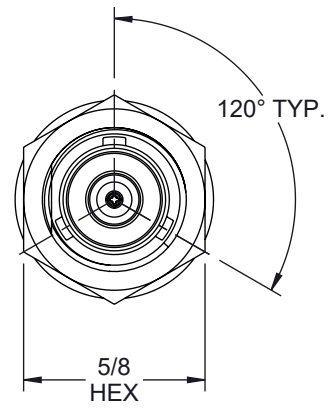
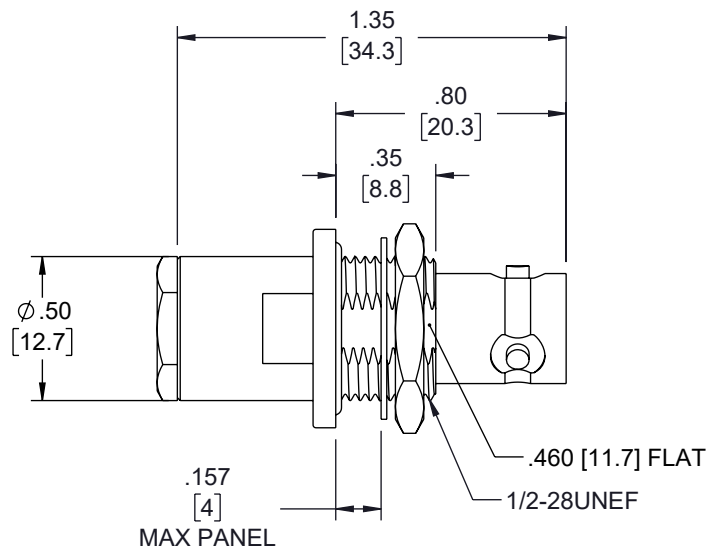
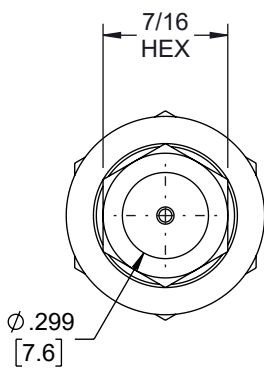
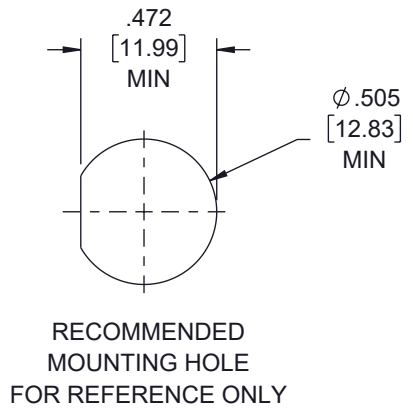
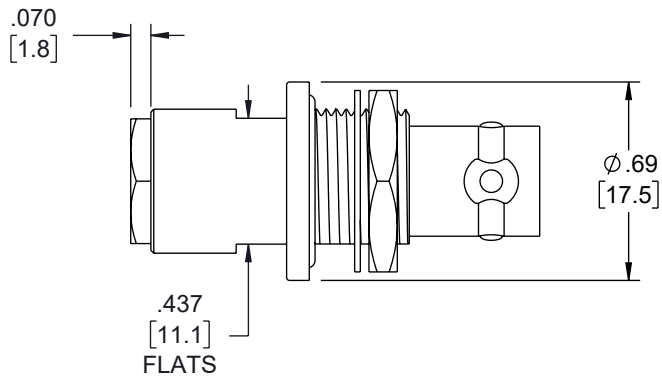
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REVISION					
ZONE	REV	DESCRIPTION	DATE	CHANGED BY	APPROVED
	B	ECO-13202	04/30/2024	KGLEBOVA	KHIETPAS



UNLESS OTHERWISE SPECIFIED LEADING DIMENSIONS ARE INCHES DIMENSIONS IN [] ARE MILLIMETERS

TOLERANCES:

X = ±.2 [5]	FRACTIONS ± 1/32
XX = ±.02 [0.5]	± 1/32
.XXX = ±.005 [0.13]	ANGLES ± 1°

CABLE LENGTH TOLERANCES:

≤12 [305]	= +1 [25] / -0
>12 [305] ≤ 60 [1524]	= +2 [51] / -0
>60 [1524] ≤ 120 [3048]	= +4 [102] / -0
>120 [3048] ≤ 300 [7620]	= +6 [152] / -0
>300 [7620]	= +5% / -0

ALL DIMENSIONS ARE FOR REFERENCE ONLY AND SUBJECT TO CHANGE WITHOUT NOTICE UN-DIMENSIONED/NON-CRITICAL FEATURES MAY VARY IN SIZE AND LOCATION COLORS MAY VARY



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 Phone: 1.800.715.4396 | 1.972.649.6678

SCALE	SHEET
NONE	1 OF 2

DESCRIPTION
78 OHM TRB 3-LUG JACK NI BULKHEAD MOUNT 1553 CONNECTOR CLAMP/SOLDER ATTACHMENT FOR FMBC-30-02001, TWC-78-2

SIZE	CAGE CODE	DRAWN BY	ITEM NO.	REV
A	3FKR5	SREITER	FMCN10-06577-210	B

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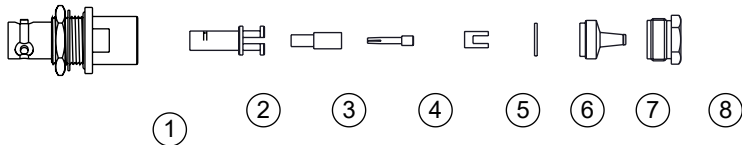
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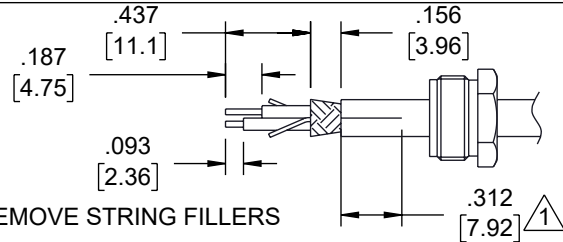
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ASSEMBLY INSTRUCTIONS



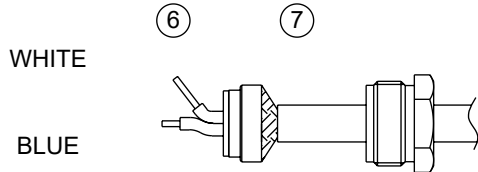
- ① BODY ASSEMBLY
- ② INNER SHIELD
- ③ DIELECTRIC
- ④ CONTACT
- ⑤ NOTCHED INSERT
- ⑥ INSULATING WASHER
- ⑦ CONE
- ⑧ CLAMP NUT

STEP 1



- PLACE ⑧ ONTO CABLE.
- STRIP CABLE AS SHOWN AND FLARE BRAID TO ALLOW FREE ENTER OF ⑦. (▲ LATERAL SLITS 180° APART MAY BE REQUIRED FOR INFLEXIBLE JACKET MATERIALS).
- LIGHTLY TIN CENTER CONDUCTOR.

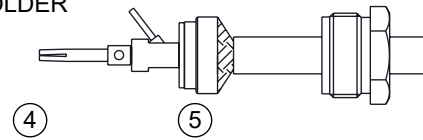
STEP 2



- PUSH ⑦ UNDER BRAID UNTIL BRAID IS FLUSH WITH EDGE OF ⑦.
- INSTALL ⑥ OVER CONDUCTORS AND SEAT AGAINST ⑦.
- BEND LONGER BARED CONDUCTOR AT RIGHT ANGLE AND POSITION OTHER CONDUCTOR TO CENTER OF CABLE.

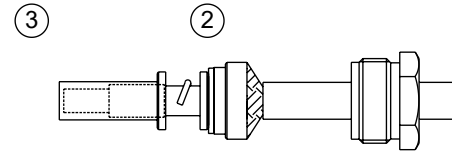
STEP 3

SOLDER



- PLACE ⑤ OVER CONDUCTORS WITH CENTER CONDUCTOR THRU CENTER HOLE AND OTHER CONDUCTOR THRU SIDE SLOT UNTIL SEATED AGAINST ⑥ OR ⑦.
- INSTALL ④ OVER CENTER CONDUCTOR. SEAT AGAINST ⑤ AND SOLDER IN PLACE.

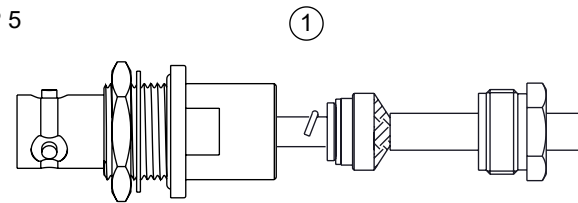
STEP 4



SOLDER

- PLACE ③ OVER ④ UNTIL BOTTOMED.
- INSTALL ② OVER ③ & ⑤ WITH CONDUCTOR THRU SIDE SLOT UNTIL BOTTOMED.
- WRAP CONDUCTOR BETWEEN ② RIDGES AND SOLDER. BEING CAREFUL NOT TO ALLOW SOLDER OR CONDUCTOR TO EXTEND ABOVE ② RIDGES.

STEP 5



- BRING ⑧ UP ONTO TAPERED PORTION OF CABLE.
- ASSEMBLE ① OVER ENTIRE ASSY AND ENGAGE WITH ⑧.
- WRENCH TIGHTEN TO 25-35 IN LBS TORQUE.

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INTERPRET ALL DIMENSIONS AND TOLERANCES PER ASME Y14.5
SCALE NONE SHEET 2 OF 2

DESCRIPTION
78 OHM TRB 3-LUG JACK NI BULKHEAD MOUNT 1553
CONNECTOR CLAMP/SOLDER ATTACHMENT FOR FMBC-30-02001, TWC-78-2

SIZE A	CAGE CODE 3FKR5	DRAWN BY SREITER	ITEM NO. FMCN10-06577-210	REV B
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