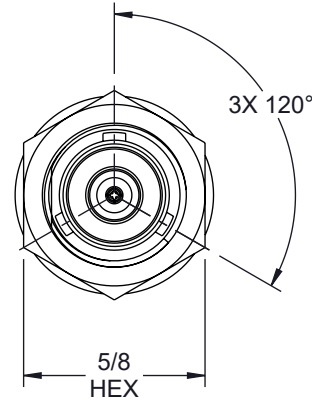
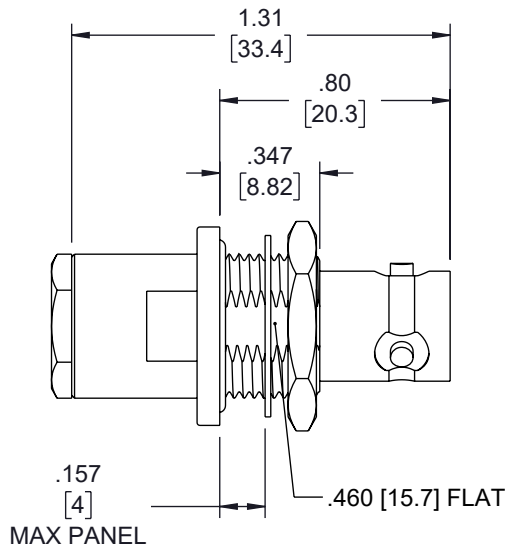
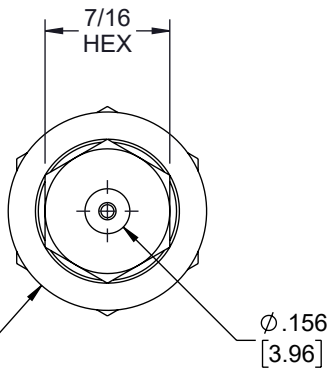
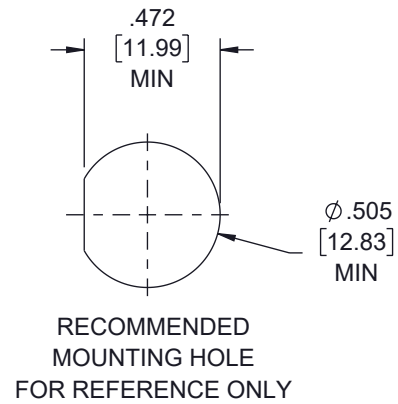
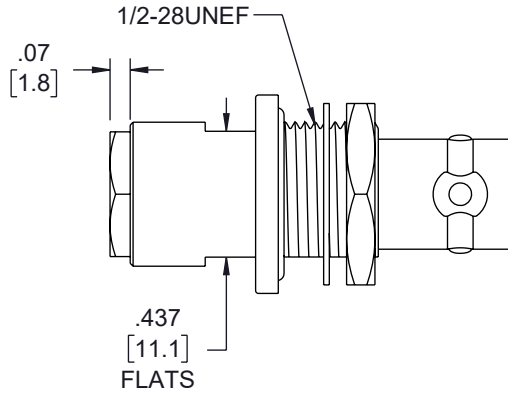


6 5 4 3 2 1

REVISION					
ZONE	REV	DESCRIPTION	DATE	CHANGED BY	APPROVED
	B	ECO-13202	03/21/2024	KGLEBOVA	SRAUTUS



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

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

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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INTERPRET ALL DIMENSIONS AND TOLERANCES PER ASME Y14.5

SCALE	SHEET
NONE	1 OF 2

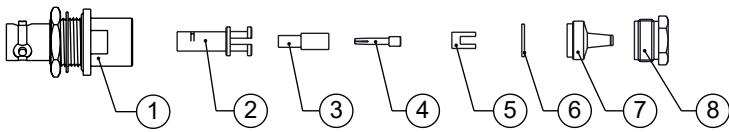
DESCRIPTION
78 OHM TRB 3-LUG JACK NI BULKHEAD MOUNT 1553 CONNECTOR CLAMP/SOLDER ATTACHMENT FOR FMBC-30-02002, TWAC-78-1F2

SIZE	CAGE CODE	DRAWN BY	ITEM NO.	REV
A	3FKR5	SREITER	FMCN10-06577-242	B

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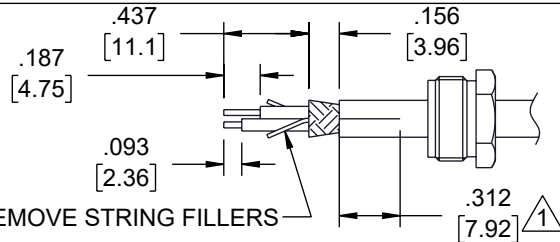
6 5 4 3 2 1

ASSEMBLY INSTRUCTIONS



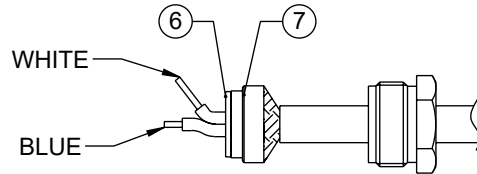
- ① BODY ASSEMBLY
- ② INNER SHIELD
- ③ DIELECTRIC
- ④ CONTACT
- ⑤ NOTCHED INSERT
- ⑥ INSULATING WASHER
- ⑦ CONE
- ⑧ CLAMP NUT

STEP 1



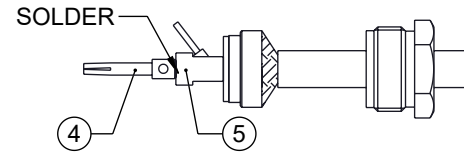
- PLACE ⑧ ONTO CABLE.
- STRIP CABLE AS SHOWN AND FLARE BRAID TO ALLOW FREE ENTER OF ⑦. (▲ LATERAL SLITS 180° APART MAY BE REQUIRED FOR INFLEXIBLE JACKET MATERIALS).
- LIGHTLY TIN CENTER CONDUCTOR.

STEP 2



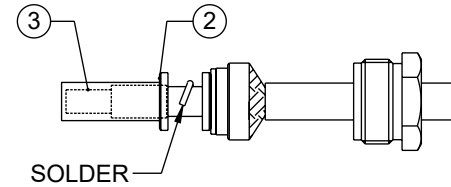
- PUSH ⑦ UNDER BRAID UNTIL BRAID IS FLUSH WITH EDGE OF ⑦.
- INSTALL ⑥ OVER CONDUCTORS AND SEAT AGAINST ⑦.
- BEND LONGER BARED CONDUCTOR AT RIGHT ANGLE AND POSITION OTHER CONDUCTOR TO CENTER OF CABLE.

STEP 3



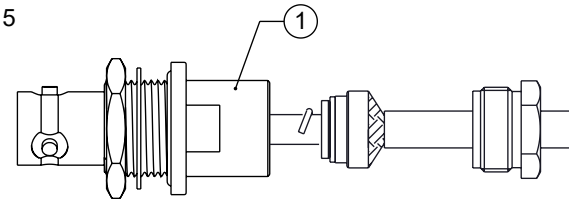
- PLACE ⑤ OVER CONDUCTORS WITH CENTER CONDUCTOR THRU CENTER HOLE AND OTHER CONDUCTOR THRU SIDE SLOT UNTIL SEATED AGAINST ⑥ OR ⑦.
- INSTALL ④ OVER CENTER CONDUCTOR. SEAT AGAINST ⑤ AND SOLDER IN PLACE.

STEP 4



- 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-30-02002, TWAC-78-1F2

SIZE A	CAGE CODE 3FKR5	DRAWN BY SREITER	ITEM NO. FMCN10-06577-242	REV B
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